



ROBERT W. HUNT COMPANY
A Bureau Veritas Company

S-37-58

REPORT OF QUALITY ASSURANCE SERVICES

Project: Sign structures for Marathon County

RWH Reference: 963693 & 963736

Prime Contractor:

Client Reference: 88513/ 1166-07-72 code 5503

Client: Wisconsin Department of Transportation

Reporting Period: (Or Date) 1-3-07

Attachments:

Certified Welding Inspector: Jeff Hudson

Report Reference: 6

Summary of Services Provided:

Witnessed magnetic particle inspection of welds by Valmont QC on truss section for unit 121989. Marked cosmetic grinding/weld repairs (sharp edges from saw cutting pipe, MIG weld wire on weld, poor termination of weld, etc.), with Valmont QC technician and witnessed repairs.

Received the remaining certified mill test reports for units 121986, 121987 & 121988.

Truss assembly for unit 121990 is being tacked together in a fixture.

Witnessed loading of the truss sections for units 121986, 121987 & 121988 on a truck. Valmont QC still does not know which vendor will galvanize these units.

Uprights for require chord connection weldment. This component will be trial fit/tacked during a trial assembly.

All certifications were audited.
Certifications saved for primary
members.

SW
6/20/11

Jeff Hudson
Inspector,

1-3-07
Date

Dan Nichols
Project Manager



ROBERT W. HUNT COMPANY
A Bureau Veritas Company

REPORT OF QUALITY ASSURANCE SERVICES

Project: Sign structures for Marathon County

RWH Reference: 963736

Prime Contractor:

Client Reference: 88513/ 1166-07-72 code 5503

Client: Wisconsin Department of Transportation

Reporting Period: (Or Date) 1-5-07

Attachments: J & K

Certified Welding Inspector: Jeff Hudson

Report Reference: 7

Summary of Services Provided:

Received/reviewed/accepted magnetic particle test reports for:

- Unit 121989 chord to flange welds, (attachment J).
- Unit 121989 upright (column) to connection plate saddle welds, (attachment K).

Visually and mechanically (thickness gage) inspected zinc coating on truss and uprights for 121986, 121987 & 121988, finding:

- Greater than the required 3 mils of zinc.
- Excessive zinc build-up on upright to column connection plate contact surfaces. Valmont QC was notified of the required grinding corrective action.

Witnessed "snug-tightening" of internal diagonal weldments. These components will require field tightening. Unit 121989 is being sent to Witt Company for galvanizing.

Last unit 121990 is having its last (2 of 2) truss sections assembled. Truss has all weld-able cross-bracing tack welded, in preparation for the night shift to weld.

Welds on truss assembly for unit 121989 have been visually inspected, finding them acceptable to AWS D1.5 and approved drawings.

Jeff Hudson
Inspector,

1-5-07
Date

Dan Nichols
Project Manager



ROBERT W. HUNT COMPANY
A Bureau Veritas Company

REPORT OF QUALITY ASSURANCE SERVICES

Project: Sign structures for Marathon County

RWH Reference: 963736

Prime Contractor:

Client Reference: 88513/ 1166-07-72 code 5503

Client: Wisconsin Department of Transportation

Reporting Period: (Or Date) 1-8-07

Attachments:

Certified Welding Inspector: Jeff Hudson

Report Reference: 8

Summary of Services Provided:

Truss and upright sections for units 121986, 121987 & 121988, were shipped 1-5-07.

Truss and upright sections for unit 121989 were galvanized over the weekend.

Warping in cross-brace angles on 121989 uprights was found after galvanizing. Corrective action of removal of defective cross brace angles will be required. Valmont shop is planning to ship replacement cross brace angles to the galvanizing shop this evening.

Truss connection shoes were welded to the support columns for 121990. One of the truss column sections requires removal of welded cross braces, due to the base span being less than the detailed 5 feet, by ½".

Witnessed grinding removal of cross braces on support column for 121990. Shop was trying to save the welded/repared components by not ruining them by flame cutting, which failed. Replacement component heat numbers were noted by writer.

Jeff Hudson *JH* 1-8-07
Inspector, Date

Dan Nichols
Project Manager



ROBERT W. HUNT COMPANY
A Bureau Veritas Company

REPORT OF QUALITY ASSURANCE SERVICES

Project: Sign structures for Marathon County

RWH Reference: 963736

Prime Contractor:

Client Reference: 88513/ 1166-07-72 code 5503

Client: Wisconsin Department of Transportation

Reporting Period: (Or Date) 1-9-07

Attachments: L & M

Certified Welding Inspector: Jeff Hudson

Report Reference: 9

Summary of Services Provided:

Received/reviewed/accepted magnetic particle test reports for:

- Unit 121990 flange to chord weld, (attachment L).
- Unit 121990 base plate weld, base plate gusset welds & truss support shoe welds, (attachment M).

Visually inspected unit 121989 upright column sections finding one bent cross-brace on each section. One upright was repaired by mechanical means. The other requires removal and replacement of cross-brace. 1 of 2 uprights for unit 121990 requires the removal/replacement of two cross-brace angles due to bending of approximately 1".

Unit 121989 has one upright section that has the base plate twisted 3/8". Probably due to the support/rigging done by the galvanizing vendor.

Unit 121990 upright 1 of 2 has the base plates twisted 3/8". Valmont QC has witnessed this writers measurements of the plate twisting discrepancy, and has yet to suggest corrective action.

Upright section 2 of 2 is at the galvanizing shop for galvanizing. Valmont QC is to witness rigging during dipping to identify when twisting of base plates is occurring.

Jeff Hudson *JS/H* 1-9-07
Inspector, Date

Dan Nichols
Project Manager



ROBERT W. HUNT COMPANY
A Bureau Veritas Company

REPORT OF QUALITY ASSURANCE SERVICES

Project: Sign structures for Marathon County

RWH Reference: 963736

Prime Contractor:

Client Reference: 88513/ 1166-07-72 code 5503

Client: Wisconsin Department of Transportation

Reporting Period: (Or Date) 1-10-07

Attachments:

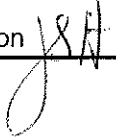
Certified Welding Inspector: Jeff Hudson

Report Reference: 10

Summary of Services Provided:

Witnessed replacement of two upright cross-braces on unit 121989. The base plate flanges & truss saddle supports were counter twisted by a port-a-power hydraulic jack before installation of cross braces. Magnetic particle inspection is scheduled on the adjacent cross-brace plate to column welds.

Upright section 2 of 2 was twisted at the galvanizing shop, as photographic evidence from Valmont QC attests. Photographs indicate that the galvanizing rigging on uprights was on the base-plate offset holes, which twisted them due to the support of load. Also, the center to center base plate measurements were taken before and after galvanizing, which measures the 3/8" rotation of the base plates, which in turn has caused cross-braces to bend.

Jeff Hudson  1-10-07
Inspector, Date

Dan Nichols
Project Manager



ROBERT W. HUNT COMPANY
A Bureau Veritas Company

REPORT OF QUALITY ASSURANCE SERVICES

Project: Sign structures for Marathon County

RWH Reference: 963736

Prime Contractor:

Client Reference: 88513/ 1166-07-72 code 5503

Client: Wisconsin Department of Transportation

Reporting Period: (Or Date) 1-11-07

Attachments:

Certified Welding Inspector: Jeff Hudson

Report Reference: 11

Summary of Services Provided:

Witnessed magnetic particle inspection on upright 121990 (1 of 2), cross-brace plate to column welds finding them without cracks. This unit had two cross-braces changed then welded. Touch up galvanizing is being performed on area where galvanized zinc plating was removed for welding or magnetic particle testing. (1 of 2, 121989 uprights is acceptable, "as is". The other (2 of 2), 121989 upright will require disassembly (cutting of welds and cross-braces), as it is not dimensionally in compliance with the approved drawing. The remaining upright 121990 (2 of 2) is being repaired for two bent cross-braces and twisted base plates. Zinc coatings on truss sections for 121989 & 121990 were visually found as acceptable in appearance and over 3 mils of coating.

Jeff Hudson
Inspector,

1-11-07
Date

Dan Nichols
Project Manager



ROBERT W. HUNT COMPANY
A Bureau Veritas Company

REPORT OF QUALITY ASSURANCE SERVICES

Project: Sign structures for Marathon County

RWH Reference: 963736

Prime Contractor:

Client Reference: 88513/ 1166-07-72 code 5503

Client: Wisconsin Department of Transportation

Reporting Period: (Or Date) 1-12-07

Attachments:

Certified Welding Inspector: Jeff Hudson

Report Reference: 12

Summary of Services Provided:

Repairs to unit 121989 are completed. A trial fit up with truss to upright shoes was witnessed and found to be adequate. Unit 121989 is acceptable to ship.

Unit 121989 upright (2 of 2) requires two cross-braces welded in place. The missing cross-braces are at the Ivanizing shop.

Once upright is repaired a trial fit-up to truss sections will be required.

Received/reviewed/accepted certified mill test reports for 121989 & 121990. The replacement angles are the only components missing from the material packages.

Jeff Hudson
Inspector,

1-12-07
Date

Dan Nichols
Project Manager



ROBERT W. HUNT COMPANY
A Bureau Veritas Company

REPORT OF QUALITY ASSURANCE SERVICES

Project: Sign structures for Marathon & Rock County

RWH Reference: 963736

Prime Contractor:

Client Reference: 88513/ 1166-07-72 code 5503

Client: Wisconsin Department of Transportation

Reporting Period: (Or Date) 1-15-07

Attachments:

Certified Welding Inspector: Jeff Hudson

Report Reference: 13

Summary of Services Provided:

Witnessed trial fit-up of trusses to uprights on unit 121990. Units accepted bolts through upright shoes and truss chord holes.

Checked zinc coating thickness finding it above 3 mils in all randomly checked areas on both 121989 & 121990 trusses and uprights.

Acceptance stamped 121989 & 121990 as they are ready to ship.

Witnessed zinc dipping of truss span for 122058 at Witt galvanizing. Witnessed Witt inspector testing zinc thickness on 122058 upright, finding an average of 6 mils of zinc. The truss span was too hot to check for zinc thickness.

Requested missing certified mill test reports from Valmont QC for unit 122058

Requested missing magnetic particle test reports for 122058.

Jeff Hudson
Inspector,

1-15-07
Date

Dan Nichols
Project Manager



ROBERT W. HUNT COMPANY
A Bureau Veritas Company

REPORT OF QUALITY ASSURANCE SERVICES

Project: Sign structures for Marathon & Rock County

RWH Reference: 963736

Prime Contractor:

Client Reference: 88513/ 1166-07-72 code 5503

Client: Wisconsin Department of Transportation

Reporting Period: (Or Date) 1-19-07

Attachments: AA & AB

Certified Welding Inspector: Jeff Hudson

Report Reference: 14

Summary of Services Provided:

Received missing certified mill test reports & magnetic particle test reports for unit 122058.

- Attachment AA is a magnetic particle test report for welds on the upright gussets & support plates.
- Attachment AB is a liquid die penetrant test report for column chord plate & truss connection plate welds.

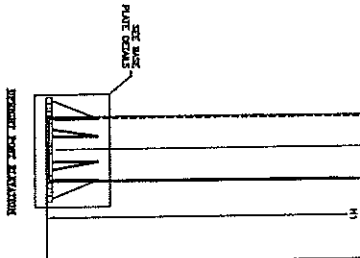
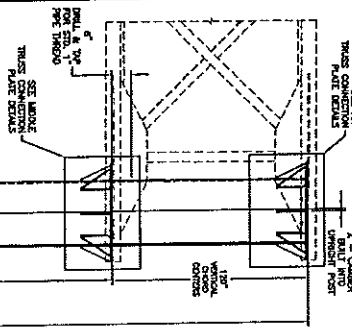
Compiled mill test reports & non-destructive test reports for units: 121986, 121987, 121988, 121989, 121990 & 122058. Will send this data to Lombard office for distribution.

Jeff Hudson *JH* 1-19-07
Inspector, Date

Dan Nichols
Project Manager

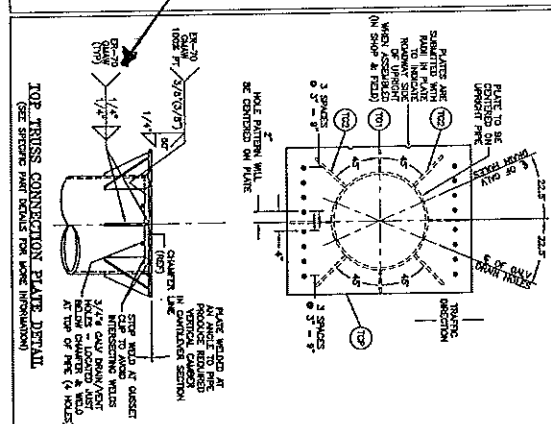
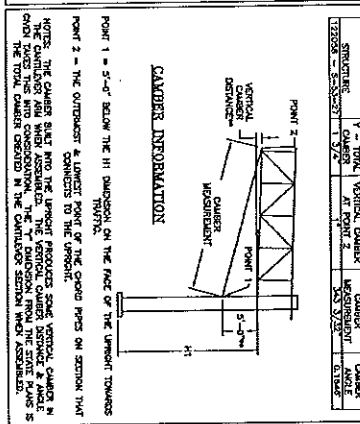
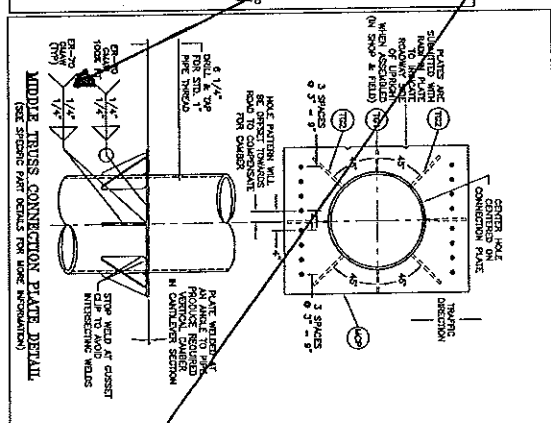
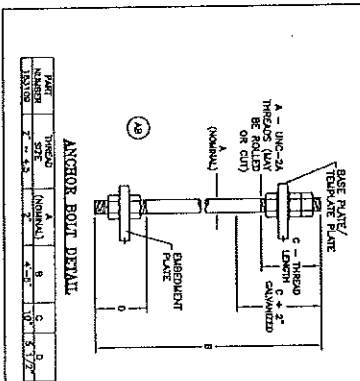
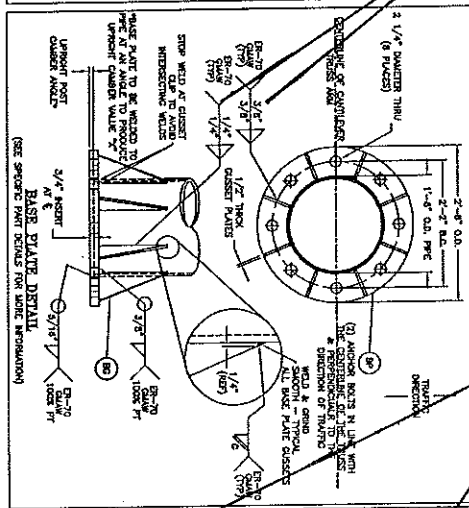
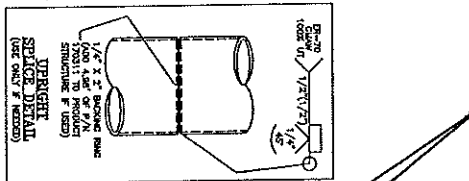
PART	L - OVERALL		X - UPRIGHT POST
NUMBER	M	H1	POST CARRIER
100241	122006	21 5/8 (17-10 3/4)	27 3/4 (22-10 3/4)
			HEIGHT
			6/8
			UPRIGHT POST
			CARRIER ANGLE
			0.1305

*H1 & OVERALL HEIGHT VALUES FOR THE UPRIGHT ARE MEASURED TO THE CENTER OF THE TOP FACE OF THE TOP PLATE ALONG THE CENTERLINE OF THE UPRIGHT PIPE.
SEE THE FOLLOWING PAGE FOR SPECIFIC PART DETAILS.

[illegible]

W-2 MPPO

42-100% MS

[illegible]

PROPRIETARY NOTE:
THE DATA AND TECHNIQUES CONTAINED IN THIS DRAWING ARE PROPRIETARY INFORMATION OF VALMONT INDUSTRIES AND CONSIDERED A TRADE SECRET. ANY USE OR DISCLOSURE WITHOUT THE CONSENT OF VALMONT INDUSTRIES IS STRICTLY PROHIBITED.

TOLERANCE NOTE:
TOLERANCES GOVERN UNLESS OTHERWISE NOTED ABOVE

(PLUS OR MINUS) MACHINING 0.030" AND STRUCTURAL 0.060"
BENDS ARE (+ OR -) 1/2 DEGREE.

DESCRIPTION		DATE BY	CHKD NO.	DRAWING USAGE
WISCONSIN CANTILEVER SUBMITTAL		THUR 06/28/2006	3901	SUBMITTAL
CITY PROJECT# C2006-08				
JANESVILLE - ROCK COUNTY				
ENG. APPROVAL	CHECKED BY			
JAWH 12/11/2006	TWR 12/11/2006			

DESCRIPTION
WISCONSIN CANTILEVER SUBMITTAL
CITY PROJECT# C2006-08
JANESVILLE - ROCK COUNTY

valmont 
7-657-4761 Dunsmuir IN



Report #4 attachment "AB"

PAGE NO. 1 OF 1

CTS JOB # 9709

CALUMET TESTING SERVICES

1945 N. Griffith Blvd. / Griffith, Indiana 46319 / (219) 923-9800 - (708) 474-5860 - FAX (219) 923-0990

REPORT OF NONDESTRUCTIVE EXAMINATION

MT ☐ PT ☒

Customer Valmont Structures		Job No.		Project P/N# 199260 & P/N# 199241		Date 1-11-2007	
Examination Standard/Edition - Add ASTM E-165		Acceptance Standard/Edition - Add AWS D11 Sec 6/2006		N.D.E. Procedure No. LP 3-9		P.O. No.	
Line or Dwg. No.		Surface Condition As Welded		Mat'l Temp. 70°F		Mat'l Thickness VARIABLES	
						Type of Material 415	
MAGNETIC PARTICLE TECHNIQUE DATA* N/A							
Equipment		Dry <input type="checkbox"/>	Visible <input type="checkbox"/>	AC <input type="checkbox"/>	DC <input type="checkbox"/>	Amperage	Prod. Spacing
		Wet <input type="checkbox"/>	Fluorescent <input type="checkbox"/>		Rectified <input type="checkbox"/>		Head <input type="checkbox"/> Coil <input type="checkbox"/> Yoke <input type="checkbox"/>
						Particle Type	
						Batch No.	
LIQUID PENETRANT TECHNIQUE DATA* N/A							
Penetrant MAGNAFLUX SKL-SPI		Batch No. 06B12K		Penetrant - Dwell Time 10 MIN		Development - Time 15 MIN	
Cleaner MAGNAFLUX SKC-S		Batch No. 06B01K		Developer MAGNAFLUX SKD-S2		Batch No. 06B10K	

IDENTIFICATION	ACC.	REJ.	REMARKS & DIAGRAM
J/N#A-122058 P/N# 199241 W1 W2 W3 W4 W5	✓ ✓ ✓ ✓ ✓		<p>A Liquid Penetrant Examination was performed on Pieces Shown. No Reportable Defects were found. For the State of Illinois WISCONSIN.</p> <p>DWG #198557</p> <p>P/N# 199260</p> <p>3/16" TYP 100% PT</p> <p>W1 then W8</p> <p>3/16" TYP 100% PT</p> <p>P/N# 199241</p> <p>100% PT</p> <p>W5 W4 W3 W2 W1</p>
J/N#A-122058 P/N# 199260 W1 W2 W3 W4 W5 W6 W7 W8	✓ ✓ ✓ ✓ ✓ ✓ ✓ ✓		

Examiner A.R. Doten II 1-11-2007
Signature Level Date

Interpreter A.R. Doten II 1-11-2007
Signature Level Date

Customer Review [Signature] 1-11-07
Signature Date

121986

1/3

PO14397
PA173406
HTA31856



AMERICAN STEEL PIPE
A division of American Cast Iron Pipe Co.,
P.O. Box 2727, Birmingham, AL 35202-2727
QUALIFICATION REPORT OF SHIPMENT

DATE: 17/FEB/2005

MFG Order Number
S106367Customer Order Number
25479

CUSTOMER ADDRESS: SAGINAW PIPE INCORPORATED
P O BOX 8
SAGINAW AL 35137

SPECIAL NOTES

LINE 1 WILL ALSO CERTIFY TO ASTM A53 GRADE B AND ASME SA53 GRADE B.
LINE 2 WILL ALSO CERTIFY TO API 5L GRADE BX42 PSL2; ASTM A53 GRADE B
AND ASME SA53 GRADE B.
PIPE WERE NDT TESTED USING AN ULTRASONIC TEST METHOD CALIBRATED ON ID & OD N-10 NOTCHES
HYDROSTATIC TEST DURATION 10 SECONDS. MAX ALLOWABLE PCM .25.
MINIMUM WELD SEAM ANNEAL TEMPERATURE 1600 DEGREES F FOR ALL PIPE.
CHARPY ACCEPTANCE CRITERIA MIN. ENERGY 14/HEAT, MIN. SHEAR AREA N/A.

LINE	PIECES	FOOTAGE	SIZE	WALL	SHIPMENT DESCRIPTION	SPECIFICATIONS	GRADE
1	37	2553.1	20.00	.500	ERW API LINE PIPE	API 5L, PSL2	BX42
2	58	4026.5	24.00	.375	DITTO		X52

All tests are from the body of the pipe in the transverse direction unless otherwise noted.
Standard tensile gage length 1-1/2" x 2".

HEAT	C	MN	P	S	CE	SI	TI	CU	NI	MO	CR	V	AL	B	N	C.E.	Coil Pipe
A31856	*	LINE 1															
EDITION REFERENCE 3																	
Yield Strength by Strap																	
W=0.060	1.000	0.010	0.010	0.006	0.029	0.160	0.009	0.110	0.040	0.020	0.050	0.000	0.033	.0001	.0072	0.126	0013
P=0.050	0.976	0.010	0.010	0.006	0.032	0.157	0.008	0.115	0.039	0.015	0.055	0.000	0.025	.0003	.0000	0.116	04/08
M=Weld Ten.	77.0 ksi	Ten.	70.5 ksi	Yield	61.5 ksi	Yield	61.5 ksi	Yield	45.0 RB	78	Hydro:	1890 Psi	RUN: 44-4				
Y/T RATIO = 0.87																	

Attachments

PAGE 1
Continued

Issue No.: 6

Form Date: 10/18/2004

QD-AW3F05

(1) 2000 500 DX 42 CB3
(2) 2400 375 DX 52 E B3

WI-DOT-121986

SO-963736



CUSTOMER NAME: SAGINAW PIPE INCORPORATED
Charpy "V" Notch Tests

Date: 17/FEB/2005
MFG Order Number
S106367

Customer Order Number
25479

P014397 2/3
Q173406

HEAT NO.	SIZE	TEMP	Energy (FT./LBS.)	AVG.	Fracture Appearance (% Shear Area)	AVG.	Line
A31856 -	.666	32	166.0	124.0	126.0	138.7	100 100 100 100.0 1
C30891 -	.666	32	158.0	148.0	134.0	146.7	100 100 100 100.0 1
B4S6306 -	.666	32	166.0	158.0	150.0	158.0	100 100 100 100.0 1
B4S6307 -	.666	32	164.0	170.0	160.0	164.7	100 100 100 100.0 1
44858 -	.666	32	83.0	85.0	81.0	83.0	100 100 100 100.0 2
44469 -	.666	32	134.0	164.0	180.0	159.3	100 100 100 100.0 2
44470 -	.666	32	104.0	111.0	96.0	103.7	100 100 100 100.0 2
ALL HEAT AVERAGE = 136.3							100.0

Legend Analyses:

- A-Z - Additional Testing R - Retest
- H - Heat Analysis L - Longitudinal
- P - Product Analysis T - Transitional
- M - Mechanical Properties W - Weld Line

Hydrostatic Test: OK
Flattening Test: OK

EDITION REFERENCE 1: API 5L 41ST EDITION 4/1/1995
EDITION REFERENCE 2: API 5L 42ND EDITION 7/1/2000
EDITION REFERENCE 3: API 5L 43RD EDITION 10/4/2004
EDITION REFERENCE 4: ASTM/ASME ANNUAL BOOK OF STANDARDS SECT.1, VOL 01.01

* Manufactured and Melted in the USA.

We hereby certify that the above figures are correct as contained in the records of this company, and th the pipe were manufactured, tested and inspected in compliance with the latest edition of the applicable specification, in Birmingham, Alabama, U.S.A.

Noel A. Gordon

Noel A. Gordon
Manager of Quality Assurance - Steel Pipe

PAGE 4
End Of Report
Form Date: 10/18/2004

Issue No.: 6

QD-AW3F055

HYCOR
PLATE MILL

P.O. Box 279
 Winston, NC 27586
 (252) 356-2700

Mill Test Report

PO 20139 PN 351345

Issuing Date : 05/27/2009 CUL No. : 135114 Load No. : 251004 Cust. Order No. : 450345 Ship To : METRON STEEL DIVISION
 Vehicle No. : LW 62065 Sold To : PRIMARY STEEL LLC 12900 SOUTH METRON DRIVE OF PRIMARY STEEL INC
 Specification : 1.7500" x 96.000" x 480.000" METRON DIVISION, CHICAGO, ILLINOIS 12900 SOUTH METRON DRIVE CHICAGO, IL 60628
 ASTM A36-05/ASTM A709 Grade 36-36/ASME SA36-03 CHICAGO, IL 60633

Marking :

Heat No	C	Mn	P	S	Si	Cu	Ni	Cr	Mo	Al	V	Nb	Ti	N	Ca	B	Sn	CEQ	PCM
6104356	0.19	0.64	0.011	0.007	0.19	0.24	0.05	0.37	0.01	0.009	0.004	0.007	0.001		0.0001	0.0004	0.013	0.36	0.25
Tensile Test																			
Plate Serial No.	Plates	Dir.	Yield	Tensile	Elongation	Charpy Impacts													
6104356-05	2	T	41,000	68,300	18.5														
		F	41,500	69,200	21.5														

PO 20139
 PN 351345
 CE = .370

LW30944

Manufactured to fully killed practice by Electric Arc Furnace. Welding or weld repair was not performed on this material.
 Mercury has not been used in the direct manufacturing of this material. Produced as continuous cast as-rolled discrete plate
 Yield by 0.5%EL method unless otherwise specified. Deq = C470MnSi+60Cr-Mb-Nb-Ni-Si-Mn(Cu+Mn+Si)
 Form = C470MnSi+60Cr-Mb-Nb-Ni-Si-Mn(Cu+Mn+Si)
 Marked and manufactured in the USA. ISO 9001:2009 certified (012442-0) by SRI Quality System Register (00965-02). PED 97/23/EC Conformant.
 DIN 50646 3.1, BEN 10214 3.1, EN10004 compliant. For ABS grades only. Quality Assurance certificate No. 03-MMPQA-182
 We hereby certify that the contents of this report are accurate and correct. All test results and operations performed by the material manufacturer are in compliance with the applicable specifications.
 T. A. Depuyts, Metallurgist
 05/25/2009 3:21:02 PM



Report #4 Attachment "G"

CALUMET TESTING SERVICES

1945 N. Griffith Blvd. / Griffith, Indiana 46319 / (219) 923-9800 - (708) 474-5860 - FAX (219) 923-0990

REPORT OF NONDESTRUCTIVE EXAMINATIONMT ☐ PT ☒

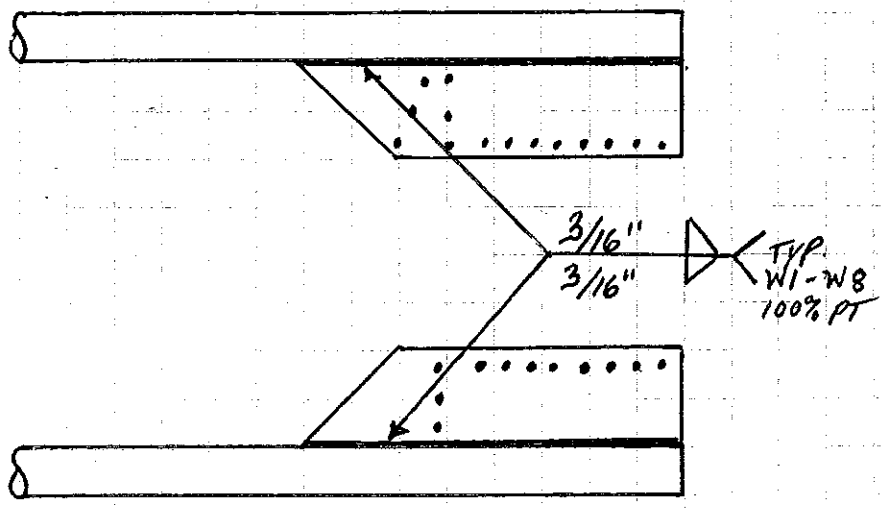
Customer VALMONT STRUCTURES	Job No. 121986	Project P.N. 199257	Date 12-28-06
Examination Standard/Edition - Add ASTM E-165	Acceptance Standard/Edition - Add ANSI 211 2006 SEC. 6	N.D.E. Procedure No. LP 3-9	P.O. No.
Line or Dwg. No. 198557	Surface Condition AS WELDED	Mat'l Temp. 65°	Mat'l Thickness 3/16"
		Type of Material C/S	

MAGNETIC PARTICLE TECHNIQUE DATA* N/A ☒

Equipment	Dry <input type="checkbox"/> Visible <input type="checkbox"/> AC <input type="checkbox"/> DC <input type="checkbox"/> Amperage	Prod. Spacing	Particle Type	Batch No.
	Wet <input type="checkbox"/> Fluorescent <input type="checkbox"/> Rectified <input type="checkbox"/>	Head <input type="checkbox"/> Coil <input type="checkbox"/> Yoke <input type="checkbox"/>		

LIQUID PENETRANT TECHNIQUE DATA* N/A ☐

Penetrant SKL-SP1 MAGNAFLUX	Batch No. 05G02K	Penetrant - Dwell Time 10 MIN Water Washable <input type="checkbox"/> Visible <input type="checkbox"/> Solvent Post Emulsified <input type="checkbox"/> Fluorescent <input type="checkbox"/> Removable <input checked="" type="checkbox"/>	Development - Time 7 MIN Dry <input type="checkbox"/> Wet <input type="checkbox"/> Nonaqueous <input checked="" type="checkbox"/>
Cleaner SKC-S MAGNAFLUX	Batch No. 06B01K	Developer SKD-S2 MAGNAFLUX	Batch No. 05G05K

IDENTIFICATION	ACC.	REJ.	REMARKS & DIAGRAM
W-1	✓		<p>A LIQUID PENETRANT INSPECTION WAS PERFORMED ON 8 DIFFERENT PLATES AS NOTED ON DRAWING 198557 TO PART # 199257. NO REJECTABLE INDICATIONS WERE FOUND.</p>  <p>P.N. 199257 Dwg. #198557 Job # 121986</p>
W-2	✓		
W-3	✓		
W-4	✓		
W-5	✓		
W-6	✓		
W-7	✓		
W-8	✓		

Examiner <u>T. WASIELESKI</u> Signature	<u>II</u> Level	<u>12-28-06</u> Date	Customer Review <u>[Signature]</u> Signature	<u>12-28-06</u> Date
Interpreter <u>[Signature]</u> Signature	<u>II</u> Level	<u>12-28-06</u> Date		

Report #4 Attachment "D" Pg 1 of 2

REPORT OF MAGNETIC-PARTICLE EXAMINATION OF WELDS

Project Wisconsin Project# 1066-10-71 Valmont job 121986 Part#199238

Quality requirements—Section No. WDOT Specification 2004 Edition, Section 641.3.3 & AWS D1.1 Section 6.10

Reported to Wisconsin Inspector Craig Wehrele

WELD LOCATION AND IDENTIFICATION SKETCH

See Attached drawing indicating
location of weld.Quantity: 4 Total Accepted: 4 Total Rejected: 0

Date	Weld Identification	Area Examined		Interpretation		Repairs		Remarks
		Entire	Specific	Accept.	Reject	Accept.	Reject	
12/28/06	W-1		10%	Yes				
12/28/06	W-2		10%	Yes				
12/28/06	W-3		10%	Yes				
12/28/06	W-4		10%	Yes				

PRE-EXAMINATION

Surface Preparation: Scrape & Wirebrush

EQUIPMENT

Instrument Make: Parker Contour ProbeModel: B100S. No.: 3121

METHOD OF INSPECTION

☒ Dry ☐ Wet ☒ Visible ☐ FluorescentHow Media Applied: Powder Bulb☐ Residual ☒ Continuous ☐ True-Continuous☒ AC ☐ DC ☐ Half-Wave☐ Prods ☒ Yoke ☐ Cable Wrap ☐ Other _____Direction for Field: ☐ Circular ☐ LongitudinalStrength of Field: 10 Pound Certified

(Ampere turns, field density, magnetizing force, number, and duration of force application.)

POST EXAMINATION

Demagnetizing Technique (if required): NONECleaning (if required): _____ Marking Method: Pigmented Opaque ink pen

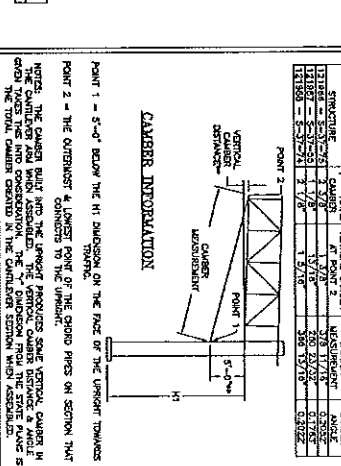
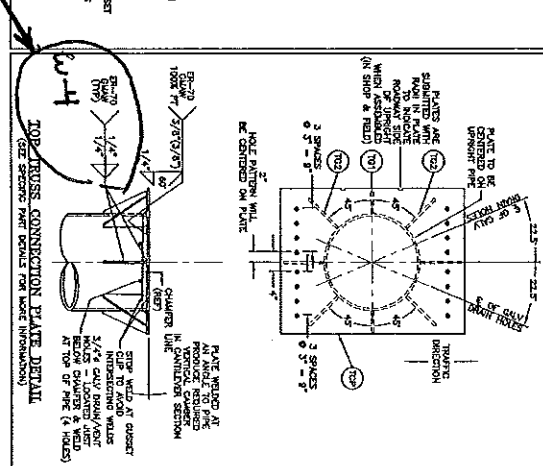
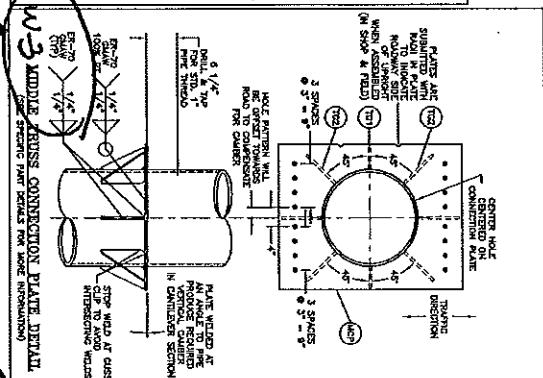
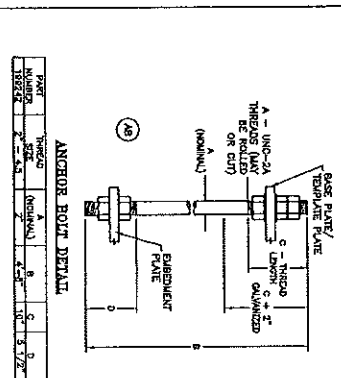
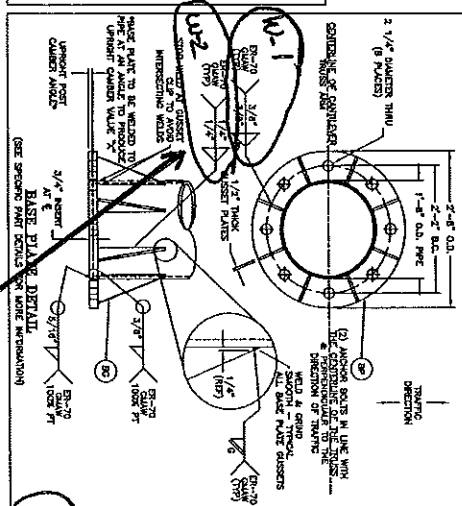
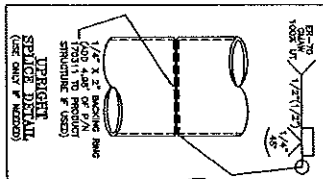
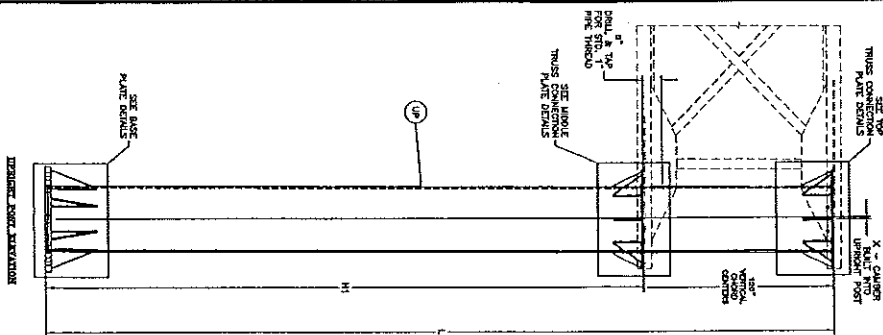
We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared and tested in conformance with the requirements of AWS D1.1/D1.1M, (2006) Structural Welding Code—Steel.
(year)

Inspector Rick SaenzManufacturer or Contractor Valmont Structures / Plymouth, INLevel IIAuthorized By Joel WadasTest Date 12/28/2006Date 12/28/2006

SEE THE FOLLOWING PAGES FOR SPECIFIC PART DETAILS.

COMPARISON FOR PAPER 1416: COMPARISON 1950-1951			
WINTER REAR 1950-51: N = 71 (60 ADULTS)			
DATE	NUMBER OF PULP COPIES	ST. OF CLOSURE OF THE PULP	ST. OF PULP
10/10/50	1	100% FINE	100% FINE
10/11/50	1	100% FINE	100% FINE
10/12/50	1	100% FINE	100% FINE
10/13/50	1	100% FINE	100% FINE
10/14/50	1	100% FINE	100% FINE
10/15/50	1	100% FINE	100% FINE
10/16/50	1	100% FINE	100% FINE
10/17/50	1	100% FINE	100% FINE
10/18/50	1	100% FINE	100% FINE
10/19/50	1	100% FINE	100% FINE
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10/78/50	1	100% FINE	100% FINE
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10/81/50	1	100% FINE	100% FINE
10/82/50	1	100% FINE	100% FINE
10/83/50	1	100% FINE	100% FINE
10/84/50	1	100% FINE	100% FINE
10/85/50	1	100% FINE	100%

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100		1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100	1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86
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REV.	DESCRIPTION OF REVISIONS	QPD	BY	DATE
D	CORRECTED DETAIL FOR "TBA" ON P. 17	3582	JMC	12/12/2006
C	REVISED SIDEPLATE "TBS" DIMENSIONS	3582	TWR	12/07/2006
B	CORRECTED SIDE PLATE QUANTITIES	3582	JMC	11/07/2006
A	UPDATED FOR FABRICANT RELEASE	3582	JMC	10/31/2006

TOLERANCE NOTE:
TOLERANCES ON DIMENSIONS UNLESS OTHERWISE NOTED ARE
(PLUS OR MINUS) MACHINING 0.030 AND STRUCTURAL 0.060
BENDS ARE (+ OR -) 1/2 DEGREE.

DR BY	CPD NO.	DRAWING USAK
TWR 05/16/2006	3882	SUBMITTA
ENG. APPROVAL	CHECKED BY	
JMW 12/12/2006	TWR 12/12/20	

1-888-880-9191	Salem, OR	11/06/2007
PART NO.		20 OF 23
DMC. NO.	198557	

PROPRIETARY NOTE:
THE DATA AND TECHNIQUES CONTAINED IN THIS DRAWING ARE PROPRIETARY INFORMATION OF VALMONT INDUSTRIES AND CONSIDERED A TRADE SECRET. ANY USE OR DISCLOSURE WITHOUT THE CONSENT OF VALMONT INDUSTRIES IS STRICTLY

DESCRIPTION	AMOUNT
WISCONSIN BOX TRUSS SUBMITTAL	
PROJECT# 1166-07-72	
MARATHON COUNTY	

valmont 
1-877-467-4763 Plymouth, IN
VTB1171 INDEX

10% MT



Report #4 Attachment "C"

PAGE NO. 1 OF 1

CTS JOB # 9635

CALUMET TESTING SERVICES

1945 N. Griffith Blvd. / Griffith, Indiana 46319 / (219) 923-9800 - (708) 474-5860 - FAX (219) 923-0990

REPORT OF NONDESTRUCTIVE EXAMINATIONMT ☐ PT ☒

Customer VALMONT STRUCTURES		Job No. A 121986		Project P.N. 199238 BOX TRUSS UPRIGHT		Date 12-27-06	
Examination Standard/Edition - Add ASTM E-165		Acceptance Standard/Edition - Add AWS D1.1-2006 SEC.6		N.D.E. Procedure No. LP-3-9		P.O. No.	
Line or Dwg. No. 198557		Surface Condition AS WELDED		Mat'l Temp. 65°		Mat'l Thickness VARIOUS	
						Type of Material Q/S	
MAGNETIC PARTICLE TECHNIQUE DATA* N/A <input checked="" type="checkbox"/>							
Equipment		Dry <input type="checkbox"/>	Visible <input type="checkbox"/>	AC <input type="checkbox"/>	DC <input type="checkbox"/>	Amperage	Prod. Spacing
		Wet <input type="checkbox"/>	Fluorescent <input type="checkbox"/>		Rectified <input type="checkbox"/>		Head <input type="checkbox"/> Coil <input type="checkbox"/> Yoke <input type="checkbox"/>
						Particle Type	
						Batch No.	
LIQUID PENETRANT TECHNIQUE DATA* N/A <input type="checkbox"/>							
Penetrant SKL-SPI MAGNAFLUX		Batch No. 06B12K		Penetrant - Dwell Time 10 MIN		Development - Time 7 MIN	
Cleaner SKC-S MAGNAFLUX		Batch No. 06B02K		Developer SKD-S2 MAGNAFLUX		Batch No. SKD-S2	

IDENTIFICATION	ACC.	REJ.	REMARKS & DIAGRAM
W-1	✓		<p>A LIQUID PENETRANT INSPECTION WAS PERFORMED ON P.N. 199238 JOB #121986 DWG. #198557 ON 100% OF INDICATED WELDS BELOW. NO REJECTABLE INDICATIONS WERE FOUND.</p>
W-2	✓		
W-3	✓		
W-4	✓		
W-5	✓		

Examiner T. WASIELESKI II 12-27-06
 Signature Level Date

Interpreter Kenn Altman II 12-27-06
 Signature Level Date

Customer Review David Baldo 12-27-06
 Signature Date