

**ITEM 09564.7501 M - WELD REPAIR, TYPE 1**  
**ITEM 09564.7502 M - WELD REPAIR, TYPE 2**  
**ITEM 09564.7503 M - WELD REPAIR, TYPE 3**

**DESCRIPTION**

Under these items, the contractor shall perform repair work to the existing structural steel where indicated on the plans and where ordered by the engineer. The work shall be done in place.

**MATERIALS**

Materials for this work shall meet the requirements of the New York State Steel Construction Manual (SCM) and the welding procedure specifications and general repair notes listed in the contract documents.

**CONSTRUCTION DETAILS**

All welding work shall be done in accordance with the provisions of the SCM and the procedures listed in the contract documents for each type of weld repair.

Dye penetrant testing of the finished repairs, where required by the repair procedures, will be done by qualified technicians in accordance with Section 19 of the SCM and in accordance with the methods noted in the contract. This testing shall be witnessed by a representative of the state.

Ultrasonic Testing (UT) of the finished repairs, where required by the repair procedures, will be done by the state. The contractor shall allow for scheduling of the UT by contacting the D.C.E.S. five (5) working days prior to the need for testing.

Rejectable indications in any of the tested welds shall be repaired by the contractor at no additional cost to the state.

Paint removal and repainting of the repair location will be required and paid under the appropriate items in the contract.

**METHOD OF MEASUREMENT**

The quantity to be paid for shall be for each weld repair performed where required. Each weld repair shall be considered the work involved to complete each repair at the locations shown on the plans, or ordered by the engineer.

**BASIS OF PAYMENT**

The unit price bid shall include the cost of furnishing all labor, materials, testing and equipment necessary to complete the work. All damage done to the structure while performing the necessary repairs shall be corrected to the satisfaction of the engineer at the contractor's expense.