

**PREQUALIFICATION PROCEDURES AND ACCEPTANCE CRITERIA FOR HEADED ASTM
A 706 REINFORCING STEEL BARS**

- I. Manufacturer/Supplier provides
 - A. The model number/name of the product.
 - B. Brochures, shop drawings, and other technical information that indicates
 1. Dimensions
 2. Materials
 - C. Documentation of heat treatment or any special manufacturing process (i.e., forging the bar end).
 - D. Quality control procedures for materials and manufacturing process (es). As a minimum, the QC manual shall include the following:
 1. The pre-production procedures for the qualification of materials and equipment.
 2. The methods and frequencies for performing QC procedures during production.
 3. The calibration procedures and calibration frequency for all equipment.
 4. The welding procedure specification (WPS) for friction welded headed bar reinforcement.
 5. A system for marking and tracking headed bar reinforcement lots with the following information:
 - a. Production lot numbers
 - b. Heats of bar material and head material used in the manufacture of each production lot
 - c. Number of bars in each production lot
 - d. Manufacturing records, including tracking and production parameters for welds or forgings.
 - E. Test report from an independent testing lab verifying that the product meets Caltrans' Standard Specifications, Section 52, and ASTM A970 specifications.
 - F. Four headed rebar samples for each rebar size: 4 feet long for rebar sizes #9 and below and 6.0 feet long for rebar sizes #10 and above.
 - G. Mill certificates for head material and rebar for each sample and rebar size.
- II. Caltrans will:
 - A. Ensure all required documentation and samples are received.
 - B. Review the technical information the supplier provided.
 - C. Perform mechanical testing
 1. Cyclical test per Test Method CT 670
 2. Tensile test per Test Method CT 670
 - a. Tensile strength shall conform to the requirements specified in ASTM Designation: A 970/A 970M, Class A (80 ksi minimum).
 - b. Rupture in the rebar, with visible necking or decrease in the sample's cross-sectional area, at the point of rupture, at a minimum distance of one bar diameter away from the head to bar connection for friction welded and forged headed bar reinforcement, and/or the threads end for threaded headed bars.

- D. Upon evaluation of results from II.A to II.C above, issue either an acceptance letter or rejection letter.
- E. Update the Caltrans Headed Bar Reinforcement Pre-qualified Products list, if applicable.

For more information, you may contact the Structural Materials Testing Branch at (916) 227-7253.