

QUALITY MANUAL for Steel Fabricator

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Abstract:

This document describes the Company's quality management system.

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Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

TABLE OF CONTENTS

1.0	<i>Purpose</i>	5
2.0	<i>Scope</i>	5
2.1	Exclusions	5
3.0	<i>References</i>	5
4.0	<i>Definitions</i>	5
5.0	<i>Management Responsibility</i>	5
5.1	Policy for Quality and Quality Goals	6
5.2	Periodic Management Review	7
5.3	Responsible Quality Personnel	8
5.4	Resource Management	8
5.4.1	Personnel	8
5.4.2	Buildings, Workspace, Equipment and Associated Utilities	8
5.4.3	Fabrication Process Equipment (Hardware & Software)	9
5.5	Quality Management System	9
5.6	Internal Communication	9
5.7	Quality Manual	9
5.7.1	Organization	10
5.7.2	Approval	10
5.7.3	Order of Precedence <small>Value-Added</small>	11
6.0	<i>Construction Document Review and Communication</i>	11
6.1	Customer Requirements	12
7.0	<i>Detailing</i>	12
7.1	Detailing Standards	12
7.1.1	Preparation of Shop Drawings (also see 7.8)	13
7.2	Checking of Shop Drawings	13
7.3	Approval of Approval Documents and Release for Fabrication	13
7.4	Shop Drawings Supplied by Others	13
7.5	Management of Detailing	13
7.6	Detailing Functions	14
7.6.1	References (required library)	14
7.6.2	Connection Consultation	14
7.7	Subcontract Services	14
7.8	Design Procedure	14
7.9	Design for Standard Services	15
7.10	Design for Non-standard Services	15
8.0	<i>Control of Management System Documents and Project Documents</i>	15
8.1	Management System Documents	15
8.1.1	Quality Management System Documents	15
8.1.2	Review and Approval of Quality Management System Documents	15
8.1.3	Revision Control of Quality Management System Documents	15



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Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

8.1.4	Access to Quality Management System Documents.....	16
8.1.5	Communication of Changes and Revisions to Quality Management System Documents.....	16
8.2	Project Documents.....	16
8.2.1	Tracking Project Documents.....	16
8.2.2	Revision Control of Project Documents.....	16
8.2.3	Access to Project Documents.....	17
9.0	<i>Maintenance of Quality Records.....</i>	17
9.1	Retention of Quality Records.....	17
9.2	Storage of Quality Records.....	17
9.3	Retrieval of Quality Records.....	17
10.0	<i>Purchasing.....</i>	17
10.1	Purchasing Data.....	18
10.2	Selection of Subcontractors and Suppliers.....	18
10.2.1	Fabrication Subcontractors.....	18
10.2.2	Detailing Subcontractors.....	18
10.3	Verification of Purchased Product, Materials and Services.....	18
10.3.1	Customer Verification of Fabricated Product.....	19
10.4	Control of Customer-Furnished Material.....	19
11.0	<i>Material Identification.....</i>	19
12.0	<i>Process Controls.....</i>	19
12.1	Welding.....	20
12.2	Bolt Installation.....	20
12.3	Material Preparation for Application of Coatings.....	21
12.4	Coating Application.....	21
12.5	Equipment Maintenance.....	21
12.6	Laydown/Assembly.....	21
13.0	<i>Inspection and Testing.....</i>	21
13.1	Assignment of QC Inspections and Monitoring.....	22
13.2	In-Process Inspection.....	22
13.3	Final Inspection.....	22
13.4	Inspection Records.....	23
14.0	<i>Calibration of Inspection, Measuring and Test Equipment.....</i>	23
15.0	<i>Control of Nonconformances.....</i>	23
15.1	Nonconformance with Management Systems.....	23
15.2	Nonconforming Product and Work.....	23
16.0	<i>Corrective Action.....</i>	24
17.0	<i>Handling, Storage and Delivery of Product and Materials.....</i>	24
18.0	<i>Training.....</i>	24
19.0	<i>Internal Audit.....</i>	25

Paragraphs 5.7.3 is "value added" content.



Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

1.0 Purpose

The purpose of the Quality Management System is to confirm to our Customers and the Construction Industry that [REDACTED]

2.0 Scope

The Company's quality management system applies to all employees within all functional areas of the Company's business operation. The Company's **AISC Certification** should not be understood as a product inspection of steel products. This Quality Management System includes all functions to provide steel products from receipt of contract through final delivery.

2.1 Exclusions

The Company cites no exclusions to the AISC standard. (revise as required)

3.0 References

The latest editions of the following documents and standards are required:

- a) **AISC Steel Construction Manual**, which includes the following specifications, codes and standards:
 - I. **AISC Specification for Structural Steel Buildings (AISC 360-10)**
 - II. **AISC Code of Standard Practice for Steel Buildings and Bridges (AISC 303-10)**
 - III. **RCSC Specification for Structural Joints Using ASTM A325 or A490 Bolts**
- b) **ANSI/AWS D1.1/D.1.1M Structural Welding Code - Steel**
- c) **ANSI/AWS D1.5 Bridge Welding Code**
- d) **AISC 503 Selected ASTM Standards for Structural Steel Fabrication**
- e) **ASTM/AASHTO Standards required for verification purposes**
- f) **AWS A2.4 Symbols**
- g) **AWS A3.0M/A3.0 Terms and Definitions**
- h) **SSPC - The Society for Protective Coatings**
 - I. **SSPC-PA 1 "Shop, Field and Maintenance Painting of Steel"**
 - II. **SSPC-PA 2 "Measurement of Dry Coating Thickness with Magnetic Gages"**
 - III. **SSPC-VIS 1 "Guide and Reference Photographs for Steel Surfaces prepared by Dry Abrasive Blast Cleaning"**

4.0 Definitions

See **QMS-16 Definitions and Abbreviations Procedure** for more details. Subordinate or external documentation is referenced in **Bold Italics**.

5.0 Management Responsibility

The Company is committed to [REDACTED]

Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

[Redacted]

5.1 Policy for Quality and Quality Goals

The Company's quality policy defines [Redacted]

CUSTOMER FOCUS: [Redacted]

EMPOWERMENT: [Redacted]

INTELLIGENT MANAGEMENT: [Redacted]

WORKPLACE EXCELLENCE: [Redacted]

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Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

COMPANY VISION

To continually improve our construction, services and processes to meet our Customers' requirements, allowing us to prosper as a business and to produce a reasonable return on capital investment.

QUALITY POLICY

[REDACTED]

ENVIRONMENTAL POLICY

[REDACTED]

PRACTICAL STEPS TO SUPPORT POLICIES

Customer Focus: [REDACTED]

Workplace Excellence: [REDACTED]

Empowerment: [REDACTED]

Intelligent Management: [REDACTED]

5.2 Periodic Management Review

Review meetings are held by all managers two times each year to [REDACTED]. [REDACTED]. The controls for management review are defined in the **QMS-04 Management Procedure**, which [REDACTED]. [REDACTED].

Management review meeting reports are posted to the network or intranet to communicate the performance of the quality system to employees. Internal quality audits are conducted according to the **QMS-12 Internal Auditing Procedure** to [REDACTED]. [REDACTED].

Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

5.3 Responsible Quality Personnel

The individual designated as Quality Manager (QM) understands all of the Company's quality procedures and has the authority to [REDACTED]

5.4 Resource Management

The Company has the resources necessary to [REDACTED]

5.4.1 Personnel

Personnel performing assigned functions have qualifications that [REDACTED]

[REDACTED] Qualified personnel are assigned to manage the following functions: (revise as required)

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

5.4.2 Buildings, Workspace, Equipment and Associated Utilities

The facility consists of areas and buildings that provide space for [REDACTED]

The fabrication facility includes [REDACTED]

Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

Equipment includes [REDACTED]

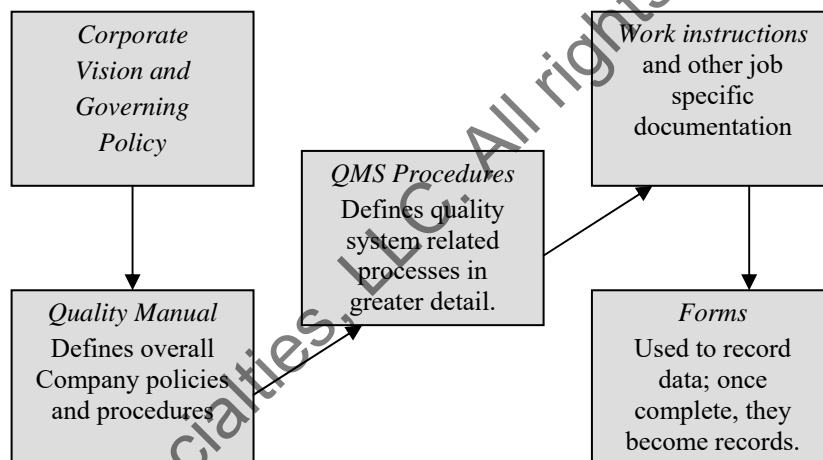
The facility also provides [REDACTED]

5.4.3 Fabrication Process Equipment (Hardware & Software)

The Company has under its control the equipment [REDACTED]

5.5 Quality Management System

The Company maintains all required documentation to [REDACTED]. The quality system documentation is comprised of a hierarchy of documents that flow from this Quality Manual.



5.6 Internal Communication

To ensure proper communication between and throughout all levels of employees within the Company, [REDACTED]

Management periodically communicates with [REDACTED]

Employees are encouraged [REDACTED]

5.7 Quality Manual

The primary purpose of the Quality Manual and QMS Procedures [REDACTED]

Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

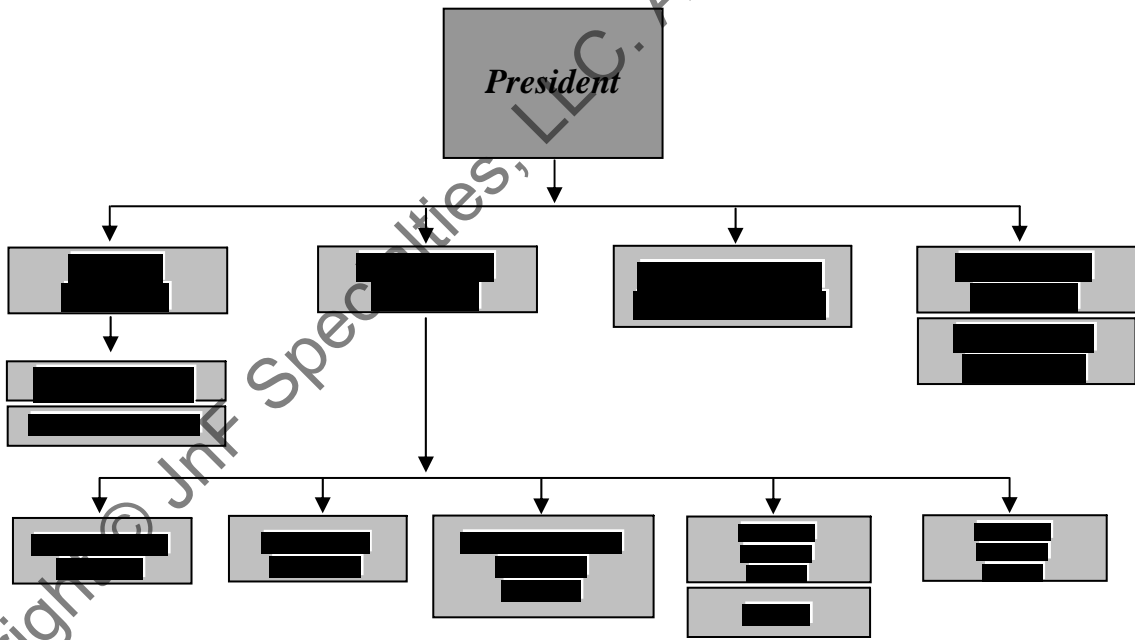


5.7.1 Organization

The organizational chart below defines the basic management structure of the Company. In all cases, [redacted] which are further defined in the *QMS-05 Responsibilities and Authorities Procedure*.

The qualifications of key personnel and managers listed in paragraph 5.4.1 are [redacted]

- [redacted]
- [redacted]



5.7.2 Approval

This manual is issued under the authority of [redacted]
 [redacted] Management ensures the QMS



Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

[REDACTED]

5.7.3 Order of Precedence Value-Added

The order of precedence of order-specific documentation is as follows unless otherwise directed by Customer or government requirements:

1. [REDACTED]
2. [REDACTED]
3. [REDACTED]
4. [REDACTED]
5. [REDACTED]

6.0 Construction Document Review and Communication

The Company performs contract and project specification review according to the **QMS-07 Proposal Development and Contract Review Procedure**. The review [REDACTED]

[REDACTED]

The Company communicates [REDACTED] which includes:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

Decisions made in the process of these communications [REDACTED]

Contract review records may include [REDACTED]

Project requirements are distributed to responsible authorities in the Company. [REDACTED]

The controls for contract review are defined in the **QMS-07 Proposal Development and Contract Review Procedure**.

[REDACTED]

Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

Communications with the Authorities having Jurisdiction (AHJ) [REDACTED]

A number is assigned [REDACTED] the following:

- a) [REDACTED]
- b) [REDACTED]
- c) [REDACTED]
- d) [REDACTED]
- e) [REDACTED]

6.1 Customer Requirements

The Company captures all contractual [REDACTED] as part of the **Proposal Development & Contract Review** process. Once contractual [REDACTED]

[REDACTED] The Company

determines their capability to meet Customer requirements [REDACTED] which is defined in the **QMS-07 Proposal Development & Contract Review Procedure**.

7.0 Detailing

7.1 Detailing Standards

The Company utilizes detailing standards [REDACTED]

The standards describe [REDACTED]

The standards describe [REDACTED]



Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

[REDACTED]

The standards include [REDACTED]

7.1.1 Preparation of Shop Drawings (also see 7.8)

The Company has prepared and implemented a documented procedure for preparation of shop detail and project specific drawings and material ordering specifications to [REDACTED]

[REDACTED]

Detailing procedures are defined in the *QMS-17 Detailing Procedure*.

7.2 Checking of Shop Drawings

The Company has prepared and implemented a procedure to provide for checking of all shop drawings to [REDACTED]

[REDACTED] Detailing procedures are defined in the *QMS-17 Detailing Procedure*.

7.3 Approval of Approval Documents and Release for Fabrication

The *QMS-21 Approval of Approval Documents Procedure* describes [REDACTED] The methods include [REDACTED]

[REDACTED]

7.4 Shop Drawings Supplied by Others

Shop drawings received from the Owner/Buyer are [REDACTED]

7.5 Management of Detailing

Detailing Management Connection Consultation and other detailing functions may [REDACTED]

Personnel performing Detailing Management are responsible for [REDACTED]



Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

[Redacted]

- [Redacted]
- [Redacted]

7.6 Detailing Functions

Personnel that detail and/or check shop drawings have [Redacted]

[Redacted]

7.6.1 References (required library)

[Redacted] Detailing procedures are defined in the **QMS-17 Detailing Procedure**.

7.6.2 Connection Consultation

Personnel directing Detailers performing connection detailing are qualified by one or more of the following:

- [Redacted]
- [Redacted]
- [Redacted]

7.7 Subcontract Services

In lieu of employed staff personnel, subcontract services [Redacted]

[Redacted]

The Company defines and documents the qualification and selection process for choosing subcontract detailers according to **QMS-08 Purchasing Procedure**.

7.8 Design Procedure

The Company's design and development process ensures [Redacted] which includes policies for:

- A. [Redacted]

Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

- B. [REDACTED]
- C. [REDACTED]
- D. [REDACTED]

7.9 Design for Standard Services

The controls for standard services are [REDACTED]

7.10 Design for Non-standard Services

The controls for non-standard services are [REDACTED]

8.0 Control of Management System Documents and Project Documents

8.1 Management System Documents

[REDACTED] The controls are defined in the *QMS-01 Control of Documented Information Procedure* and *QMS-02 Configuration Management Procedure*.

8.1.1 Quality Management System Documents

The Quality System ensures [REDACTED]

[REDACTED]

The System is structured from top-down using this Quality Manual, Safety Manual, Supporting Documents, Work Instructions and Quality Records (also see 5.5).

8.1.2 Review and Approval of Quality Management System Documents

Internal documents that affect quality are [REDACTED]

[REDACTED]

Revision controls are defined in the *QMS-02 Configuration Management Procedure*.

8.1.3 Revision Control of Quality Management System Documents

Controlled management system documents [REDACTED]

[REDACTED]



Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

[Redacted]

Documents are controlled so that the information on them [Redacted]

The controls for document control and configuration management are defined in the **QMS-01 Control of Documented Information Procedure** and **QMS-02 Configuration Management Procedure**.

8.1.4 Access to Quality Management System Documents

Relevant and current [Redacted] controls are defined in the **QMS-10 Steel Fabrication Procedure**.

8.1.5 Communication of Changes and Revisions to Quality Management System Documents

Changes and revisions to quality management system documents are [Redacted] according to the **QMS-02 Configuration Management Procedure** and applicable **Change Order(s)**.

8.2 Project Documents

A method has been established [Redacted] The controls are defined in the **QMS-01 Control of Documented Information Procedure** and **QMS-02 Configuration Management Procedure**.

8.2.1 Tracking Project Documents

A **Transmittal Register** and **Contract Log** have been established [Redacted]

8.2.2 Revision Control of Project Documents

Controlled project documents [Redacted]



Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

[REDACTED]

The controls for document control and configuration management are defined in the **QMS-01 Control of Documented Information Procedure** and **QMS-02 Configuration Management Procedure**.

8.2.3 Access to Project Documents

Relevant and current procedures and policies [REDACTED]

The controls are defined in the **QMS-10 Steel Fabrication Procedure**.

9.0 Maintenance of Quality Records

Records are retained and maintained [REDACTED]

All quality records are [REDACTED]

9.1 Retention of Quality Records

The control of records is defined in the **QMS-01 Control of Documented Information Procedure**.

9.2 Storage of Quality Records

Records are controlled [REDACTED] according to the **QMS-01 Control of Documented Information Procedure**.

9.3 Retrieval of Quality Records

Proprietary records are [REDACTED] non-proprietary records are [REDACTED]

10.0 Purchasing

Purchasing is treated as a process within the Company's quality system according to **QMS-08 Purchasing Procedure**. The Company accepts [REDACTED]



Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

10.1 Purchasing Data

Purchase documents clearly define [REDACTED]

[REDACTED] documents contain the following information:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

The purchasing process is fully defined in the *QMS-08 Purchasing Procedure*.

10.2 Selection of Subcontractors and Suppliers

The purchasing process ensures the Company [REDACTED]

[REDACTED] The supplier evaluation process is fully defined in the *QMS-08 Purchasing Procedure*.

10.2.1 Fabrication Subcontractors

When required by contract, the Company uses Fabricator Subcontractors that are AISC certified [REDACTED]

10.2.2 Detailing Subcontractors

The Company performs [REDACTED] according to the *QMS-08 Purchasing Procedure*.

10.3 Verification of Purchased Product, Materials and Services

The responsibility for quality of subcontracted products remains with the Company. [REDACTED]

[REDACTED] The methods used for verification of purchased items are defined in the *QMS-09 Receiving Procedure for Steel Fabricator*.

Materials received [REDACTED]

Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

[Redacted]

Deliveries are checked [Redacted]

[Redacted]

The methods for performing receiving inspections are defined in the **QMS-09 Receiving Procedure for Steel Fabricator**.

10.3.1 Customer Verification of Fabricated Product

If specified in the Customer's purchase contract, the Customer [Redacted]

[Redacted]

The methods used for the control of Customer verification are defined in the **QMS-08 Purchasing Procedure**.

10.4 Control of Customer-Furnished Material

A negotiated agreement [Redacted]

[Redacted]

The methods for the control of supplied materials are defined in the **QMS-10 Steel Fabrication Procedure**.

11.0 Material Identification

A documented procedure has been established and maintained for identifying deliverable items by suitable means. [Redacted]

[Redacted]

The methods for the control of supplied materials and identification of deliverable items are defined in the **QMS-10 Steel Fabrication Procedure**.

12.0 Process Controls

[Redacted]



Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

[Redacted]

Procedures and records are maintained that demonstrate care and control of [Redacted]

[Redacted]

Effective implementation of the following documented procedures is required as a minimum:

- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]

The methods for the control of the fabrication process are defined in the **QMS-10 Steel Fabrication Procedure**.

12.1 Welding

The Company's welding procedures address [Redacted] and include:

- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]

12.2 Bolt Installation

The Company's bolting procedure is [Redacted] and includes:

- [Redacted]



Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

- [REDACTED]
- [REDACTED]
- [REDACTED]

12.3 Material Preparation for Application of Coatings

The Company's prepares material for coating application [REDACTED]

12.4 Coating Application

The Company applies and cures coatings [REDACTED]

12.5 Equipment Maintenance

A documented preventive maintenance program is implemented [REDACTED]

It is acceptable to operate equipment [REDACTED]

12.6 Laydown/Assembly

The Company's documented procedure for shop assembly of field connections includes the following:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

13.0 Inspection and Testing

To ensure conformance to requirements of deliverable items, monitoring and measurement [REDACTED]

The methods for the control of the inspection and testing process are defined in the **QMS-10 Steel Fabrication Procedure**. Nonconforming items are controlled according to the **QMS-14 Control of Nonconformances Procedure**.

Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

13.1 Assignment of QC Inspections and Monitoring

QC inspectors are [REDACTED]
[REDACTED] under the following conditions:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

13.2 In-Process Inspection

The Company retains and maintains in-process inspection [REDACTED]
[REDACTED]

In-process inspections are [REDACTED]
[REDACTED]

In-process inspections are [REDACTED]

The following inspections are described in the **QMS-10 Steel Fabrication Procedure**: (revise as required, here and in QMS-10)

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

13.3 Final Inspection

Qualified inspectors perform final inspection [REDACTED]
[REDACTED]



Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

13.4 Inspection Records

Inspection records provide [REDACTED] according to the **QMS-01 Control of Documented Information Procedure.**

14.0 Calibration of Inspection, Measuring and Test Equipment

All measuring and test equipment instruments and devices used to determine an item's conformance to specified requirements [REDACTED]. The controls for such equipment and calibration activities are defined in the **QMS-15 Calibration Procedure.**

15.0 Control of Nonconformances

Nonconformances are identified [REDACTED]. Nonconformances are controlled according to the **QMS-14 Control of Nonconformances Procedure.**

15.1 Nonconformance with Management Systems

The Company conducts internal audits [REDACTED] according to the **QMS-12 Internal Auditing Procedure.**

15.2 Nonconforming Product and Work

When a nonconformance occurs, [REDACTED] according to the **QMS-13 Corrective Action Procedure** and **QMS-14 Control of Nonconformances Procedure.**

[REDACTED]

[REDACTED]

Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

16.0 Corrective Action

The Company has implemented and maintains [REDACTED]

Such reports result in [REDACTED]

The Company determines [REDACTED]

defined in the **QMS-**

13 Corrective Action Procedure.

17.0 Handling, Storage and Delivery of Product and Materials

According to contractual directives, instructions are detailed in the applicable job documentation [REDACTED]

General rules are

defined in the **QMS-10 Steel Fabrication Procedure.**

The handling and shipping process is defined in the **QMS-11 Shipping Procedure.**

18.0 Training

All Company personnel are hired [REDACTED]

The Company has implemented a training program that:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

Your Logo	Your Company Name	QMS-00 Quality Manual for Steel Fabricator
AISC:		Rev: Orig

[REDACTED] The training program is defined in the **QMS-06 Training Procedure**.

19.0 Internal Audit

Internal quality audits [REDACTED]
 [REDACTED] The internal audit process is defined in the **QMS-12 Internal Auditing Procedure**.

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QUALITY MANUAL for STRUCTURAL STEEL ERECTOR

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Document Identifier: QMS-00 Quality Manual for Structural Steel Erector

Date: Latest Revision Date

Signature:

Project: Customer, Unique ID, Part Number

Document Status: Draft, Redline, Released, Obsolete

Company Location: (your address, city, state, zip)

Abstract:

This document describes the Company's quality management system.

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Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

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Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

TABLE OF CONTENTS

1.0	Scope.....	5
2.0	Exclusions.....	5
3.0	References.....	5
3.1	Seismic Erection.....	6
3.2	Metal Deck Installation.....	6
3.3	Bridge Erection.....	6
3.4	Safety.....	6
4.0	Definitions.....	6
5.0	Management Responsibility.....	6
5.1	Policy for Quality and Quality Goals.....	6
5.2	Periodic Management Review.....	8
5.3	Responsible Quality Personnel.....	8
5.4	Resource Management.....	9
5.4.1	Personnel.....	9
5.4.2	Buildings, Workspace, Equipment and Associated Utilities.....	9
5.4.3	Erection Tools and Equipment.....	9
5.5	Quality Management System.....	9
5.6	Internal Communication.....	10
5.7	Quality Manual.....	10
5.7.1	Organization.....	11
5.7.2	Approval.....	11
5.7.3	Order of Precedence <small>Value-Added</small>	12
5.8	Safety Manual.....	12
5.9	Policy for Safety.....	12
5.10	Responsible Safety Personnel.....	13
6.0	Construction Document Review and Communication.....	13
6.1	Customer Requirements.....	14
7.0	Reserved.....	14
8.0	Control of Management System Documents and Project Documents.....	14
8.1.1	Quality Management System Documents.....	14
8.1.2	Review and Approval of Quality Management System Documents.....	14
8.1.3	Revision Control of Quality Management System Documents.....	15
8.1.4	Access to Quality Management System Documents.....	15
8.1.5	Communication of Changes and Revisions to Quality Management System Documents.....	15
8.2	Project Documents.....	15
8.2.1	Tracking Project Documents.....	15
8.2.2	Revision Control of Project Documents.....	16
8.2.3	Access to Project Documents.....	16
9.0	Maintenance of Quality Records.....	16
9.1	Retention of Quality Records.....	16



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<h1>Your Logo</h1>	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

9.2	Storage of Quality Records	16
9.3	Retrieval of Quality Records.....	17
10.0	<i>Purchasing</i>	17
10.1	Purchasing Data	17
10.2	Selection and Evaluation of Subcontractors	17
10.2.1	Fabrication/Erection Subcontractors.....	17
10.3	Verification of Purchased Product, Materials and Services	17
10.4	Customer Verification of Product.....	18
10.5	Control of Supplied Material	18
11.0	<i>Material Identification</i>	18
12.0	<i>Erection Process Control</i>	18
12.1	Welding	19
12.2	Bolt Installation	19
12.3	Material Preparation for Application of Coatings	19
12.4	Equipment Maintenance	19
13.0	<i>Inspection and Testing</i>	19
13.1	Assignment of QC Inspections and Monitoring.....	20
13.2	Inspection Procedures	20
13.2.1	Material Receipt Inspection.....	20
13.2.2	In-Process Inspection	20
13.2.3	Final Inspection.....	20
14.0	<i>Calibration of Inspection, Measuring and Test Equipment</i>	21
15.0	<i>Control of Nonconformances</i>	21
15.1	Nonconforming Quality Management System.....	21
15.2	Nonconforming Work	21
16.0	<i>Corrective Action</i>	21
17.0	<i>Handling, Storage and Delivery of Product and Materials</i>	22
18.0	<i>Training</i>	22
19.0	<i>Internal Audit</i>	23
20.0	<i>Erection Plan</i>	23
21.0	<i>Safety Plan</i>	24
22.0	<i>Other Project-Specific Requirements</i>	25
23.0	<i>Safety Management System</i>	25
23.1	Documentation Requirements	25
23.2	Safety Training	25

Paragraph 5.7.3 is "value added" content.

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<h1>Your Logo</h1>	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

1.0 Scope

The Company's quality management system applies to all employees within all functional areas of the Company's business operation. The Company's **AISC Certification** should not be understood as a product inspection of Structural Steel. This Quality Management System includes all functions to provide Structural Steel Erection from receipt of contract through final delivery.

The purpose of the Quality Management System is to confirm to our Customers and the Construction Industry that [REDACTED]

2.0 Exclusions

The Company cites no exclusions to the AISC standard. (revise as required)

3.0 References

The latest editions of the following documents and standards are required: (revise as required)

- **AISC Detailing for Steel Construction**
- **AISC 503 Selected ASTM Standards for Structural Steel Fabrication**
- **AISC Steel Construction Manual**, which includes the following specifications, codes and standards:
 - **AISC 303 Code of Standard Practice for Steel Buildings and Bridges**
 - **AISC 360-10 Specification for Structural Steel Buildings**
 - **RCSC Specification for Structural Joints Using High Strength Bolts**
- **ANSI/ASSE A10.13 Safety Requirements for Steel Erection**
- **ANSI/SDI QA/QC Standard for Quality Control and Quality Assurance for Installation of Steel Deck**
- **AWS D1.1/D1.1M Structural Welding Code - Steel**
- **AWS D1.3 Structural Welding Code - Sheet Steel**
- **AWS D1.5 Structural Welding Code - Bridge Welding Code**
- **AWS A2.4 Symbols**
- **AWS A3.0M/A3.0 Terms and Definitions**
- **OSHA Part 1926 Safety and Health Regulations for Construction**
- **SSPC - The Society for Protective Coatings**
 - **SSPC-PA 1 Shop, Field and Maintenance Painting of Steel**
 - **SSPC-PA 2 Measurement of Dry Coating Thickness with Magnetic Gages**
 - **SSPC-VIS 1 Guide and Reference Photographs for Steel Surfaces prepared by Dry Abrasive Blast Cleaning**

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Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

3.1 Seismic Erection

For the erection of structures requiring the use of **ANSI/AISC 341 Seismic Provisions for Structural Steel Buildings**, the Company [REDACTED] meet the requirements of:

- [REDACTED]
- [REDACTED]

3.2 Metal Deck Installation

When work includes the installation of metal deck, the Company has available and demonstrates the ability [REDACTED]

- (a) [REDACTED]

3.3 Bridge Erection

For the erection of bridges, the Company [REDACTED] meet the requirements of:

- [REDACTED]
- [REDACTED]

3.4 Safety

Employees and others that perform work for the Company are [REDACTED] which also includes [REDACTED]

4.0 Definitions

See **QMS-16 Definitions and Abbreviations Procedure** for more details. Subordinate or external documentation is referenced in ***Bold Italics***.

5.0 Management Responsibility

The Company is committed to safety, continuous improvement and [REDACTED]

5.1 Policy for Quality and Quality Goals

The Company's quality policy defines [REDACTED]

Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

CUSTOMER FOCUS: [REDACTED]

EMPOWERMENT: [REDACTED]

INTELLIGENT MANAGEMENT: [REDACTED]

WORKPLACE EXCELLENCE: [REDACTED]

COMPANY VISION
 To continually improve our construction, services and processes to meet our Customers' requirements, allowing us to prosper as a business and to produce a reasonable return on capital investment.

QUALITY POLICY
 [REDACTED]

ENVIRONMENTAL POLICY
 [REDACTED]

PRACTICAL STEPS TO SUPPORT POLICIES

Customer Focus: [REDACTED]

Workplace Excellence: [REDACTED]

Empowerment: [REDACTED]

Intelligent Management: [REDACTED]



Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

5.2 Periodic Management Review

Review meetings are held by all managers two times each year to [REDACTED]

[REDACTED] The controls for management review are defined in the **QMS-04 Management Procedure**, which [REDACTED]

Management review meeting reports are posted to the network or intranet to communicate the performance of the quality and safety systems to employees. Internal quality audits are conducted according to the **QMS-12 Internal Auditing Procedure** to [REDACTED]

Responsible Authorities also perform an annual review of the safety management system, which includes:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

5.3 Responsible Quality Personnel

The individuals designated as Quality (QM) and/or Safety Manager (SM) understand all of the Company's quality and safety procedures and have the authority to [REDACTED]

[REDACTED]



Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

5.4 Resource Management

The Company has the resources necessary to [REDACTED]

5.4.1 Personnel

Personnel performing assigned functions have qualifications that [REDACTED]

[REDACTED] Qualified personnel are assigned to manage the following functions: (revise as required)

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

5.4.2 Buildings, Workspace, Equipment and Associated Utilities

The facility consists of areas and buildings that provide space to [REDACTED]

Adequate space is provided for [REDACTED]

Ambient conditions are [REDACTED]

5.4.3 Erection Tools and Equipment

The Company has under its control the equipment [REDACTED]

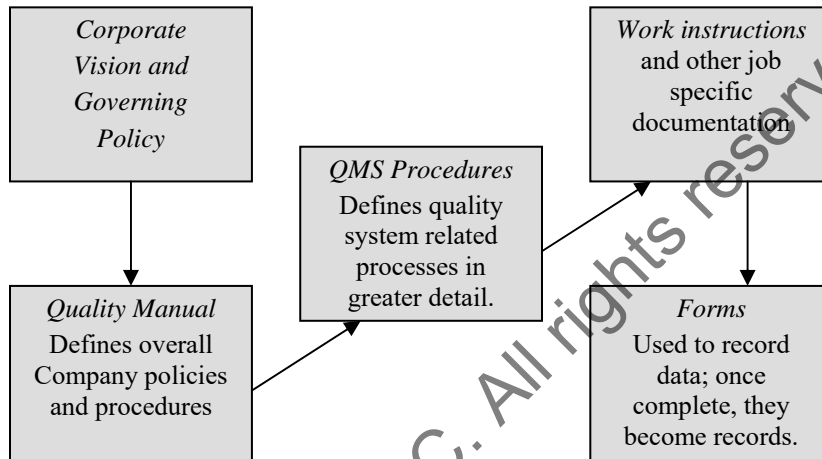
5.5 Quality Management System

The Quality System ensures that necessary procedures and instructions [REDACTED]

<h1>Your Logo</h1>	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

[REDACTED]

The Company maintains all required documentation [REDACTED]. The quality system documentation is comprised of a hierarchy of documents that flow from this Quality Manual.



5.6 Internal Communication

To ensure proper communication between and throughout all levels of employees within the Company, [REDACTED]

Management periodically communicates with [REDACTED]

Employees are encouraged [REDACTED]

5.7 Quality Manual

The primary purpose of the Quality Manual and QMS Procedures [REDACTED]

<h1>Your Logo</h1>	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

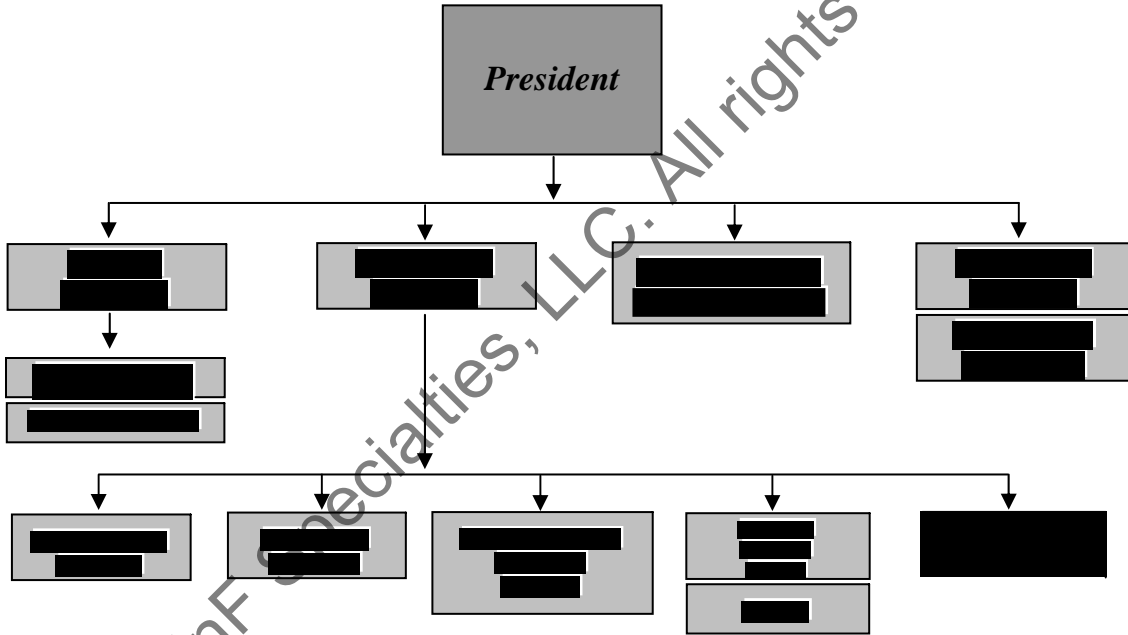
5.7.1 Organization

Review meetings are held by all managers [REDACTED]. The controls for management review are defined in the **QMS-04 Management Procedure**.

The organizational chart below defines the basic management structure of the Company. In all cases, [REDACTED] which are further defined in the **QMS-05 Responsibilities and Authorities Procedure**.

The qualifications of key personnel and managers listed in paragraph 5.4.1 are [REDACTED].

- [REDACTED]
- [REDACTED]



5.7.2 Approval

This manual is issued under the authority of [REDACTED]. Management ensures the QMS [REDACTED].

Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

5.7.3 Order of Precedence Value-Added

The order of precedence of order-specific documentation is as follows unless otherwise directed by Customer or government requirements:

1. [Redacted]
2. [Redacted]
3. [Redacted]
4. [Redacted]
5. [Redacted]

5.8 Safety Manual

The Company ensures Employees [Redacted]

The highest ranking member of executive management [Redacted] which contains the following information:

- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]

5.9 Policy for Safety

Executive management is responsible for [Redacted]
[Redacted] The policy for safety includes:

- [Redacted]
- [Redacted]
- [Redacted]

Executive management [Redacted]
[Redacted]



Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

5.10 Responsible Safety Personnel

Executive management designates [REDACTED]

The designated management representative(s) has the ability, responsibility and authority to:

- [REDACTED]
- [REDACTED]
- [REDACTED]

6.0 Construction Document Review and Communication

The Company performs contract and project specification review according to the **QMS-07 Proposal Development and Contract Review Procedure**. The review [REDACTED]

[REDACTED]

The Company communicates [REDACTED] which includes:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

Decisions made in the process of these communications [REDACTED]

Contract review records may include [REDACTED]

Project requirements are distributed to responsible authorities in the Company. [REDACTED]

The controls for contract review are defined in the **QMS-07 Proposal Development and Contract Review Procedure**.



Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

Communications with Authorities Having Jurisdiction (AHJ) [REDACTED]

A number is assigned [REDACTED] the following:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

6.1 Customer Requirements

The Company captures all contractual [REDACTED] as part of the **Proposal Development & Contract Review** process. Once contractual [REDACTED]

[REDACTED] The Company determines their capability to meet Customer requirements [REDACTED] which is defined in the **QMS-07 Proposal Development & Contract Review Procedure**.

8.0 Control of Management System Documents and Project Documents

8.1.1 Quality Management System Documents

The Quality System ensures [REDACTED] The System is structured from top-down using this Quality Manual, Safety Manual, Supporting Documents, Work Instructions and Quality Records (also see 5.5).

8.1.2 Review and Approval of Quality Management System Documents

Internal documents that affect quality [REDACTED]

Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

[REDACTED]

Revision controls are defined in the **QMS-02 Configuration Management Procedure**.

8.1.3 Revision Control of Quality Management System Documents

Controlled management system documents [REDACTED]

[REDACTED]

Documents are controlled so that the information on them [REDACTED]

[REDACTED]

The controls for document control and configuration management are defined in the **QMS-01 Control of Documented Information Procedure** and **QMS-02 Configuration Management Procedure**.

8.1.4 Access to Quality Management System Documents

Relevant and current [REDACTED]

[REDACTED] controls are defined in the **QMS-10 Structural Steel Erection Procedure**.

8.1.5 Communication of Changes and Revisions to Quality Management System Documents

Changes and revisions to applicable Company policies, [REDACTED]

[REDACTED] according to the **QMS-02 Configuration Management Procedure** and applicable **Change Order(s)**.

8.2 Project Documents

A method has been established [REDACTED]

[REDACTED] The controls are defined in the **QMS-01 Control of Documented Information Procedure** and **QMS-02 Configuration Management Procedure**.

8.2.1 Tracking Project Documents

A **Transmittal Register** and **Contract Log** have been established [REDACTED]

[REDACTED]

[REDACTED]

Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

8.2.2 Revision Control of Project Documents

Controlled project documents [REDACTED]

The controls for document control and configuration management are defined in the **QMS-01 Control of Documented Information Procedure** and the **QMS-02 Configuration Management Procedure**.

8.2.3 Access to Project Documents

Relevant and current procedures and policies [REDACTED]

The controls are defined in the **QMS-10 Structural Steel Erection Procedure**.

9.0 Maintenance of Quality Records

Records are retained and maintained [REDACTED]

All quality records are [REDACTED]

9.1 Retention of Quality Records

The control of records is defined in the **QMS-01 Control of Documented Information Procedure**.

9.2 Storage of Quality Records

Records are controlled [REDACTED]

[REDACTED] according to the **QMS-01 Control of Documented Information Procedure**.

Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

9.3 Retrieval of Quality Records

Proprietary records are [REDACTED]
 [REDACTED] non-proprietary records are [REDACTED]

10.0 Purchasing

Purchasing is treated as a process within the Company's quality system. The Company accepts [REDACTED]

10.1 Purchasing Data

Purchase documents clearly define [REDACTED]

Purchasing documents contain the following information:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

The purchasing process is fully defined in the **QMS-08 Purchasing Procedure**.

10.2 Selection and Evaluation of Subcontractors

The purchasing process ensures the Company [REDACTED]
 [REDACTED] The supplier evaluation process is fully defined in the
QMS-08 Purchasing Procedure.

10.2.1 Fabrication/Erection Subcontractors

When required by contract, the Company uses Fabricator/Erector Subcontractors that are AISC certified [REDACTED]

10.3 Verification of Purchased Product, Materials and Services

The responsibility for quality of subcontracted products remains with the Company. [REDACTED]

Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

[REDACTED]

The methods used for verification of purchased items are defined in the **QMS-09 Receiving Procedure for Structural Steel Erector**.

10.4 Customer Verification of Product

If specified in the Customer's purchase contract, the Customer [REDACTED]

[REDACTED] The methods used for the control of Customer verification are defined in the **QMS-08 Purchasing Procedure**.

10.5 Control of Supplied Material

A negotiated agreement [REDACTED]

[REDACTED] The methods for the control of supplied materials are defined in the **QMS-10 Structural Steel Erection Procedure**.

11.0 Material Identification

A documented procedure has been established and maintained for identifying deliverable items by suitable means [REDACTED]

[REDACTED] The methods for the control of supplied materials and identification of deliverable items are defined in the **QMS-10 Structural Steel Erection Procedure**.

12.0 Erection Process Control

[REDACTED]

Procedures and records are maintained that demonstrate care and control of [REDACTED]

[REDACTED]

Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

Effective implementation of the following documented procedures is required as a minimum:
 (revise as required)

- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]

The methods for the control of the erection process are defined in the **QMS-10 Structural Steel Erection Procedure**.

12.1 Welding

The Company's welding procedures include [Redacted]

12.2 Bolt Installation

The Company's bolting procedure includes [Redacted]

12.3 Material Preparation for Application of Coatings

The Company's prepares material for coating application [Redacted]

12.4 Equipment Maintenance

A documented preventive maintenance program is implemented [Redacted]

[Redacted]

It is acceptable to operate equipment [Redacted]

13.0 Inspection and Testing

To ensure conformance to requirements of the applicable erection project, monitoring and measurement [Redacted]

[Redacted]

The methods for the control of the inspection and testing [Redacted]

Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

process are defined in the **QMS-10 Structural Steel Erection Procedure**. Nonconforming items are controlled according to the **QMS-14 Control of Nonconformances Procedure**.

13.1 Assignment of QC Inspections and Monitoring

QC inspectors are [REDACTED] Construction personnel are assigned to inspection duties under the following conditions:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

13.2 Inspection Procedures

13.2.1 Material Receipt Inspection

Materials received [REDACTED]

Deliveries are checked [REDACTED]

The methods for performing receiving inspections are defined in the **QMS-09 Receiving Procedure for Structural Steel Erector**.

13.2.2 In-Process Inspection

In-process inspections are conducted [REDACTED]

13.2.3 Final Inspection

The Company examines completed work [REDACTED]



Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

14.0 Calibration of Inspection, Measuring and Test Equipment

All measuring and test equipment instruments and devices used to determine an item's conformance to specified requirements [REDACTED]. The controls for such equipment and calibration activities are defined in the **QMS-15 Calibration Procedure**.

15.0 Control of Nonconformances

Nonconformances are identified [REDACTED]. Nonconformances are controlled according to the **QMS-14 Control of Nonconformances Procedure**.

15.1 Nonconforming Quality Management System

The Company conducts internal audits [REDACTED] according to the **QMS-12 Internal Auditing Procedure**.

15.2 Nonconforming Work

When a nonconformance occurs, [REDACTED] according to the **QMS-13 Corrective Action Procedure** and **QMS-14 Control of Nonconformances Procedure**.

The Company retains and maintains records [REDACTED] according to the **QMS-01 Control of Documented Information Procedure**.

16.0 Corrective Action

The Company has implemented and maintains [REDACTED]. Such reports result in [REDACTED].

Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

Corrective actions are [REDACTED]

Corrective action is applied when:

- [REDACTED]
- [REDACTED]

The Company determines if additional nonconformances exist [REDACTED]

The corrective action process is defined in the **QMS-13 Corrective Action Procedure**.

17.0 Handling, Storage and Delivery of Product and Materials

According to contractual directives, instructions are detailed in the applicable job documentation [REDACTED]. General rules are defined in the **QMS-10 Structural Steel Erection Procedure**.

The handling and shipping process is defined in the **QMS-11 Shipping Procedure**.

18.0 Training

All Company personnel are hired [REDACTED]

The Company has implemented a training program that:

- [REDACTED]
- [REDACTED]
- Includes: [REDACTED]

Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]

[Redacted] The training program is defined in the **QMS-06 Training Program**.

19.0 Internal Audit

Internal quality audits [Redacted] The internal audit process is defined in the **QMS-12 Internal Auditing Procedure**.

20.0 Erection Plan

The Company prepares an erection plan for every project. The erection plan, [Redacted] includes the following information as appropriate for the project:

- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]



Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]

The erection plan is [Redacted]

[Redacted]

[Redacted]

21.0 Safety Plan

The Company prepares a safety plan for every project.

The safety plan [Redacted]

[Redacted]

A safety plan considers [Redacted]

[Redacted]

The safety plan includes the following information as appropriate for the project:

- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]
- [Redacted]



Your Logo	Your Company Name	QMS-00 Quality Manual for Structural Steel Erector
AISC:		Rev: Orig

- [REDACTED]

The safety plan [REDACTED]

[REDACTED]

[REDACTED]

22.0 Other Project-Specific Requirements

Prior to the start of the erection project, the Company [REDACTED]

[REDACTED]

According to the *AISC Code of Standard Practice* and contract documents, the Company [REDACTED]

[REDACTED]

23.0 Safety Management System

23.1 Documentation Requirements

The *QMS-03 Safety Program* contains the following information:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

23.2 Safety Training

Safety training includes [REDACTED]

[REDACTED]

Safety training includes [REDACTED]

The safety plan [REDACTED]

The Company provides training according to the following *OSHA Subparts*: (revise as required)

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]



