

MP 711.35.50
ORIGINAL ISSUANCE: MAY 1990
1ST REVISION: APRIL 1983
2ND REVISION: APRIL 1986
3RD REVISION: FEBRUARY 1994
REISSUED: JANUARY 1995
PAGE 1 OF 4

WEST VIRGINIA DEPARTMENT OF TRANSPORTATION
DIVISION OF HIGHWAYS
MATERIALS CONTROL, SOILS AND TESTING DIVISION

MATERIALS PROCEDURE

CERTIFICATION OF SUPPLIERS OF EPOXY COATED STEEL

- 1.0 PURPOSE
 - 1.1 To establish a procedure for certification of suppliers of epoxy coated steel. To set forth conditions for certification, and to establish inspection and shipping procedures.
- 2.0 SCOPE
 - 2.1 This procedure shall apply to suppliers of epoxy coated steel who furnish material to projects and purchase orders. The Division may elect to use other control procedures when special conditions dictate.
- 3.0 APPLICABLE DOCUMENTS
 - 3.1 West Virginia Division of Highways Specifications, Road and Bridges, Section 709.1
 - 3.2 AASHTO M 284
- 4.0 DEFINITIONS
 - 4.1 Supplier - a supplier may be a coater, coater-fabricator, or a fabricator of epoxy steel.
 - 4.2 Coater - a company which applies the epoxy coating to the steel.
 - 4.3 Coater-Fabricator - a company which applies the epoxy coating to the steel and which then fabricates the coated steel.
 - 4.4 Fabricator - a company which does not coat steel but which cuts to length and bends previously coated steel.

5.0 PROCEDURES

5.1 Prerequisites for certification as follows:

5.1.1 A Quality Control Program to ensure that the materials complies with the specification.

5.1.2 Test equipment and personnel necessary to test the materials for compliance with the specification.

5.1.3 An acceptable record of compliance with the specification.

5.2 Application for Certification - suppliers of epoxy coated steel wishing to be certified to supply material to project and purchase orders should submit the items listed below to the Division of Highways.

5.2.1 A certified statement that all material shipped to the Division will conform to the specification. The certified statement shall be signed by a representative of the supplier who has authority to bind the company.

5.2.2 An outline of the suppliers sampling, testing, and Quality Control Procedures.

5.2.3 An outline of the procedures followed to ensure proper identification of steel as it flows through the cleaning, coating, testing, storage, and shipping process.

6.0 SAMPLING AND TESTING REQUIREMENTS - The testing program is divided into three (3) phases, each of which is explained below.

6.1 Phase I

6.1.1 The supplier will sample and test material to be shipped to the Division at a minimum frequency as indicated in his Quality Control Plan (Section 5.2.2). The supplier shall test these samples for compliance with all requirements of the governing specifications.

- 6.2 Phase II
 - 6.2.1 The Division or its representative will make random inspections at the supplying plant to ensure specification compliance.
- 6.3 Phase III
 - 6.3.1 The Division will obtain and test field samples at a minimum rate of one sample per year per active coater. The samples will be tested for compliance with all requirements of the governing specifications.
- 7.0 STEEL SPECIFICATION
 - 7.1 Reinforcing steel shall meet the requirements of Section 709.1 of West Virginia Division of Highways Standard Specifications for Roads and Bridges.
 - 7.2 Non-reinforcing steel shall meet the applicable requirements of the West Virginia Division of Highways.
 - 7.3 The steel shall be approved by the Division prior to coating.
- 8.0 EPOXY POWDER
 - 8.1 The epoxy powder shall meet the requirements of Section 711.35 of the West Virginia Division of Highways Standard Specifications for Roads and Bridges.
 - 8.2 The epoxy powder shall be approved by the Division prior to use.
- 9.0 PATCHING MATERIAL
 - 9.1 The patching material shall meet the requirements of Section 711.35 of the West Virginia Division of Highways Standard Specifications for Roads and Bridges.
 - 9.2 The patching material shall be approved by the Division prior to use and shall be furnished with each shipment.

10.0 FABRICATION

10.1 The epoxy coated steel, after fabrication, shall meet the requirements of Section 711.35 of the West Virginia Division of Highways Standard Specifications for Roads and Bridges.

10.2 The documentation of repairs due to fabrication shall be noted on Attachment 1.

11.0 DOCUMENTATION

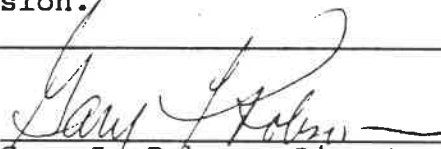
11.1 With each shipment, the supplier shall provide shipping documents which contain his certification number.

11.2 The supplier will provide a completed Attachment 1 which shall accompany the shipment to the project. The supplier shall also provide a copy of the completed Attachment 1 to Materials Control, Soils and Testing Division.

11.3 Upon receipt of epoxy coated steel from a certified source, coverage will be obtained by entering the approval number for that specific source and material. The project shall record the following:

1. Description
2. Quantity

Note: This Materials Procedure specifically applies to epoxy coated steel. The fusion bonded coating industry is developing newer powders and uses for the powders in the highway industry. The general outline of this procedure will be followed for any fusion bonded coated product supplied the Division.


Gary L. Robson, Director
Materials Control, Soils
and Testing Division

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ATTACHMENT 1
PAGE 1 OF 1

EPOXY COATED REINFORCING STEEL

PROJECT _____

SOURCE OF STEEL _____ LOCATION _____

WV LAB #: _____

COATER: _____ LOCATION: _____

COATER WV LAB #: _____

DATES COATED: ____/____/____ ____/____/____ ____/____/____

SOURCE OF EPOXY POWDER: _____ TYPE: _____

WV LAB #: _____

REBARS SHIPPED TO: PROJECT: _____ FABRICATOR _____

SHIPPED BY: _____ DATE SHIPPED: ____/____/____

FABRICATION DOCUMENTATION

FABRICATOR: _____ LOCATION _____

FABRICATOR WV LAB #: _____

TOUCH-UP AFTER FABRICATION: _____

SIGNED: _____ DATE: _____

