

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

MATERIALS PROCEDURE

CERTIFICATION OF PRODUCERS OF STEEL BARS
FOR CONCRETE REINFORCEMENT

1.0 PURPOSE

1.1 To provide Quality Assurance Procedures to be used for producer certification of steel bars for portland cement concrete reinforcement.

2.0 SCOPE

2.1 This procedure shall apply to all certified producers who manufacture dowel bars and/or reinforcing steel bars for West Virginia Division of Highways projects or purchase orders.

3.0 APPLICABLE DOCUMENTS

3.1 WVDOH Standard Specifications for Roads and Bridges, Section 709.1.

3.2 AASHTO M-31.

3.3 AASHTO M-42

4.0 PROCEDURES

4.1 Each producer applying for certification shall submit their Quality Control Plan to the Materials Control, Soils and Testing Division for approval. This Quality Control Plan must include the procedures used for producing, storing, and shipping steel bars for portland cement concrete reinforcement.


4.1.1 The Quality Control Plan shall include a description of all testing performed from the initial melt through testing after final rolling.

- 4.1.2 The method(s) used for tracking the heat number through all steps, including shipping, must be included.
- 4.1.3 The name of the employee responsible for Quality Control shall be included in the plan.
- 4.2 After approval of the producer's Quality Control Plan, Materials Control, Soils and Testing Division personnel or their representative will inspect the producer's testing and production facilities.
 - 4.2.1 The producer's testing equipment will be inspected to determine compliance with the requirements of AASHTO M-31 and AASHTO M-42.
 - 4.2.1.1 Producer's location will be certified only for the AASHTO specification material they produce.
 - 4.2.2 Production facilities, including storage and shipping, will be inspected to determine if the Quality Control Plan is adhered to.
 - 4.2.3 Materials Control, Soils and Testing Division personnel or their representatives will witness those chemical and physical tests as they are routinely performed by the producer to determine compliance with Division of Highways specifications.
 - 4.2.4 At the time of the precertification visit and at random times after certification, but at least once per year, Materials Control, Soils and Testing Division personnel or their representative may select random samples to be tested at the Central Laboratory.
- 4.3 Prior to certification, the producer must submit a signed statement attesting that all materials supplied for Division of Highways projects or purchase orders will meet the applicable AASHTO Specifications. This will be continued on an annual basis.
- 5.0 CERTIFICATION
 - 5.1 When the producer is considered acceptable for certification, a WVDOH Laboratory Number will be assigned. This number will identify the producer as being certified.

- 5.1.1 The laboratory number shall be entered by the producer on all shipping documents for suppliers, Division of Highways projects and purchase order contracts.
- 5.1.2 Producers not following their approved Quality Control Plan may have their laboratory number cancelled.
- 5.1.3 Approval may be reinstated at the discretion of the Division of Highways when correction of all deficiencies can be documented and the producer has reestablished his Quality Control to the satisfaction of the Division.
- 5.1.4 The producer and the Division of Highways District Materials offices will be notified of all changes in the status of a producer's certification.
- 6.0 ACCEPTANCE AND DOCUMENTATION
- 6.1 All shipping documents shall contain the producer's laboratory number.
- 6.1.1 Shipments of reinforcing steel or dowel bars which do not include the producer's laboratory number will be refused until the shipping documents are corrected.
- 6.2 In addition to the producer's laboratory number, the shipping document shall contain the producer's name and address, the grade, size, length, weight, heat number, and certified test results for the bars shipped.
- 7.0 PROCEDURE AT WVDOH DELIVERY SITE
- 7.1 West Virginia Division of Highways personnel will review the shipping documentation and verify correctness. If the documents are not correct, the shipment shall be rejected until proper documentation is received.
- 7.2 The material shall be visually inspected for damage. Material which has been damaged or does not meet Division of Highways Specifications will be rejected.

8.0 WVDOH DOCUMENTATION

- 8.1 When the items in the shipment have been verified as per 7.1 and 7.2, a copy of the bill of material or shipping documentation indicating acceptance by project personnel or storekeeper will be forwarded to Materials Control, Soils and Testing Division through the District Materials Section. The certified producer's laboratory number will be entered on the project or the storekeepers records as materials acceptance.



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