

GENERAL SHOP NOTES

SPECIFICATIONS:

- MATERIAL AND WORKMANSHIP TO BE IN ACCORDANCE WITH THE STATE OF VERMONT, AGENCY OF TRANSPORTATION, STANDARD SPECIFICATIONS FOR CONSTRUCTION DATED 1990, ITS LATEST REVISIONS, SPECIAL PROVISIONS AND SUPPLEMENTAL SPECIFICATIONS, AND THE AASHTO STANDARD SPECIFICATIONS FOR HIGHWAY BRIDGES DATED 1992, AND ITS LATEST REVISIONS.

MATERIAL:

- UNLESS OTHERWISE NOTED, ALL STRUCTURAL STEEL TO BE AASHTO M270-50W.
- (T) INDICATES CHARPY V-NOTCH TESTING REQUIRED.
- △ SHOP BOLTS TO BE H.S. BOLTS ASTM A325, TYPE 3 W/1 ASTM A563 GR. DH3 HVY HEX NUT AND ONE F436 WEATHERING WASHER EACH BOLT. (UN).
- RCT INDICATES ROTATIONAL CAPACITY TESTED BOLTS. DO NOT MIX NUTS, BOLTS AND WASHERS FROM DIFFERENT CONTAINERS UNLESS ALL NUTS, BOLTS AND WASHERS HAVE THE SAME LOT NUMBER.

SHOP PROCEDURE:

- CAMBER TOLERANCE: -0, + 3/4"
- ALL RE-ENTRANT CUTS TO HAVE 1" MIN. RADIUS.
- ⊗ DENOTES THICKER SIDE OF SOLE PLATE.
- ⊕ DENOTES SET LINE.
- [RA] NOTE: "HOLES MARKED [RA] ARE TO BE SUB-PUNCHED/SUB-DRILLED 1/8" UNDER SIZE AND REAMED TO FULL SIZE OR DRILLED FROM SOLID WITH CONNECTING PARTS ASSEMBLED AND MATCH MARKED."

MINIMUM BENDING RADIUS FOR BENT PLATES

WHEN THICKNESS t	RADIUS INSIDE OF BENT PLATE
UP TO 1"	2 1/2 t
OVER 1" TO 1 1/2	3 t
OVER 1 1/2 TO 2 1/2	3 1/2 t
OVER 2 1/2 TO 4	4 t

INSPECTION:

- SHOP INSPECTION BY: E. L. CONWELL.

WELDING:

- ALL WELDING AND FABRICATION SHALL BE PERFORMED IN CONFORMANCE WITH ANSI/AASHTO/AWS D1.5-88 BRIDGE WELDING CODE.
- FOR WELDING STIFFENERS AND CONNECTION PLATES TO GIRDERS SEE "TYP. WELDING DETAIL".

DRAWING REFERENCE:

WEB CAMBER DIAGRAMS	- PREFIXED "WC"
FLANGE SPLICES	- PREFIXED "FS"
GIRDER JOB STANDARDS	- PREFIXED "X"
SHOP ASSEMBLY DIAGRAM	- PREFIXED "SA"

NON-DESTRUCTIVE TESTING:

- ALL WEB AND FLANGE BUTT SPLICES SHALL BE RADIOGRAPHICALLY TESTED AS FOLLOWS:

BUTT SPLICES:	TESTING:
FLANGE SPLICES	100% @ TENSION SPLICE 25% @ COMPRESSION SPLICE
WEB SPLICES	1/6 WEB @ TENSION FLANGE + 25% OF REMAINDER

- DYE PENETRATION INSPECTION SHALL BE PERFORMED AT ENDS OF FLANGE AND WEB BUTT WELDS.

- MAGNETIC PARTICLE INSPECTION: MAGNETIC PARTICLE INSPECTION IS REQUIRED ON ALL FILLET WELDS AND GROOVE WELDS NOT TESTED BY ANOTHER METHOD. INSPECTION IS REQUIRED ON 10% OF ALL WELDS GREATER THAN 10'-0" IN LENGTH AND 1'-0" OF ALL WELDS LESS THAN 10'-0" IN LENGTH IN MAIN MEMBERS.

CLEANING:

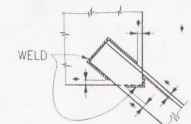
- BLAST CLEAN ALL STEEL TO SSPC-SP10 (NEAR WHITE) EXCEPT BLASTING NOT REQUIRED FOR GALVANIZED SURFACES.
- BLAST CLEANING PROFILE TO BE FROM 1.5 TO 2.5 MILS DEEP.

PAINT:

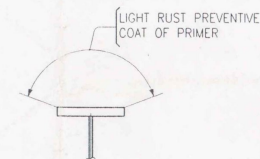
- AREAS TO BE PAINTED (NOTED ON DETAIL DWGS.) SHALL BE PAINTED WITH A 3 - COAT SHOP APPLIED SYSTEM (UN) CONSISTING OF:
 - PRIME COAT - CARBO ZINC 11 HS (INORGANIC ZINC) APPLIED AT 2.0 TO 6.0 MILS DFT.
 - INTERMEDIATE COAT - CARBOLINE 893 (EPOXY) APPLIED AT 3.0 TO 7.0 MILS DFT.
 - FINISH COAT - CARBOLINE 133HB (POLYURETHANE) APPLIED TO 3.0 TO 7.0 DFT.
- FINISH COAT COLOR TO BE DARK BROWN NO.20059 AS SHOWN IN FEDERAL STD.NO.595.

- PRIME COAT TO BE APPLIED WITHIN 8 HRS. OF BLAST CLEANING.
- STRIPE COAT ALL EDGES OF PLATES, ANGLES OR OTHER SHAPES, BOLTS AND NUTS PRIOR TO THE APPLICATION OF THE PRIME COAT.

ALL AROUND WELDS TO CROSSFRAME PLATES TO BE TERMINATED FROM END GUSSET PLATE OR ANGLE AS INDICATED



CROSSFRAME WELDING DETAIL



SECTION-A

TYP. WELD

RECEIVED
CRD BY: []
MAY 27 1996
RESUBMIT APPROVED
BY: [] DATE: []

Rec. 6

△	Eliminated Additions
△	ADDED SHOP BOLT NOTE
NO.	REV

HIGH STEEL STRUCTURES.

GENERAL	PROJECT NO.
U.S. ROUTE	J. A. McDONALD
TOWN OF WALLING	MA
STATE	VT
AGENCY OF	VT
STATE CONTRACT OR REF. NO.	VT-95367
CONTRACTOR	abs
IN CHARGE	abs
CONTRACT NUMBER	VT-95367

SHOP DRAWING REVIEW

REVIEWED FOR GENERAL COMPLIANCE WITH CONTRACT DOCUMENTS. NO RESPONSIBILITY IS ASSUMED FOR CORRECTNESS OF DIMENSIONS OR DETAILS.

APPROVED: []
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DATE: 6-10-96 BY: []