

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.
- 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 (UN).
- $\otimes$ DENOTES THICKER SIDE OF SOLE PLATE.

— 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:

- 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'

GENERAL SHOP NOTES

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
WEB SPLICES -----	1/6 WEB @ TENSION F + 25% OF REMAINDER

- DYE PENETRATION INSPECTION SHALL BE PERFORMED AT ENDS OF BUTT WELDS.
- MAGNETIC PARTICLE INSPECTION:
MAGNETIC PARTICLE INSPECTION IS REQUIRED ON ALL FILLET WELDS BY ANOTHER METHOD. INSPECTION IS REQUIRED ON 10% OF ALL 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 BOLTS 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 3 - COAT SHOP APPLIED SYSTEM (UN) CONSISTING OF:
 - PRIME COAT - CARBO ZINC 11 HS (INORGANIC ZINC) APPLIED AT 3.0 MILS DFT
 - INTERMEDIATE COAT - CARBOLINE 893 (EPOXY) APPLIED AT 3.0 MILS DFT
 - FINISH COAT - CARBOLINE 133HB (POLYURETHANE) APPLIED TO FINISH COAT COLOR TO BE DARK BROWN NO.20059 AS SHOWN IN
- 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.
- OUTSIDE SURFACES OF FASCIA GIRDERS, AS NOTED ON DETAIL DRAWINGS, SHALL RECEIVE AN ADDITIONAL COAT OF THE FINISH PAINT.
- FIELD BOLTED CONTACT SURFACES WITHIN THE AREAS TO BE PAINTED SHALL RECEIVE THE PRIME COAT ONLY WITHIN 3" OF OPEN HOLES.
- SURFACES WITHIN 2" OF FIELD WELDING (AS NOTED ON DETAILS) SHALL RECEIVE A LIGHT RUST PREVENTIVE COAT OF PRIMER, NOT TO EXCEED 1.5 MILS DFT.
- SURFACES IN CONTACT WITH CONCRETE WITHIN THE AREAS TO BE PAINTED SHALL RECEIVE A LIGHT RUST PREVENTIVE COAT OF PRIMER, NOT TO EXCEED 1.5 MILS DFT. THESE SURFACES ARE NOTED ON THE DETAIL DRAWINGS.
- TOP FLANGE OF GIRDER AS SHOWN IN SECTION-A SHALL RECEIVE A LIGHT RUST PREVENTIVE COAT OF PRIMER, NOT TO EXCEED 1.5 MILS DFT.