

HEAT STRAIGHTENING PLAN

To be completed by the Heat Straightening Contractor
and submitted to the Engineer for approval.

Naming Convention: 0388 MDOT ID-JN YYYY-MM-DD Heat Straightening Plan.pdf

GENERAL INFORMATION		
PROJECT DESCRIPTION	MDOT ID	PREQUALIFICATION TYPE
CONTRACTOR	JOB NUMBER	Structural Fabrication Unit Approval Block
HEAT STRAIGHTENING CONTRACTOR		
PREPARED BY	DATE	

KEY STAFF MEMBERS	
NAME	Please list all key staff members who will be working on the project. Key staff members must be onsite and directly supervising the heat straightening operations at all times. Key staff members not listed will not be allowed to work on the jobsite. Non-key staff members applying jacking forces or heat must be listed in the comments section below.
NAME	
NAME	
NAME	

Heat straightening is to be performed in accordance with 713.03.G of the MDOT Standard Specifications for Construction, 20SP713A, and all other contract requirements.

NON-DESTRUCTIVE TESTING

All damaged areas specified on the plans and all heat straightened areas must be 100 percent Virtual Testing (VT) and Magnetic Particle Testing (MT) inspected by an American Welding Society (AWS) Certified Welding Inspector (CWI). All weldments located in or adjacent to damage areas specified on the plans, located in or adjacent to heat straightened areas, and on components (clip plates, connection plates, intermediate stiffeners, etc.) that connect the beam/girder that was damaged to other beam/girder lines as determined by the Engineer must be 100 percent VT inspected by an AWS CWI and 100 percent MT inspected by an American Society for Nondestructive Testing (ASNT) Level II or III technician. MT must be performed before and after heat straightening and in accordance with AASHTO/AWS D1.5:2020, Bridge Welding Code (as modified by 20SP707A - Structural Steel and Aluminum Construction). Field welding requires an AASHTO/AWS D1.5 - Field Welding Plan ([MDOT Form 0395](#)) to be completed and submitted for review and approval by the Engineer prior to welding.

HEAT STRAIGHTENING PROCEDURE

Attach Heat Straightening Plan in accordance with 20SP713A.