QUALITY MANUAL
for Steel Fabricator

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Abstract:
This document describes the Company's quality management system.

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Paragraphs 5.7.3 is "value added" content.
1.0 Purpose
The purpose of the Quality Management System is to confirm to our Customers and the
Construction Industry that

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
5.1 Policy for Quality and Quality Goals

The Company's quality policy defines

CUSTOMER FOCUS:

EMPOWERMENT:

INTELLIGENT MANAGEMENT:

WORKPLACE EXCELLENCE:

Left blank intentionally
5.2 Periodic Management Review

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

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...
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...

5.4 **Resource Management**

The Company has the resources necessary to...

5.4.1 **Personnel**

Personnel performing assigned functions have qualifications that...

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

- 
- 
- 
- 
- 
- 
- 

5.4.2 **Buildings, Workspace, Equipment and Associated Utilities**

The facility consists of areas and buildings that provide space for...

The fabrication facility includes...
Equipment includes...
The facility also provides...

5.4.3 Fabrication Process Equipment (Hardware & Software)
The Company has under its control the equipment...

5.5 Quality Management System
The Company maintains all required documentation to...
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...
Management periodically communicates with...
Employees are encouraged...

5.7 Quality Manual
The primary purpose of the Quality Manual and QMS Procedures...
5.7.1 Organization
The organizational chart below defines the basic management structure of the Company. In all cases, 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:

- [List of qualifications]

5.7.2 Approval
This manual is issued under the authority of [Name]. Management ensures the QMS.
5.7.3 Order of Precedence

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

1.
2.
3.
4.
5.

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

The Company communicates which includes:

•
•
•
•
•

Decisions made in the process of these communications

Contract review records may include

Project requirements are distributed to responsible authorities in the Company. The controls for contract review are defined in the QMS-07 Proposal Development and Contract Review Procedure.
6.1 Customer Requirements
The Company captures all contractual as part of the Proposal Development & Contract Review process. Once contractual

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

7.0 Detailing

7.1 Detailing Standards
The Company utilizes detailing standards

The standards describe

The standards describe
The standards include:

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 ensure completeness. 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 ensure completeness. 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 the methods included.

7.4 Shop Drawings Supplied by Others
Shop drawings received from the Owner/Buyer are

7.5 Management of Detailing
Detailing Management Connection Consultation and other detailing functions may
Personnel performing Detailing Management are responsible for

7.6 Detailing Functions
Personnel that detail and/or check shop drawings have

7.6.1 References (required library)
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:

7.7 Subcontract Services
In lieu of employed staff personnel, subcontract services

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

which includes policies for:

A.
7.9 Design for Standard Services
The controls for standard services are...

7.10 Design for Non-standard Services
The controls for non-standard services are...

8.0 Control of Management System Documents and Project Documents

8.1 Management System Documents
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...

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...

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...
8.1.4 Access to Quality Management System Documents
Relevant and current 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 according to the QMS-02 Configuration Management Procedure and applicable Change Order(s).

8.2 Project Documents
A method has been established. 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.

8.2.2 Revision Control of Project Documents
Controlled project documents
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 are defined in the QMS-10 Steel Fabrication Procedure.

9.0 Maintenance of Quality Records
Records are retained and maintained according to the QMS-01 Control of Documented Information Procedure.

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 according to the QMS-01 Control of Documented Information Procedure.

9.3 Retrieval of Quality Records
Proprietary records are non-proprietary records are

10.0 Purchasing
Purchasing is treated as a process within the Company's quality system according to QMS-08 Purchasing Procedure. The Company accepts
10.1 Purchasing Data
Purchase documents clearly define the following information:

- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]

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's compliance with contract requirements. 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.

10.2.2 Detailing Subcontractors
The Company performs detailing 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. The methods used for verification of purchased items are defined in the QMS-09 Receiving Procedure for Steel Fabricator.

Materials received
Deliveries are checked 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

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

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

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
Procedures and records are maintained that demonstrate care and control of the fabrication process.

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

- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]

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 and include:

- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]

12.2 Bolt Installation

The Company’s bolting procedure is and includes:

- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
- [ ]
12.3 Material Preparation for Application of Coatings
The Company's prepares material for coating application.

12.4 Coating Application
The Company applies and cures coatings.

12.5 Equipment Maintenance
A documented preventive maintenance program is implemented.

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

13.0 Inspection and Testing
To ensure conformance to requirements of deliverable items, monitoring and measurement 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.
13.1 Assignment of QC Inspections and Monitoring

QC inspectors are under the following conditions:

- 
- 
- 
- 

13.2 In-Process Inspection

The Company retains and maintains in-process inspection

In-process inspections are

In-process inspections are

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

- 
- 
- 
- 
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- 
- 

13.3 Final Inspection

Qualified inspectors perform final inspection
13.4 Inspection Records
Inspection records provide 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. The controls for such equipment and calibration activities are defined in the QMS-15 Calibration Procedure.

15.0 Control of Nonconformances
Nonconformances are identified according to the QMS-14 Control of Nonconformances Procedure.

15.1 Nonconformance with Management Systems
The Company conducts internal audits according to the QMS-12 Internal Auditing Procedure.

15.2 Nonconforming Product and Work
When a nonconformance occurs, according to the QMS-13 Corrective Action Procedure and QMS-14 Control of Nonconformances Procedure.
16.0 Corrective Action
The Company has implemented and maintains

Such reports result in

The Company determines

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

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

The Company has implemented a training program that:

•
•
•
•
The training program is defined in the **QMS-06 Training Procedure**.

### 19.0 Internal Audit

Internal quality audits are performed to ensure that the processes are in conformity with the quality system. The internal audit process is defined in the **QMS-12 Internal Auditing Procedure**.
QUALITY MANUAL for STRUCTURAL STEEL ERECTOR

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Paragraph 5.7.3 is "value added" content.
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

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
3.1 Seismic Erection
For the erection of structures requiring the use of ANSI/AISC 341 Seismic Provisions for Structural Steel Buildings, the Company meet the requirements of:

- 
- 

3.2 Metal Deck Installation
When work includes the installation of metal deck, the Company has available and demonstrates the ability:

(a) 

3.3 Bridge Erection
For the erection of bridges, the Company meet the requirements of:

- 
- 

3.4 Safety
Employees and others that perform work for the Company are which also includes 

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 

5.1 Policy for Quality and Quality Goals
The Company's quality policy defines 

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CUSTOMER FOCUS:

EMPOWERMENT:

INTELLIGENT MANAGEMENT:

WORKPLACE EXCELLENCE:

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

ENVIRONMENTAL POLICY

PRACTICAL STEPS TO SUPPORT POLICIES

Customer Focus:

Workplace Excellence:

Empowerment:

Intelligent Management:
5.2 Periodic Management Review

Review meetings are held by all managers two times each year to define the controls for management review are defined in the QMS-04 Management Procedure, which 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 Responsible Authorities also perform an annual review of the safety management system, which includes:

- ...
- ...
- ...
- ...
- ...
- ...
- ...
- ...

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
5.4 Resource Management

The Company has the resources necessary to

5.4.1 Personnel

Personnel performing assigned functions have qualifications that

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

- 
- 
- 
- 

5.4.2 Buildings, Workspace, Equipment and Associated Utilities

The facility consists of areas and buildings that provide space to

Adequate space is provided for

Ambient conditions are

5.4.3 Erection Tools and Equipment

The Company has under its control the equipment

5.5 Quality Management System

The Quality System ensures that necessary procedures and instructions
The Company maintains all required documentation. 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, Management periodically communicates with the employees. Employees are encouraged to communicate with each other.

5.7 Quality Manual

The primary purpose of the Quality Manual and QMS Procedures is to define overall Company policies and procedures.
5.7.1 Organization

Review meetings are held by all managers defined in the QMS-04 Management Procedure. 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, the organizational chart below defines the basic management structure of the Company. In all cases, 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:

- President
- [List of other key personnel and managers]

5.7.2 Approval

This manual is issued under the authority of Management ensures the QMS.
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. 
2. 
3. 
4. 
5. 

5.8 Safety Manual

The Company ensures Employees which contains the following information:

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5.9 Policy for Safety

Executive management is responsible for The policy for safety includes:

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Executive management
5.10 Responsible Safety Personnel

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

- 
- 
- 

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

The Company communicates which includes:

- 
- 
- 
- 
- 
- 

Decisions made in the process of these communications

Contract review records may include

Project requirements are distributed to responsible authorities in the Company. The controls for contract review are defined in the QMS-07 Proposal Development and Contract Review Procedure.
Communications with Authorities Having Jurisdiction (AHJ)

A number is assigned the following:

- 
- 
- 
- 

6.1 Customer Requirements
The Company captures all contractual as part of the Proposal Development & Contract Review process. Once contractual

The Company determines their capability to meet Customer requirements 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 

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
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 are managed and maintained in accordance with this procedure. 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 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, procedures, and practices are communicated and documented in accordance with the QMS-02 Configuration Management Procedure and applicable Change Order(s).

8.2 Project Documents
A method has been established for tracking project documents. 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.
8.2.2 Revision Control of Project Documents

Controlled project documents are managed according to 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 are defined in the QMS-10 Structural Steel Erection Procedure.

9.0 Maintenance of Quality Records

Records are retained and maintained as required by applicable laws and regulations. All quality records are controlled according to the QMS-01 Control of Documented Information Procedure.

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 according to the QMS-01 Control of Documented Information Procedure.
9.3 Retrieval of Quality Records
Proprietary records are non-proprietary records are

10.0 Purchasing
Purchasing is treated as a process within the Company’s quality system. The Company accepts

10.1 Purchasing Data
Purchase documents clearly define

Purchasing documents contain the following information:

- 
- 
- 
- 
- 

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

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

10.3 Verification of Purchased Product, Materials and Services
The responsibility for quality of subcontracted products remains with the Company.
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
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
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
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
Procedures and records are maintained that demonstrate care and control of
Effective implementation of the following documented procedures is required as a minimum:
(revise as required)

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- 
- 
- 
- 
- 

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

12.2 Bolt Installation
The Company's bolting procedure includes

12.3 Material Preparation for Application of Coatings
The Company's prepares material for coating application

12.4 Equipment Maintenance
A documented preventive maintenance program is implemented

It is acceptable to operate equipment

13.0 Inspection and Testing
To ensure conformance to requirements of the applicable erection project, monitoring and measurement

The methods for the control of the inspection and testing
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 assigned to inspection duties under the following conditions:

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- 
- 
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13.2 Inspection Procedures

13.2.1 Material Receipt Inspection

Materials received are checked for conformance to specifications. Deliveries are checked for completeness and proper identification. 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 to ensure compliance with the erection process. The Company examines completed work.

13.2.3 Final Inspection

The Company examines completed work.
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 are calibrated. The controls for such equipment and calibration activities are defined in the QMS-15 Calibration Procedure.

15.0 Control of Nonconformances
Nonconformances are identified and controlled according to the QMS-14 Control of Nonconformances Procedure.

15.1 Nonconforming Quality Management System
The Company conducts internal audits according to the QMS-12 Internal Auditing Procedure.

15.2 Nonconforming Work
When a nonconformance occurs, corrective action is taken according to the QMS-13 Corrective Action Procedure and QMS-14 Control of Nonconformances Procedure.

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

16.0 Corrective Action
The Company has implemented and maintains procedures for the detection, correction, and Prevention of nonconformances. Such reports result in
Corrective actions are

Corrective action is applied when:

- The Company determines if additional nonconformances exist
- 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 defined in the QMS-10 Structural Steel Erection Procedure. General rules are

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

18.0 Training
All Company personnel are hired

The Company has implemented a training program that:

- Includes:
The training program is defined in the QMS-06 Training Program.

19.0 Internal Audit

Internal quality audits

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 includes the following information as appropriate for the project:
The erection plan is

21.0 Safety Plan

The Company prepares a safety plan for every project.

A safety plan considers

The safety plan includes the following information as appropriate for the project:
22.0 Other Project-Specific Requirements

Prior to the start of the erection project, the Company

According to the AISC Code of Standard Practice and contract documents, the Company

23.0 Safety Management System

23.1 Documentation Requirements

The QMS-03 Safety Program contains the following information:

- The safety plan

23.2 Safety Training

Safety training includes

Safety training includes

The safety plan

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