

State of Illinois
Department of Transportation
Bureau of Materials and Physical Research
Springfield

POLICY MEMORANDUM

Revised: June 6, 2014

26-08.6

This Policy Memorandum supersedes number 26-08.5 dated August 12, 2011

TO: REGIONAL ENGINEERS AND HIGHWAY BUREAU CHIEFS

SUBJECT: REINFORCEMENT BAR AND/OR DOWEL BAR PLANT
CERTIFICATION PROCEDURE

1.0 SCOPE

1.1 This procedure shall apply to all Producers that supply reinforcement bars to State of Illinois projects. No reinforcement bars may be used unless the Producer has been certified.

2.0 PURPOSE

2.1 To establish a procedure whereby Producers may supply reinforcement bars and/or dowel bars based on their status as a Certified Producer.

2.2 To set forth the procedures and conditions for Producer certification.

3.0 APPLICABLE SPECIFICATIONS

3.1 ASTM A706/A706M, "Low-Alloy Steel Deformed and Plain Bars for Concrete Reinforcement" (current year issued).

3.2 ASTM A36/A36M, "Standard Specification for Standard Carbon Structural Steel" (current year issued).

3.3 ASTM E4 "Standard Practices for Force Verification of Testing Machines"

3.4 AASHTO M227/M227M, "Steel Bars, Carbon, Merchant Quality, Mechanical Properties" (current year issued).

3.5 National Transportation Product Evaluation Program (NTPEP), "Standard Practice for NTPEP Evaluation of Reinforcing Steel"

3.6 Illinois Department of Transportation Standard Specifications for Road and Bridge Construction (current year issued).

4.0 DEFINITIONS

BUREAU - Bureau of Materials and Physical Research, Springfield, Illinois.

CERTIFIED MILL ANALYSIS - A document prepared by the Producer that lists all chemical and physical test results as required by the applicable specifications. The following must also be included in addition to any other data deemed necessary by the Producer:

- Producer name and address
- Type and grade
- Heat number
- Authorized signature of person responsible for quality control
- Date melted and where in the United States
- Date rolled
- Date printed

DEPARTMENT - Illinois Department of Transportation.

REGION/DISTRICT - A Bureau of Materials is located at each Illinois Department of Transportation District.

ENGINEER - The Director of Highways of the Illinois Department of Transportation or authorized representative limited by the particular duties entrusted to that person.

NTPEP – National Transportation Product Evaluation Program.

INSPECTION EXPENSE - The cost of inspection for plant certification will be borne by the Producer. A Producer intending to supply reinforcement bars and/or dowel bars to Illinois projects shall contact the Engineer of Materials and Physical Research, Bureau of Materials and Physical Research, 126 East Ash Street, Springfield, Illinois 62706, to arrange for the required sampling. All samples to be tested by the Bureau will be shipped at the Producer's expense. A producer will not be added to the "Approved/Qualified Producer List of Certified ASTM A-706 Reinforcement Bar and/or Dowel Bar" list until the inspection expenses have been paid in full.

PRODUCER - A steel mill that produces as-rolled deformed reinforcement bars and/or dowel bars.

PRODUCER CLASSIFICATION - A Producer under this procedure will be classified as Certified, Decertified, or Non-Certified.

CERTIFIED PRODUCER - A Producer that has met the requirements for certification under this policy and is allowed to supply reinforcement bars and/or dowel bars to Illinois highway projects.

DECERTIFIED PRODUCER - A Producer whose Certified status has been rescinded because one or more of their products have not consistently met requirements or their certification status has not been maintained. A

Decertified Producer is not allowed to supply reinforcement bars and/or dowel bars to Illinois highway projects.

NON-CERTIFIED PRODUCER - A Producer that does not meet certification requirements according to this policy or has not been checked for certification and is not qualified to supply reinforcement bars or dowel bars to Illinois highway projects.

MISTIC - Materials Integrated System for Test Information and Communication.

5.0 CERTIFICATION PROCEDURE

- 5.1 GENERAL - Certification shall be based on the following: (a) satisfactory compliance of heats tested to standard specifications; (b) satisfactory comparison of test results between laboratories; (c) satisfactory compliance to stated conditions for random samples taken from plant stock melted and rolled within two (2) months of sampling and (d) the Producer must be listed as “compliant” by NTPEP. The method of certification shall consist of both the Producer and the Bureau/NTPEP testing sample bars from the same heats within a two (2) month period for conformance to specifications. The test results obtained by the Producer laboratory shall be compared with the Bureau/NTPEP laboratory test data. The differences in the comparison of test data from the laboratories must fall within the product limits specified.
- 5.1.1 ACCEPTANCE UNDER CERTIFIED PRODUCER STATUS – Under Certified Producer status, plant stock will be checked periodically to the conditions stated herein. Field acceptance of reinforcement bars and/or dowel bars will be based on evidence that the products were manufactured and shipped by a Certified Producer. All shipments of reinforcement bars and/or dowel bars to State of Illinois projects must be clearly identified, as required in Paragraph 5.3. Reliability of data will be verified periodically by comparison tests and random samples from the jobsite.
- 5.2 SAMPLING AND TESTING PROCEDURE – The Engineer will select samples and witness bend tests at the location of the Producer. The results of other tests performed by the Producer shall be forwarded to the Bureau/NTPEP. The material to be sampled shall be selected from sizes, grades, and heats in stock. The date and time shall be prearranged by the Bureau/NTPEP and the Producer.
- 5.2.1 SAMPLING FREQUENCY – Samples shall be taken from 3 different bars and/or dowels from 10 different heats. Samples shall be numbered 1 thru 30 and marked on each end in such a manner as to ensure traceability. Each heat shall be from a different bar size when available. See Appendix A
- 5.2.2 PRODUCER SAMPLE SIZE – Samples sizes shall be such to ensure all tests outlined in 5.2.4 can be performed.

5.2.3 BUREAU/NTPEP SAMPLE SIZE – Sample bars shall be the sister sample to the Producer sample, tagged on both ends with the same identification number. Two 0.8 m (30 in.) tensile samples shall be taken per bar.

5.2.4 SAMPLE TESTING – One (1) specimen from each sample shall be tested by the Producer and the following test results shall be signed and submitted to the Bureau/NTPEP laboratory.

Information/Test	Unit
Bar Number	Numerical (1 thru 30)
Bar Size	English
Heat Number	Unique To Producer
Weight	Lbs
Length	Inches
Deformation Height	In (Pass/Fail)
Deformation Spacing	In (Pass/Fail)
Yield Load	Lbs
Max Load	Lbs
Elongation	%
Bend Test*	Pass/Fail

*Bend test shall be performed on one (1) sample bar per heat by the producer in his/her laboratory.

The specimen that is to be sent to the Bureau/NTPEP shall contain all the markings normally used by the Producer.

5.3 PRODUCER RESPONSIBILITY -

5.3.1 Test sample specimens shall be cut and identified by the Producer in the presence of the Engineer, and all necessary facilities shall be made available to the Engineer to perform his assigned duties. Producer plant facilities, witnessing of testing, and test records shall be accessible to the Engineer or his representative at all times.

5.3.2 The plant laboratory test equipment shall be maintained in good working order and calibrated annually in accordance with ASTM E4.

5.3.3 The Producer, through his supplier if applicable, shall be responsible for supplying material identification consisting of the following: rolled markings, source identification (i.d.) tags, purchase orders, bill of lading, certified mill analysis, or any other documents of certification required by the Engineer to make identification and satisfy reporting requirements.

5.3.4 For a period of five years, the Producer shall maintain all Certified Mill Analyses for reinforcing bars produced, and if applicable, dowel bars. Records shall be available for review during working hours by the Engineer.

5.4 BUREAU RESPONSIBILITY - The Bureau/NTPEP shall test the companion specimens and subsequently determine if Certified Producer status shall be granted. The Producer will be notified in writing as to test

results and Producer Classification. Copies of the updated Certified Producers list will be distributed to all Regions/Districts.

- 5.5 RESIDENT ENGINEER / RESIDENT TECHNICIAN RESPONSIBILITY - The Resident Engineer or Resident Technician at the construction site shall make positive identification between the bar identification marks or source i.d. tags, and the bill of lading or invoice. Material from a Certified Producer shall be accepted and reported to the Region/District Materials Engineer for entry into MISTIC.

6.0 REQUIREMENTS FOR CERTIFICATION

- 6.1 TESTS AND SPECIFICATIONS - The methods of tests and specification requirements shall be in accordance with the applicable specifications.

- 6.2 LABORATORY COMPARISON REQUIREMENTS - Test results for sample of three (3) specimens cut from the same heat and tested at each laboratory shall vary between laboratories by no more than the following:

Unit Weight.....	1.0 percentage point
Yield.....	10.0 percent (see Paragraph 6.2.3)
Tensile.....	10.0 percent
Elongation.....	4.0 percentage points

- 6.2.1 The differences in average test results for the same sample from the same heat tested at each laboratory shall vary between laboratories by no more than the following:

Unit Weight.....	1.0 percentage point
Yield.....	4.0 percent (see Paragraph 6.2.3)
Tensile.....	4.0 percent
Elongation.....	3.0 percentage points

- 6.2.2 Any heat failing to meet Paragraphs 6.2 or 6.2.1 may be resampled. The resampling shall consist of three (3) additional bars from the same heat.

- 6.2.3 Failure of less than 90% of comparable test values to agree within the above limits and meet the minimum product limits will constitute failure to obtain Certified Producer status. Producer will be in Non-Certified Producer status. Yield comparisons may be waived for "coiled" bars at the discretion of the Department.

- 6.3 QUALITY REQUIREMENTS - No more than one (1) heat shall have any of the average test results, as determined in Paragraph 6.2.1, below the applicable specification minimums as tested at either laboratory.

- 6.3.1 No more than one (1) heat may fail the bend test.

- 6.3.2 The failure of more than one (1) heat to meet the deformation height specification will constitute rejection of that heat. No more than two (2) heats may fail the deformation height test.

- 6.3.3 The failure of more than one (1) heat to meet the deformation spacing specification will constitute rejection of that heat. No more than two (2) heats may fail the deformation spacing test.
- 6.3.4 Failure to meet Paragraphs 6.3, 6.3.1, 6.3.2, 6.3.3 or specified chemical analysis will constitute failure to obtain Certified Producer status.
- 6.4 All resampled heats or additional heats sampled shall be included in the limits for quality evaluation as specified in Paragraphs 6.3 and 6.3.1.

7.0 REQUIREMENTS DURING PERIOD OF CERTIFICATION

- 7.1 ENGINEER RESPONSIBILITY - Within each year, each Region/District shall take a minimum of six (6) random samples from material supplied by each Certified Producer plant supplying material to that Region/District and assigned to or designated for a State of Illinois contract. Samples shall be a minimum of six (6) feet and shall include mill markings. The samples shall include as many grades and sizes as are available. The samples shall be taken from different shipments and may be taken at either the jobsite, the fabricator, the warehouse, or any other location approved by the Engineer. The samples shall be sent to the Bureau laboratory for testing.
- 7.2 BUREAU RESPONSIBILITY - The Bureau shall be responsible for all testing and evaluation of the samples. Written notice of Producer Classification will be sent to both the Producer and all Regions/Districts.

8.0 EVALUATION OF RANDOM SAMPLES

- 8.1 QUALITY REQUIREMENTS - A Certified Producer may be placed on Decertified Producer status when the test results from random samples vary below the applicable minimums of the standards and specifications listed in Section 3.0 by more than the following tolerances:

Unit Weight.....	1.0 percentage point
Yield.....	5.0 percent
Tensile.....	5.0 percent
Elongation.....	2.0 percentage points

8.2 CONTROL LIMITS

- (a) No more than 10% of the random test samples may fail the applicable specification minimums within the tolerances in Paragraph 8.1.
- (b) No more than one (1) random test sample may fail the physical property specification minimums by more than the tolerances in Paragraph 8.1 within a one-year period.
 - 1) In the event the physical property failure is on an epoxy coated or fabricated bar, the producer will be required to submit as-rolled bars to the BMPR on a bi-weekly basis for testing. Testing shall continue on as-rolled bars until the Engineer is satisfied the as-rolled bars meet specifications.

(c) No more than one (1) random test sample may fail the bend test, with allowance for retests where included in the Material Specification within a one-year period.

1) In the event the bend failure is on an epoxy coated or fabricated bar, the producer will be required to submit as-rolled bars to the BMPR on a bi-weekly basis for testing. Testing shall continue on as-rolled bars until the Engineer is satisfied the as-rolled bars meet specification.

2) If at any time two (2) or more certified epoxy coating plants fall into the category outlined in 8.2 (c) (1), the Producer shall be limited to supplying as-rolled bars to State of Illinois contracts.

8.3 Failure to meet requirements of Paragraphs 8.1 and 8.2 will place the Producer in a Decertified Producer status.

9.0 RECERTIFICATION PROCESS / CONDITIONS OF CERTIFIED PRODUCER STATUS

9.1 PROCEDURE - The same procedure (Sections 5.0 and 6.0) required to obtain Certified Producer status will be used to gain renewal of Certified Producer status.

9.1.1 TRIAL PERIOD OF ONE YEAR - Certified status for a new Producer determined under Sections 5.0 and 6.0 will be in effect for a 12-month period unless decertified under conditions of Sections 7.0 and 8.0. At that time, a second certification check to Sections 5.0 and 6.0 will be performed.

A Department representative shall accompany NTPEP on the initial one year audit/certification.

9.1.2 TWO-YEAR CERTIFICATION - A plant successfully meeting certification requirements for 2 consecutive annual checks will retain certified status for a 24-month period unless decertified under conditions of Sections 7.0 and 8.0. At that time, another check to Sections 5.0 and 6.0 will be made.

The two year audit/certification may be performed by NTPEP.

9.1.3 THREE-YEAR CERTIFICATION - A plant meeting three (3) consecutive (annual or biennial) certification checks will retain certified status for a 36-month period unless decertified under Sections 7.0 and 8.0. Thereafter, certified status will remain on a 3-year basis unless decertification occurs, and certification checks to Sections 5.0 and 6.0 will be made every 3 years.

A Department representative shall accompany NTPEP on the three year audit/certification.

9.1.4 DECERTIFICATION STATUS - Upon decertification, the plant will revert to a new plant status, and all variable certification periods and checks will apply. A plant decertified a second time under Sections 7.0 and 8.0 within

one year of the first decertification will be on non-certified status for a minimum of one year from the date of the second decertification. After one year, a Decertified Producer may request a retest for Certified Producer status provided the producer can demonstrate proof to the Engineer that the causes for the deficiencies have been remedied.

- 9.2 GAINING CERTIFICATION AFTER BEING ON NON-CERTIFIED OR DECERTIFIED PRODUCER STATUS - A Producer on the Non-Certified Producer or Decertified Producer status may gain Certified Producer status at the next annual renewal inspection provided he meets the testing procedures required for Certified Producer status. A Non-Certified Producer or a Decertified Producer may request a retest for Certified Producer status prior to the annual renewal inspection provided he can demonstrate proof to the Engineer that causes of the deficiencies have been remedied.

10.0 REPORTING

A copy of the shipping orders or invoice showing job identification, size, grade, heat, and total weight shall be provided to the Resident Engineer and the Region/District Materials Engineer. The Resident Engineer shall make positive identification between the bar identification marks, or i.d. tags, and the Certified Producer list. Materials from a Certified Producer will be accepted and entered into the MISTIC report system by the Region/District Materials Engineer.



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EEH

Appendix A: Sampling outline

Heat #1

Mill Samples		Sister Samples	
1	1 @ 30 Inches Long	1	2 @ 30 Inches Long
2	1 @ 30 Inches Long	2	2 @ 30 Inches Long
3	1 @ 30 Inches Long	3	2 @ 30 Inches Long
Bend Test			
1 - 3 Length determined by size			

Heat #2

Mill Samples		Sister Samples	
4	1 @ 30 Inches Long	4	2 @ 30 Inches Long
5	1 @ 30 Inches Long	5	2 @ 30 Inches Long
6	1 @ 30 Inches Long	6	2 @ 30 Inches Long
Bend Test			
4 - 6 Length determined by size			

Heat #3

Mill Samples		Sister Samples	
7	1 @ 30 Inches Long	7	2 @ 30 Inches Long
8	1 @ 30 Inches Long	8	2 @ 30 Inches Long
9	1 @ 30 Inches Long	9	2 @ 30 Inches Long
Bend Test			
7 - 9 Length determined by size			

Heat #4

Mill Samples		Sister Samples	
10	1 @ 30 Inches Long	10	2 @ 30 Inches Long
11	1 @ 30 Inches Long	11	2 @ 30 Inches Long
12	1 @ 30 Inches Long	12	2 @ 30 Inches Long
Bend Test			
10 - 12 Length determined by size			

Heat #5

Mill Samples		Sister Samples	
13	1 @ 30 Inches Long	13	2 @ 30 Inches Long
14	1 @ 30 Inches Long	14	2 @ 30 Inches Long
15	1 @ 30 Inches Long	15	2 @ 30 Inches Long
Bend Test			
13 - 14 Length determined by size			

Appendix A: Sampling outline continued

Heat #6

Mill Samples

16 1 @ 30 Inches Long

17 1 @ 30 Inches Long

18 1 @ 30 Inches Long

Sister Samples

16 2 @ 30 Inches Long

17 2 @ 30 Inches Long

18 2 @ 30 Inches Long

Bend Test

16 - 18 Length determined by size

Heat #7

Mill Samples

19 *2 @ 30 Inches Long

20 1 @ 30 Inches Long

21 1 @ 30 Inches Long

Sister Samples

19 2 @ 30 Inches Long

20 2 @ 30 Inches Long

21 2 @ 30 Inches Long

Bend Test

19 - 21 Length determined by size

Heat #8

Mill Samples

22 *2 @ 30 Inches Long

23 1 @ 30 Inches Long

24 1 @ 30 Inches Long

Sister Samples

22 2 @ 30 Inches Long

23 2 @ 30 Inches Long

24 2 @ 30 Inches Long

Bend Test

22 - 24 Length determined by size

Heat #9

Mill Samples

25 *2 @ 30 Inches Long

26 1 @ 30 Inches Long

27 1 @ 30 Inches Long

Sister Samples

25 2 @ 30 Inches Long

26 2 @ 30 Inches Long

27 2 @ 30 Inches Long

Bend Test

25 - 27 Length determined by size

Heat #10

Mill Samples

28 *2 @ 30 Inches Long

29 1 @ 30 Inches Long

30 1 @ 30 Inches Long

Sister Samples

28 2 @ 30 Inches Long

29 2 @ 30 Inches Long

30 2 @ 30 Inches Long

Bend Test

28 - 30 Length determined by size
