

Mock Exercise Instructions for Fabricators of Hydraulic Steel Structures

1. Scope

For applicability, refer to the *Supplemental Program Requirements for Fabricators of Hydraulic Steel Structures (the Supplements)*. This exercise will demonstrate fabrication knowledge, skills, and capability to produce fabricated steel to the quality required for hydraulic steel structures.

2. Document Requirements

In addition to the required documents listed in the Supplements, the fabricator shall have the following documents available for review during the site audit:

1. Valid SAW or FCAW Welding Procedure Specification (WPS) with supporting Procedure Qualification Record (PQR) for all welds in this exercise.
2. C



6.

Inspection, and Audit Activities

Fabrication Activity	Inspection Instructions	Audit Activities
Bottom Plate - Butt-joint CJP weld (Plate 1 to 2 shall be completed first to permit RT)	<p>The welded assembly may be completed prior to the start of the on-site audit.</p> <p>Visual inspection and NDT shall be performed in accordance with the fabricator's QMS and FCP.</p>	<p>The on-site auditor shall observe the completed welds. Witness of NDT is not required.</p> <p>The Fabricator's inspection records, including NDT reports, shall be made available for the onsite auditor to review.</p>
T-Joint CJP weld (Plate 1 to 3)		
T-Joint CJP weld (Plate 2 to 4)		
T-Joint CJP weld (Plate 6 to 3 and 4 and Plate 8 to 3 and 4)		
T-Joint Fillet Welds (Plate 5 and Plate 7)		



<p>Holes</p>	<p>Drilling of holes may be completed prior to site audit.</p> <p>Dimensional inspection of hole sizes, locations, and alignment shall be performed in accordance with the fabricator's QMS.</p>	<p>The onsite auditor shall observe the measurement/verification of hole sizes, locations, and alignment.</p> <p>The Fabricator's QC and inspection records shall be made available for the onsite auditor to review.</p>
<p>Final Inspection</p>	<p>Final inspection shall be performed in accordance with the fabricator's QMS and FCP.</p>	<p>The Fabricator's QC and final inspection records, including NDT reports, shall be made available for the onsite auditor to review.</p>

