

GENERAL FABRICATION NOTES

MATERIAL SPECIFICATIONS

1. ALL MATERIAL SHALL BE ASTM A709 GRADE 50W (UNO). THE BOTTOM FLANGES OF THE GIRDERS FOR BRIDGE 43N SHALL CONFORM TO ASTM A709 HPS 70W.
2. ALL A709 GRADE 50W MATERIAL DENOTED "CVN" SHALL MEET THE CHARPY V-NOTCH TESTING REQUIREMENTS OF ZONE 2, H FREQUENCY: 15 FT-LB AT 40° (UP TO 2" WELDED). ALL A709 GRADE HPS 70W MATERIAL DENOTED "CVN" SHALL MEET THE CHARPY V-NOTCH TESTING REQUIREMENTS OF ZONE 2, H FREQUENCY: 25 FT-LB AT -10° (UP TO 4" WELDED). ITEMS SHALL CALL OUT "CVN" FOR EACH APPLICABLE ITEM IN THE BILL OF MATERIALS.
3. BOLTS SHALL BE HIGH STRENGTH BOLTS ASTM A325, TYPE 3. NUTS SHALL BE ASSI GRADE D3 OR D13. WASHERS SHALL BE ASTM F436, TYPE 3. BOLTS AND NUTS SHALL BE ROTATIONAL CAPACITY TESTED. DO NOT MIX NUTS AND BOLTS FROM DIFFERENT CONTAINERS UNLESS ALL NUTS AND BOLTS HAVE THE SAME LOT NUMBER.
4. DIRECT TENSION INDICATORS SHALL BE INSTALLED WITH ALL HIGH STRENGTH BOLTS.

FABRICATION

1. DIE STAMPING IS ALLOWED IN SPECIFIC LOCATIONS WITH THE APPROVAL OF THE ENGINEER.
2. ALL EDGES OF FLAME CUT MATERIAL SUBJECTED TO CALCULATED STRESSES SHALL BE ROUNDED TO A MINIMUM RADIUS OF 1/16", OR AN EQUIVALENT FLAT SURFACE AT A SUITABLE ANGLE.
3. ALL PLATES FLAME CUT FROM LARGER PLATES, SHALL BE CUT SO THAT THE PRIMARY DIRECTION OF ROLLING IS PARALLEL TO THE MAIN TENSILE OR COMPRESSIVE STRESS. STANDARD SPEC. 506.06.
4. FLANGE PLATE MATERIAL SHALL HAVE AN EDGE HARDNESS NOT GREATER THAN HRc 30, ALLOWED per STANDARD SPEC. 506.09.

WELDING

1. ALL WELDING PROCEDURES SHALL BE IN ACCORDANCE WITH THE PROVISIONS OF SUBSECTION 506.10.
2. NON DESTRUCTIVE TESTING OF WELDS SHALL BE IN ACCORDANCE WITH NDS/AASHTO 903.013 - SECTION 6. FLANGE WELDS WILL BE CALLED OUT AS BEING IN EITHER COMPRESSION OR TENSION. WEB WELDS WILL LABEL EITHER TOP OR BOTTOM AS BEING IN COMPRESSION, OR BE LABELED AS BEING IN A STRESS REVERSAL AREA.
 - FLANGE SPLICES SHALL BE TESTED AS FOLLOWS:
 - FLANGE SPLICES IN TENSION ~ TESTED 100%
 - FLANGE AREAS IN STRESS REVERSAL AREAS ~ TESTED 25%
 - FLANGE SPLICES IN COMPRESSION ~ TESTED 25%
 - WEB SPLICES SHALL BE TESTED AS FOLLOWS:
 - FOR 1/8 THE DEPTH OF THE WEB (TENSION AREA) ~ TESTED 100%
 - FOR THE REMAINING DEPTH OF WEB (COMPRESSION AREA) ~ TESTED 25%
 - FOR 1/8 DEPTH OF THE WEB @ TOP & BTM (STRESS REVERSAL) ~ TESTED 100%
 - THE REMAINING 2/3 OF THE WEB ~ TESTED 25%

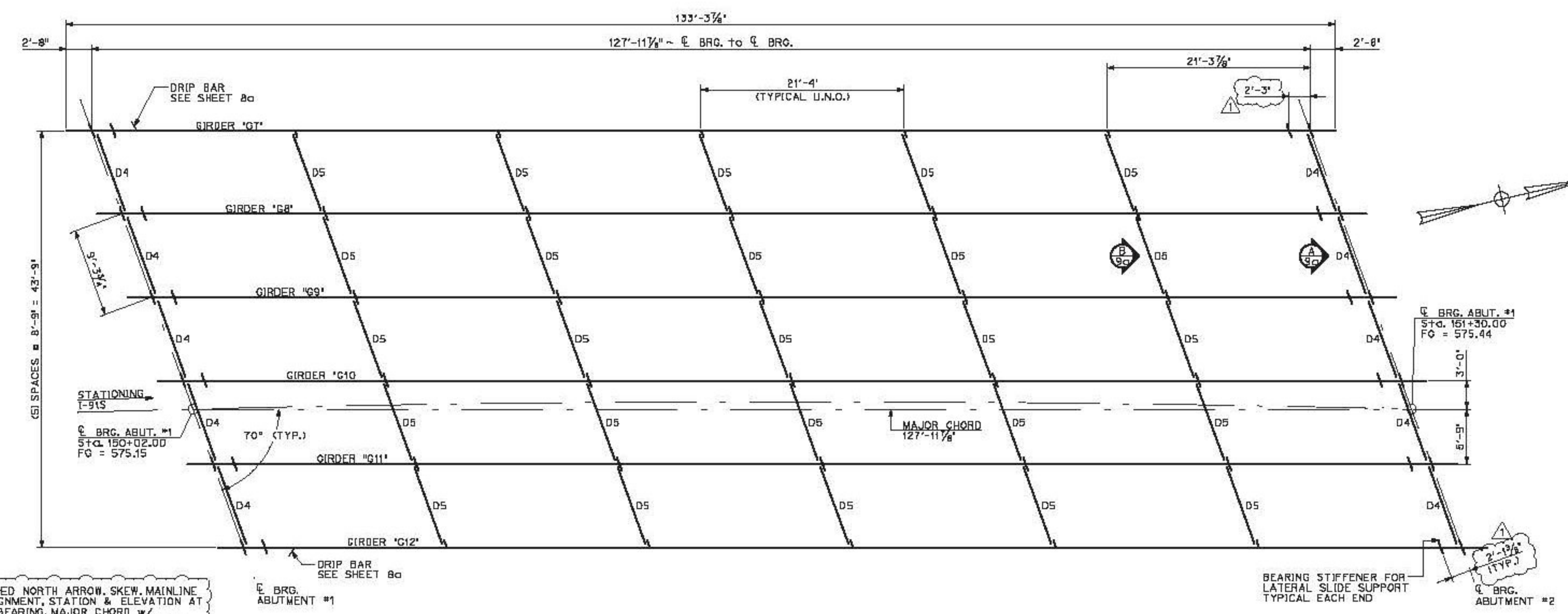
3. TERMINATE CONNECTION R & STIFFENER WELDS AS SHOWN IN THE "WELD TERMINATION DETAIL" ON SHEET 8c.

FIELD CONNECTIONS

1. FIELD BOLTS SHALL HAVE A HEAVY HEX NUT, HEX HEAD, ONE HARD WASHER AND ONE DIRECT TENSION INDICATOR (DTI) EACH. DTI'S SHALL BE INSTALLED ACCORDING TO SUBSECTION 506.13.
2. PIECE MARKS WILL BE LOCATED AS SHOWN ON ERECTION DRAWINGS. ALL ERECTION MARKS, MATCH MARKS, AND WEIGHT MARKS MUST NOT BE EXPOSED IN THE FINISHED STRUCTURE.

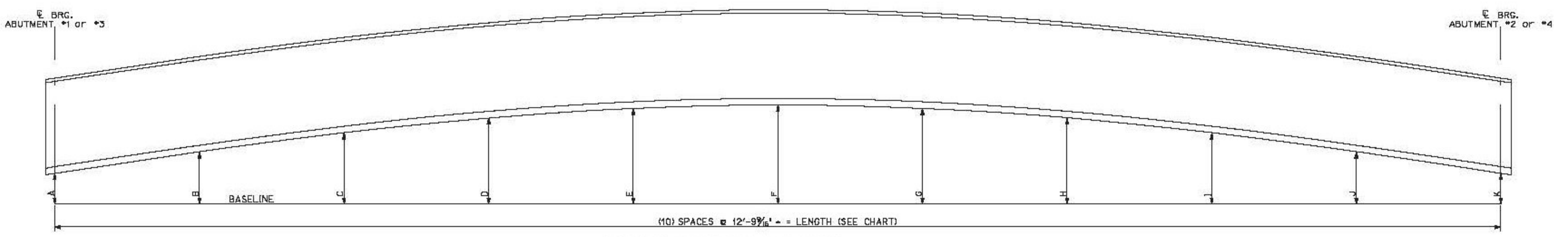
CLEANING AND PAINTING

1. UNPAINTED STEEL SHALL BE BLAST CLEANED TO SSPC SP-10 TO ACHIEVE A UNIFORM WEATHERED APPEARANCE.



SOUTHBOUND FRAMING PLAN (BRIDGE 43S)
SCALE: 1/4" = 1'-0"

- ADDED NORTH ARROW, SKEW, MAINLINE ALIGNMENT, STATION & ELEVATION AT BEARING, MAJOR CHORD w/ DIMENSIONS TO ADJACENT GIRDERS
- IT IS VERIFIED THAT THE DIAPHRAGMS ARE SHOWN ON THE CORRECT SIDE OF THE BEARING STIFFENERS. THE NOTE ON SHEET 9c HAS BEEN REMOVED.
- THE SHIP MARKS ON THE SOUTHBOUND BRIDGE HAVE BEEN CHANGED SO THAT THEY ARE DIFFERENT FROM THE NORTHBOUND BRIDGE.



BLOCKING DIAGRAM ~ SEE CHART
ALL DIMENSIONS ARE TO THE OUTSIDE OF BOTTOM FLANGES NOT TO SCALE

GIRDER LINE	LENGTH	ABUT. 1 E. BRG. "A"	"B"	"C"	"D"	"E"	"F"	"G"	"H"	"I"	"J"	ABUT. 2 E. BRG. "K"
SOUTHBOUND GIRDERS BRIDGE 43S	127'-11 3/4"	6'	9'	11 1/8'	13 3/4'	15 1/4'	15 1/2'	15 3/8'	13 3/4'	(11 1/16")	9'	6'
NORTHBOUND GIRDER BRIDGE 43N	127'-11 3/4"	6'	10 3/16"	14"	17'	18 3/4'	19 1/2'	18 3/8'	17'	14"	10 3/16"	6'

Vermont Agency of Transportation
RECEIVED
CK'D BY RK/JC OK'D BY WL
February 17, 2015
RESUBMIT NO Approved
BY KH DATE 2-19-2015

PROJECT No. IM 091-2(79)
ITEM No. 506.55

FINISH	N/A		
MATERIAL	SEE DETAIL SHEETS		
HOLES			
ELECTRODES	PER WELD PROCEDURE		
WELDS	PER WELD PROCEDURE	2	2/17/14 As noted JWH
SURFACE PREP		1	2/9/14 Lateral slide support JWH
		NO	DATE DESCRIPTION BY

REVISIONS

DRAFTER	JWH	SOUTHBOUND FRAMING PLAN	PROJECT NO.
DATE	JAN. 2015	HARTFORD, VT 141 289 OVER US RTE 6	14-180
CHECKED	GMM	PROJECT NUMBER IM 091-2(79)	DWG. NO.
DATE	JAN. 2015	PCL CIVIL CONSTRUCTORS	1a

ADVANCED RESOURCES & CONST. ENTERPRISES, INCORPORATED
P.O. BOX 120 KINGFIELD, ME. 04947
PHONE: (207) 265-2545 - FAX: (207) 265-4054