8-75.1 Plant Certification Program for Fabrication of Prestressed Concrete Members

8-75.1.1 Introduction

Prestressed concrete members must be fabricated at plants certified by the department in order to be used on department projects. The purpose of this document is to outline the processes to obtain and maintain plant certification with the department. Generally, the fabricator must provide a quality control (QC) program for plant manufacturing. QC is all operations that control the product manufacturing process within the specification requirements. The fabricator is responsible for all QC functions for materials and fabrication identified in the specification and this plant certification procedure. Quality verification (QV) oversight (verification of the QC processes) is provided by the department or its agent.

Acceptance of prestressed concrete member items is contingent on the items being manufactured at plants complying with both this plant certification program and standard spec 503.

To provide prestressed concrete members to WisDOT projects, plants must:

- Be certified by the Precast/Prestressed Concrete Institute's (PCI) certification program for the type(s) of prestressed members to be produced.
- Have a PCI certified Level II inspector responsible for QC sampling, testing, and inspection.
- Be approved by the department as a certified prestressed concrete member fabrication plant before start of production for WisDOT projects.
- Be in compliance with the additional requirements of this procedure (refer to SCOPE and Appendix A).

Plants, at a minimum, must undergo an annual operation review and approval process. Certification is granted/renewed or denied subsequent to the review.

WisDOT projects include state, county, and municipal federal aid and authorized county and municipal state aid projects. Fabricators whose plants are not on the approved list to provide prestressed concrete members to WisDOT projects are given one year to establish certification according to this program. This period starts with their first notification to the department of their intent to provide products for WisDOT projects.

8-75.1.2 Scope

Throughout this document there are two distinctive inspection issues of plant certification addressed:

1. Materials incorporated into the products
2. Fabrication of the products

8-75.1.2.1 Fabrication Items

The items included under this plant certification program are as described in standard spec 503:

- Prestressed concrete girders
- Other prestressed concrete members

The item requirements must be according to the plans and specifications and contract. Prestressing of concrete members must be by the pretensioning method consisting of the following steps:

- Initial stressing of reinforcing tendons
- Placement of reinforcing steel, hardware and forms
- Production, placement, and curing of concrete
- Releasing stress from anchorages to the concrete after development of specified concrete strength
- Repairs, storage, and shipment

8-75.1.2.2 Department Plant Certification

The department's plant certification requirements are as follows (refer to Appendix A of this program for expanded information):

1. Prequalification by PCI plant certification as a fabricator in good standing.
2. A PCI certified Level II inspector responsible for QC.
3. A current quality control plan, based on PCI guidelines, and approved by the department.
4. WisDOT's annual plant review by the department's certification review team (refer to the "Authority for Plant Certification" section of this procedure) and approval process including QC/QV inspection requirements of this procedure and maintaining records identified in Appendix B and Appendix C.

8-75.1.3 General
Fabrication plants must provide facilities and qualified personnel to perform the specified tests (refer to Appendix B, "Schedule of Tests") and maintain an acceptable quality control program. The plant must have a PCI Level II certified QC inspector either on the plant staff or from a consultant employed by the plant owner. This inspector must report to personnel other than those responsible for production. The Level II QC Inspector must be on duty at all times when the plant is in production of products for WisDOT projects. When differences exist between the PCI plant certification program aspects and standard spec 503, standard spec 503 prevails.

All materials intended for use in the fabrication of prestressed concrete members must be tested according to the "Schedule of Tests" contained in Appendix B of this procedure. The fabricator must maintain records of all product ingredient test reports, certifications, and quality control testing done in the production of prestressed concrete members. These records must be available at all times for examination by the department QV inspector and must be retained for a minimum period of five years after the item has been accepted by the department.

Continued certification of a fabrication plant is contingent upon satisfactory completion of an initial plant operation review by the department and, then, sustained by a minimum of one annual review thereafter.

The fabricator must be required to perform quality control inspections. The department intends only to perform quality verification inspections. By its QV inspection, the department intends only to facilitate the work and review the quality of work. This QV inspection does not relieve the fabricator of any responsibility for identifying and replacing defective material and workmanship.

The department QV inspector must be PCI Level II certified. The QV inspector(s) must observe the fabrication process and materials, review required testing and other records on file, and make a visual inspection of the quality of workmanship of completed products for conformance with specifications and freedom from defects. Before the start of production of girders or other prestressed concrete members for WisDOT projects, the fabricator must notify the department QV inspector of the plant production schedule. The fabricator must give the QV inspector safe and free access to the work. If the QV inspector observes any work not meeting specifications or unacceptable quality control practices, the QV inspector must advise the plant manager. If the corrective action is not acceptable to the QV inspector, the girder(s) or other member(s) are rejected by the department.

8-75.1.4 Plant Certification Qualification
Plants requesting approval to fabricate prestressed concrete members for use on WisDOT projects must provide the following prequalification documentation and information with their application:

1. PCI plant certification as a fabricator in good standing. A copy of the plant’s PCI certification must be submitted to the department when application for certification is made. The plant’s two most recent audit reports by PCI must be available at all times for review by the department and the department’s certification review team. The reports must be reviewed only in the presence of plant personnel. The contents of the audit reports must remain confidential between the plant and the department and no parts of the report must be reproduced or removed from the plant premises.

2. A current quality-control plan based on PCI guidelines, including fabricator documentation of all girders and other prestressed concrete member items.

3. Apply in writing to the director of the WisDOT Bureau of Technical Services (Attention: quality management engineer). The request for plant certified status must include information on the plant QC program (i.e. product control operations, testing capabilities, facilities information, programs/tracking mechanisms such as inspection, and testing and personnel to maintain quality including identification of the PCI Level II certified inspector and a copy of the certification, records keeping information, etc.). The QC program must ensure that all fabrication, materials, and processes, consistently comply with applicable specification requirements (refer to Appendix B, Schedule of Tests).[1]

   [1] Example QC plans are furnished by the department upon request.

4. Undergo an on-site plant review by the department's certification review team who observe fabricating processes, review records on file, and make visual inspections of the quality of workmanship of completed products for conformance with specifications and freedom from defects. The certification review team must have safe and free access to the plant at any time.

The certification review team insures that the fabricator has facilities and equipment necessary to perform all
operations to produce acceptable quality prestressed concrete products complying with all applicable specification requirements. The fabricator must be capable of consistently supplying acceptable products in quantity sufficient to avoid delays during construction. Any proposed modifications in plant methods, QC program, certified QC inspection personnel, or changes in sources of materials must be reported promptly to the region designated contact person where the plant is located. Department records of plant reviews previously made are used to evaluate those fabricators currently supplying products to WisDOT. Plant reviews are made a minimum of once per year.

Fabricators are notified of their certification status subsequent to the plant review process. The department maintains a list of certified plants on its electronic materials test system (MTS).

8-75.1.5 Maintenance of Plant Certified Status
Fabricators must request plant re-approval annually. The request must be in writing and include any changes that have occurred in the fabricator's plant methods, QC program, and certified QC inspection personnel since the last approval. The request must be received by the Bureau of Technical Services within one year of the previous approval; otherwise the approval status is terminated. Upon receipt of the request for re-approval, the department initiates a plant inspection review by the certification review team, at a time when the plant is in production of products for WisDOT projects, according to this program.

Plants on the department's approved list are subject to reviews (complete or partial) at any time by the department's certification review team and QV inspector(s). Plant reviews follow the guidelines of this program.

8-75.1.6 Loss of Plant Certified Status
Plant certification may be withdrawn for the following conditions:
- Loss of PCI plant certification.
- Inability to consistently fabricate products meeting specification requirements.
- Lack of maintenance of required records and improper documentation.
- Failure to maintain an approved quality control program.
- Failure to satisfactorily resolve deficiencies identified by certification reviews.

The Director of the Bureau of Technical Services authorizes removal of plants from the certified list. The department provides notification of removal from the list in writing.

8-75.1.7 Plant Recertification Qualification
A plant that has lost certification must comply with the following to be recertified:
- Items 1 through 4 of "Plant Certification Qualification" section of this procedure.
- Submit documentation to the director of the Bureau of Technical Services identifying the reason(s) decertification occurred and the corrective actions taken by the fabricator.

During the time a plant is not on the approved list, due to loss of certification, prestressed concrete members fabricated at the plant are only accepted when the plant is under an increased level of QV inspection as determined by the department. The department's increased costs for QV inspection are paid by the fabrication plant or their agent, unless other arrangements are agreed upon by the department.

Under this program, a fabrication plant has 3 months to regain certified status. If, after three months, the plant has not met all requirements for recertification, prestressed concrete members that are fabricated in the plant are not accepted for use on WisDOT projects until the plant is recertified to furnish these products under this procedure (the department's plant certification program). Notification of this department action is sent to all WisDOT regions by the Bureau of Technical Services. Decisions regarding future qualification for certification of a plant are by the Director of the Bureau of Technical Services.

8-75.1.8 Authority for Plant Certification
The director of the Bureau of Technical Services determines the plants to be certified based on recommendations of the department's certification review team. Notification of plant certification is made in writing to the fabricator.

The certification review team consists of representatives from WisDOT Central Office, WisDOT regions, and any others included by the department. FHWA may assist with the review upon request by the department.

8-75.1.9 Department Verification and Plant Certification Stamp
Each prestressed concrete member fabricated under this plant certification program requires, for acceptance of items upon delivery to projects, a shipping document stamped with the following plant certification and a satisfactory visual inspection by the engineer at the job site.
CERTIFIED TO MEET WISDOT SPECIFICATIONS

(Name of Manufacturing Company)

The stamp serves as the fabricator’s certification that the item has been fabricated in compliance with all specifications and the fabricator has all the pertinent documentation available for examination by the appropriate department personnel.

Furthermore, acceptance is contingent upon receipt and evaluation, by the department, of the cylinder test results as provided by the fabricator.

8-75.1.10 Certification of Plants Not on the Approved List

Prestressed concrete members fabricated in plants not on the WisDOT approved list may be accepted when the plant is under increased QV inspection by the department for an interim period not to exceed one year. After that time, the plant must have attained certification under the department’s plant certification program or products are not accepted for use on WisDOT projects. The department’s increased costs for QV inspection is paid for by the fabrication plant or their agent, unless other arrangements are agreed upon by the department.

8-75.1.11 Department Contact Person

Inquiries and comments regarding this plant certification procedure may be addressed to:

Quality Assurance Supervisor
Wisconsin Department of Transportation
Truax Center
3502 Kinsman Boulevard
Madison, Wisconsin 3704
Tel.: (608) 246-7939

Replace 8-75.2 - 8-75.7 to add methods for obtaining approved fabricator status for primary steel, signs and bridge components.

8-75.2 Approved Fabricators for Primary Steel Bridge Members

8-75.2.1 General

Steel bridge members must be fabricated at shops that are on the department’s approved fabricator list for primary members in order to be used on department projects. The purpose of this section is to outline the requirements for obtaining and maintaining fabricator shop approval status with the department. Acceptance of steel bridge primary members is contingent on the items being fabricated at shops complying with both these shop approval requirements and standard spec 506.

Fabrication must comply with the American Welding Society (AWS) D1.5 Bridge Welding Code. To fabricate steel bridge members for WisDOT projects, a fabricator must be certified by the American Institute of Steel Construction (AISC) as detailed in CMM 8-75.2.2.

The fabricator must provide facilities and qualified personnel to maintain an acceptable quality control program. The fabricator must provide a current copy of their Quality Management/Control Plan directly to the Structural Metals and Fabrication Quality Assurance Inspection Unit Supervisor. The fabricator must upload mill test reports and certifications, shop drawings, and weld procedure specifications to the SharePoint Fabrication Library before starting the assembly process. The records must be available at all times for examination by the department inspector and for a period of 5 years after use on a project.

Acceptance of steel bridge members by the department is also contingent upon continued satisfactory verification inspection at the project site by project personnel.

8-75.2.2 Qualification for Approved Fabricator List

To be included in the department’s list of Approved Steel Bridge Fabricators, the fabricator must provide proof of AISC certification and an updated Quality Control/Management Plan (QMP/QCP) directly to the Structural Metals and Fabrication Quality Assurance Inspection Unit Supervisor on a yearly basis. These submittals must be received by March 1 of each calendar year to maintain an approved fabricator status in the department’s APL. Fabricators requesting product approval under the Certification Program must provide an application form to: DOTDLStructuresFabrication@dot.wi.gov

The application form is available at: https://wisconsindot.gov/dtsdManuals/strct/fabrication/apl-bridge.docx

The required level of AISC certification is based on the complexity of the structure as detailed in Table 1. Fabrication of structures with higher complexities than those allowed by the highest level of certification held by a fabrication shop is not allowed to occur at that facility.
### Table 1  AISC Certification Level Requirements for Steel Bridges

<table>
<thead>
<tr>
<th>Bridge Category - Certification Level</th>
<th>Allowable Fabrication</th>
</tr>
</thead>
<tbody>
<tr>
<td>Certified Bridge Fabricator - Simple (SBR)</td>
<td>- Unspliced rolled sections</td>
</tr>
<tr>
<td>Certified Bridge Fabricator - Intermediate (IBR) Major</td>
<td>- Field or shop spliced rolled beam bridge, straight or with radius &gt; 500ft - Built-up I-girder with constant web depth, straight or with radius &gt; 500ft, spliced or unspliced - Built-up I-girder with variable web depth, straight or with radius &gt; 1000ft - Truss with length &lt; 200ft, almost entirely preassembled at the certified facility and shipped in no more than three subassemblies</td>
</tr>
<tr>
<td>Certified Bridge Fabricator - Advanced (ABR) Major</td>
<td>- Tub or trapezoidal box girders - Closed box girders - Truss with length &gt; 200ft - Arches - Bascule bridges - Cable-supported bridges - Moveable bridges - Bridges with radius &lt; 500ft</td>
</tr>
<tr>
<td>Fracture Critical Endorsement (FCE)</td>
<td>- Bridges with fracture critical members</td>
</tr>
</tbody>
</table>

### 8-75.2.3 Loss of Approved Fabricator Status

Approval to fabricate steel bridge members may be withdrawn for the following conditions:

- Failing to submit certifications an updated to the shop’s QMP/QCP by the yearly deadline.
- Inability of a fabricator to consistently supply products meeting specification requirements.
- Lack of maintenance and submittal of required records, including: certified mill test reports, shop drawings for each structure, updates to the QMP/QCP, WPSs, welder certifications, welder continuity records, and weekly fabrication status reports.
- Failure to communicate and report any of the following: fabrication errors, accidents resulting in structural damage to steel members, intent to deviate from the contract plans, or substitute materials.
- Failure to request/obtain engineer approval for repairs when approval by the engineer is required by AWS/AASHTO codes.
- Improper documentation of shipments.
- Not maintaining an acceptable quality control program.

### 8-75.3 Approved Fabricators for Steel Sign Bridges and Overhead Sign Supports

#### 8-75.3.1 General

Sign bridges and overhead sign supports must be fabricated at shops that are on the department’s approved fabricator list for sign bridges and overhead sign supports in order to be used on department projects. The purpose of this section is to outline the requirements for obtaining and maintaining fabricator shop approval status with the department. Acceptance of sign bridges and overhead sign supports is contingent on the items being fabricated at shops complying with both these shop approval requirements and standard spec 641.2.

Fabrication must comply with the American Welding Society (AWS) D1 welding codes. Products may be inspected at the fabrication facility by a WisDOT representative. To fabricate steel sign bridges and overhead sign supports for WisDOT projects, a fabricator must be certified by AISC as detailed in CMM 8-75.3.2.

The fabricator must provide facilities and qualified personnel to maintain an acceptable quality control program. The fabricator must provide a current copy of their Quality Management/Control Plan directly to the Structural Metals and Fabrication Quality Assurance Inspection Unit Supervisor. The fabricator must upload mill test reports and certifications, shop drawings, and weld procedure specifications to the WisDOT Fabrication Library before starting the assembly process. The records must be available at all times for examination by the quality
assurance inspector and for a period of 5 years after use on a project.

Acceptance of steel sign structures by the department is also contingent upon continued satisfactory verification inspection at the project site by project personnel.

8-75.3.2 Qualification for Approved Fabricator List
To be included in the department’s list of Approved Sign Structure Fabricators, the fabricator must provide proof of AISC certification and an updated Quality Control/Management Plan (QMP/QCP) directly to the Structural Metals and Fabrication Quality Assurance Inspection Unit Supervisor on a yearly basis. These submittals must be received by March 1 of each calendar year to maintain an approved fabricator status in the department’s APL. Fabricators requesting product approval under the Certification Program must provide an application form to: DOTDLStructuresFabrication@dot.wi.gov

The application form is available at: https://wisconsindot.gov/dtsdManuals/strct/fabrication/apl-sign.docx

The required level of AISC certification is based on the complexity of the structure as detailed in Table 2. Fabrication of structures with higher complexities than those allowed by the highest level of certification held by a fabrication shop is not allowed to occur at that facility.

<table>
<thead>
<tr>
<th>Bridge Category - Certification Level</th>
<th>Allowable Fabrication</th>
</tr>
</thead>
<tbody>
<tr>
<td>Certified Component Manufacturer (CPT)</td>
<td>- Monotube sign structures</td>
</tr>
<tr>
<td>Simple Bridge (SB)</td>
<td>- Truss sign structures, Monotube sign structures</td>
</tr>
</tbody>
</table>

Monotube sign structures: Full-span monotube, cantilever monotube, 2-chord with no web elements, and tapered monotonubes

Truss sign structures: 4-chord full-span, 4-chord cantilever, 2-chord full-span with web elements, 2-chord cantilever with web elements, and sign supports for DMS/VMS signs

8-75.3.3 Loss of Approved Fabricator Status
Approval to fabricate sign structures may be withdrawn for the following conditions:
- Inability of a fabricator to consistently supply products meeting specification requirements. This is defined as three rejections of components, by department inspection, or field engineer, in a three-month period.
- Lack of maintenance and submittal of required records, including: certified mill test reports, shop drawings for each structure, updates to the QMP/QCP, WPSs, welder certifications, welder continuity records, and weekly fabrication status reports.
- Failure to communicate and report any of the following: fabrication errors, accidents resulting in structural damage to steel members, intent to deviate from the contract plans, or substitute materials.
- Failure to request/obtain engineer approval for repairs when approval by the engineer is required by AWS/AASHTO codes.
- Failure to follow contract plans, special provisions, and specifications.
- Improper documentation of shipments.
- Not maintaining an acceptable quality control program.

8-75.4 Approved Fabricators for Fabricated Bridge Components
8-75.4.1 General
To provide Fabricated Bridge Components for WisDOT projects, a fabricator must be on the department’s APL, at the time of letting, by complying with the procedures and requirements detailed in this section.

Fabrication must comply with the American Welding Society (AWS) D1 Welding Codes. Fabrication shops are subject to periodic inspections by the department and all products must be inspected at the job site by the engineer before use.

The fabricator must provide facilities and qualified personnel to maintain an acceptable quality control program. The fabricator must upload certified mill test reports to the WisDOT Fabrication Library before starting the assembly process. The fabricator must maintain records of certified mill test reports. The records must be available at all times for examination by the engineer or department inspector and for a period of 5 years after use on a project.
Acceptance of items by this process is also contingent upon continued satisfactory verification inspection at the project site by project personnel.

8-75.4.2 Scope
Items included under Fabricated Bridge Components are the following:

<table>
<thead>
<tr>
<th>Table 3 Fabricated Bridge Components</th>
</tr>
</thead>
<tbody>
<tr>
<td>Railing Assemblies</td>
</tr>
<tr>
<td>Steel Bearing Assemblies</td>
</tr>
<tr>
<td>Expansion Devices</td>
</tr>
<tr>
<td>Structural Steel Diaphragms (for concrete girders)</td>
</tr>
</tbody>
</table>

8-75.4.3 Qualification for Approved Fabricator List
Fabricators requesting product approval under the Certification Program must provide the following to:

DOTDLStructuresFabrication@dot.wi.gov

1. Application form is available at: https://wisconsindot.gov/dtsdManuals/strct/fabrication/apl-fbc.docx

The fabricator is required to undergo an on-site plant inspection by a department representative.

Fabricators are added to the Approved Fabricator List by the Structural Metals and Fabrication Quality Assurance Inspection Unit Supervisor after review and acceptance of the required documentation.

8-75.4.4 (Vacant)

8-75.4.5 Loss of Approved Status
Decisions regarding future qualification for approval of an affected shop are made by the Structural Metals and Fabrication Quality Assurance Inspection Unit Supervisor. Approval to provide fabricated bridge components may be withdrawn for the following conditions:

- Inability of a fabricator to consistently supply products meeting specification requirements. This is defined as three rejections of components, by department inspections, or field engineer, in a three-month period.
- Lack of maintenance and submittal of required records, including: certified mill test reports, shop drawings for each structure, updates to the QMP/QCP, WPSs, welder certifications, welder continuity records, test results required by the applicable sections of the standard specifications and/or CMM.
- Failure to produce accurate material traceability documentation, including chemical and mechanical testing.
- Failure to follow contract plans, special provisions, and specifications.
- Improper documentation of shipments.
- Not maintaining an acceptable quality control program.

If any of the conditions listed above occur, the fabricator is given written notice of the department’s intent to remove the fabrication shop from the department’s APL. The fabricator has the opportunity to provide a corrective action plan to the department for review by SFU. Proposed corrective actions must take effect immediately. If additional nonconformances occur the fabricator is removed from the department’s APL.

8-75.4.6 Fabricator Qualification for Re-approval
A fabricator who has lost approved status and seeks to be re-approved, must comply with the following:

1. Fulfill all parts of CMM 8-75.4.3.
2. Submit documentation to the Structural Metals and Fabrication Quality Assurance Inspection Unit Supervisor identifying the corrective actions taken to resolve the problems.

8-75.4.7 Acceptance of Products From Shops Not on the Approved List
Fabricated bridge components from shop not on the approved list are not accepted. To be added to the approved fabricator list, follow the procedures outlined in CMM 8-75.4.3.

8-75.4.8 Fabricator Certification of Shipments and Documentation
Each shipment of fabricated bridge components must include a certification statement from a fabrication shop providing a loading document or shipping invoice, date, project information, and contractor identification that lists the products in the shipment by description and number. The certification statement must be on the fabricating...
company's letterhead, with signature and title of a person responsible for certifying the product to bind the fabricator, and be worded essentially as follows:

"The products covered by this fabrication statement were manufactured in compliance with (list applicable specifications) and comply with the "Buy America Provisions" of WisDOT contracts. Copies of certified mill test reports are on file and available for review at the plant from which the products were fabricated. Representative samples of finished products have been inspected for conformance with the requirements of (list applicable specifications)."

These documents must be submitted to the engineer at the time of delivery of products to a project. The documents must be retained with the project records.

The engineer must conduct a visual inspection at the job site when delivery of products is made. The engineer may accept secondary fabrication products at the job site for shipments that include a loading document, fabricator certification statement and a satisfactory visual inspection.

8-75.5 Pile Driving Data, Form DT1924

Provide a driving log for the first piling at each unit of structure using department form DT1924. The driving log and associated data is required for informational and comparative purposes only. Record the following information

- All applicable data including type, length, size, location of the pile tested and description of the hammer.
- The "Fall H" column the height of fall (stroke) of ram or striking parts of the hammer for each foot of penetration of the pile.
- The "Penetration Resistance" column the number of blows of the hammer for each foot of penetration of the pile and/or the set (inches per 10 blows).
- The "Bearing" column the corresponding Nominal resistance values of the pile as computed in tons for each foot of penetration of the pile.
- Any unusual conditions encountered in driving the pile should be noted on the back of the report.

The log is a valuable tool for assessing reasonableness of piling requirements shown on the plan. If the driving record for the first pile deviates significantly from that which was anticipated, the project manager should promptly discuss findings with the region PDS supervisor.

An example of a completed report is shown in Figure 1. You should be aware the form provides, on the reverse side, a record for piling depths of 160 feet. The reverse side is not shown in this manual for the sake of brevity.

Electronic copies (PDFs) of forms DT1924 and DT1315 are to be submitted, with Project Manager concurrence, for all structures to the Bureau of Structures by email at:

DOTDTSDDotstructuresPiling@dot.wi.gov

and to the Bureau of Technical Services, Geotechnical Unit at:

DOTDSDGeotechnicalPiling@dot.wi.gov

Include the structure number (B, C, S, or etc.) in the subject field of the email.
Figure 1 Pile Driving Data, Form DT1924

8-75.6 Piling Record, Form DT1315
Department form DT1315 "Piling Record" provides a summary record of all piling driven, except for test piling. Test piling data is to be reported on form DT1924.

The inspector must complete a separate form DT1315 for each unit of a structure containing piling. A sketch is to be made of the unit, with the location of each pile noted on the sketch. When a test pile is left in place to become a bearing pile, the location should be noted on the sketch with an "X" and the words "Test Pile."

The form DT1315 is an excel spreadsheet with three identical workbooks. If the number of piling within the substructure exceeds 16 piles, then the additional workbook(s) must also be completed. The cell formulas for the average nominal resistance, the total driven pay length and the average driven pay length need to be revised by the submitter to include all the appropriate column information in the additional workbooks.

The set (inches per 10 blows) and stroke (feet) at the end of driving operations should be recorded for each pile. These values are required to calculate the Nominal Resistance (Bearing Value) of the piles.

Electronic copies (PDFs) of forms DT1924 and DT1315 are to be submitted for all structures to the Bureau of
Structures by email at DOTDTSDStructuresPiling@dot.wi.gov and to the Bureau of Technical Services, Geotechnical Unit at DOTDTSGeotechnicalPiling@dot.wi.gov. Include the structure number (B, C, S, or etc.) in the subject field of the email. A copy is to be retained in the region project files.

An example of a completed report is shown in Figure 2.

Figure 2 Piling Record, Form DT1315

8-75.7 Bridge Inventory Report, DT 2006 and Bridge Inspection Report, DT 2007 and DT 2008

These forms must be completed whenever work is done on a bridge. The bridge maintenance engineer should be notified by the engineer in a timely manner so the bridge can be inspected after completion, but before the contractor has left the site and the bridge is open to traffic.

Inspection is done by the bridge maintenance engineer, with assistance provided by the engineer or designee.
A copy of department forms DT2006, DT2007 and DT2008 must be filed in the region maintenance section. A copy of Form DT2006 must be sent to Bureau of Structures for their statewide bridge inventory file. If a local road is involved, a copy of DT2006 is to be sent to the county highway commissioner also.

**List of Attachments**

- Attachment 1  Department Plant Certification Program Requirements
- Attachment 2  Schedule of Tests
- Attachment 3  Plant Inspection Fabrication Forms