



1. MATERIAL-HIGH STRENGTH LOW ALLOY STEEL 55,000 PSI MIN YIELD PER ASTM A572. POST AND MAST ARM MOUNTING BASE MATERIAL PER ASTM A36.
2. FINISH- HOT DIP GALVANIZED PER ASTM A123 WITH TOP COAT PAINTED MILLERBERND PLAT BLACK MILLERBERND 8PT-1-17-PTU-093-FR.
3. POST TO BE ROUND TUBE FABRICATED WITH ONE SUBMERGED ARC LONGITUDINAL SEAM WELD WITH 100% PENETRATION 6" FORM BASE PLATE AND 50% FOR REMAINDER. GAS METAL ARC WELDING PROCESS TO BE USED FOR REMAINDER OF WELDED FABRICATION WITH 100% PENETRATION WELD FOR BASE PLATE TO SHAFT CIRCUMFERENTIAL WELD
4. WELD TESTING-100% PENETRATION WELDS ULTRASONIC TESTED OUT) USING THE CYCLICALLY LOADED ACCEPTANCE/REJECTION CRITERIA TABLE 6.3 OF AWS D9.1 SPECIFICATION. 100% OF THE POST/MAST ARM CONNECTION WELDS MAGNETIC PARTICLE TESTED (MT) AND A RANDOM 30% OF REMAINING FILLET WELDS & PARTICLE PENETRATION LONGITUDINAL SEAM WELDS MAGNETIC PARTICLE TESTED (MT)
5. FIX HD BOLTS & NUTS (UNLESS SPECIFIED) ASTM A325 GALV A153 FOR SIZES 1/4 TO 1 1/2 DIA & ASTM A354BC GR A153 FOR SIZES OVER 1 1/2 DIA.
6. THE POST AND THE FOLLOWING ITEMS WILL BE SHIPPED UNASSEMBLED.

IDENTIFICATION TAG EXAMPLE

PART (#)	QTY	DESCRIPTION	'A' POST TAG INFORMATION	'B' HAST ARM TAG INFORMATION
76000012	1	SIGNAL POST	3/16 X 3.0 X 5.5 X 250 GRADE SS	3/16 X 3.0 X 5.5 X 250 GRADE SS

PC#2250-2128 / VT DOT: SKP.0284	(17) RICHMOND / US ROUTE 3, VT ROUTE 117, US ROUTE 2, OFF-RAMP
(RAMP 2) / MILLBERRAND #51660	SP204-180/285-1200-117 DUNDON SIGNAL POST

DWN DOUG F.	RE2HA-180/286-J300-VT ROUND SIGNAL POST	
DATE: 11-4-13	3/16 X 12.0 X 28'-6" POST	
CHK: RESEKAH	LUMINAIRE ARM AT 300 DEG	
SCALE: NTS	Millerbernd MANUFACTURING CO. WINDST, NH	780B1312