

**GENERAL NOTES**

**CONSTRUCTION SPECIFICATIONS**

- 1) ALL MATERIAL AND WORKMANSHIP TO BE IN ACCORDANCE WITH THE STATE OF VERMONT AGENCY OF TRANSPORTATION STANDARD SPECIFICATIONS FOR CONSTRUCTION DATED 2006 WITH LATEST REVISIONS AND THE AASHTO LRFD BRIDGE CONSTRUCTION SPECIFICATIONS FOR HIGHWAY BRIDGES DATED 2002 AND ITS LATEST REVISIONS.

**MATERIAL SPECIFICATIONS**

- 1) UNLESS OTHERWISE NOTED, ALL STEEL TO BE UNPAINTED AASHTO M270 (ASTM A709) GRADE 50W.
- 2) MATERIAL NOTED "CVN" OR "T2" ON DETAIL DRAWINGS SHALL BE CHARPY V-NOTCH TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF VERMONT STANDARD SPECIFICATIONS SECTION 714.01.
- 3) HIGH STRENGTH BOLTS: ASTM A325 (AASHTO M164) 7/8" DIAMETER, TYPE 3, IN 15/16" DIAMETER HOLES, UNLESS NOTED OTHERWISE. NUTS SHALL BE A563 (TYPE 3) GRADE C3. IN PAINTED AREAS, USE ASTM 325 (AASHTO M164) TYPE 1 (GALV PER AASHTO M232) BOLTS, NUTS AND WASHERS.  
BOLTS & NUTS SHALL BE ROTATIONAL CAPACITY TESTED. DO NOT MIX NUTS & BOLTS FROM DIFFERENT CONTAINERS UNLESS ALL BOLTS & NUTS HAVE THE SAME LOT NUMBER.

**FABRICATION**

- 1) ALL HOLES SHALL BE PUNCHED OR DRILLED FULL SIZE (UN).

**WELDING**

- 1) THE CONFIGURATION OF THE WELD JOINTS AND ALL WELDING PROCEDURES SHALL BE IN ACCORDANCE WITH AASHTO/AWS D1.5-D2 BRIDGE WELDING CODE AND IN ADDITION TO SPECIFICATIONS SHOWN ABOVE. ALL WELDING WILL BE DETAILED TO PRE-QUALIFIED JOINTS, UNLESS PROHIBITED BY THE DESIGNER.
- 2) WELDING OF MAIN LOAD CARRYING MEMBERS AND ATTACHMENTS SHALL BE PERFORMED USING THE AUTOMATIC SUBMERGED ARC & SHIELDED METAL ARC PROCESSES. ALL WELDS ARE CONTINUOUS U.N.
- 3) NON DESTRUCTIVE TESTING OF WELDS SHALL BE IN ACCORDANCE WITH THE REFERENCED SPECIFICATION.
- 4) SEE DETAIL "MS1" ON THIS DRAWING FOR WELD TERMINATION DETAIL.

**FIELD CONNECTIONS**

- 1) ALL FIELD CONNECTIONS SHALL BE MADE WITH 7/8" DIAMETER HIGH STRENGTH A-325 BOLTS (UN), INSTALLED PER SECTION 506.19(G). SEE DWG E1 FOR FIELD BOLT SIZES.
- 2) BOLTS SHALL HAVE HEAVY HEX NUT, HEAVY HEX HEAD, AND AT LEAST ONE FLAT WASHER EACH. WASHER TO BE PLACED UNDER TURNED ELEMENT.
- 3) PIECE MARKS WILL BE LOCATED AS SHOWN ON ERECTION DRAWINGS.

**CLEANING**

- 1) ALL STEEL SHALL BE BLAST CLEANED IN ACCORDANCE WITH SSPC SP-10.

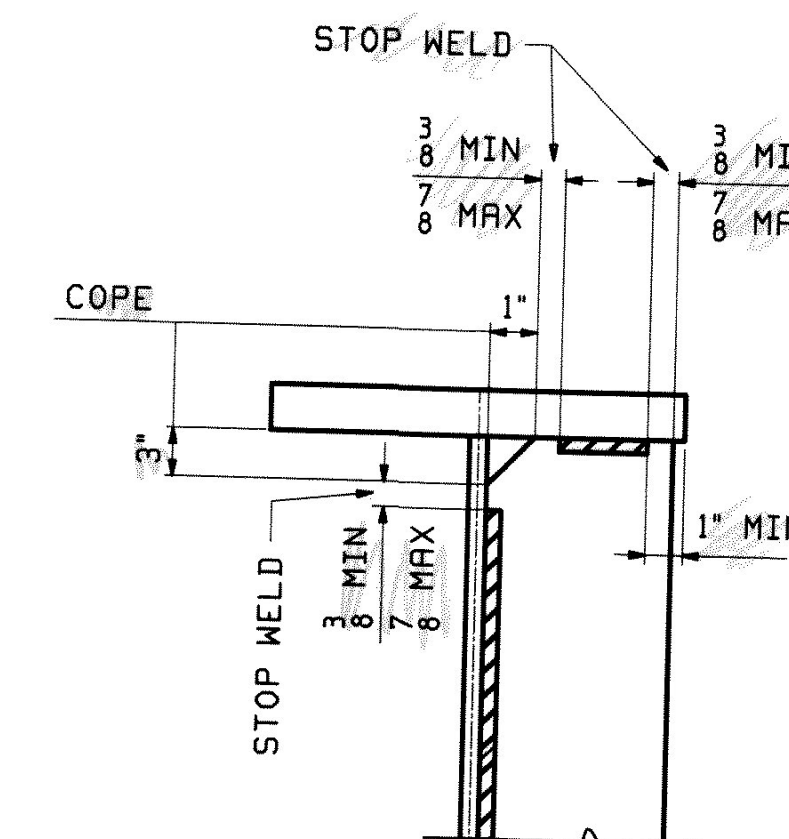
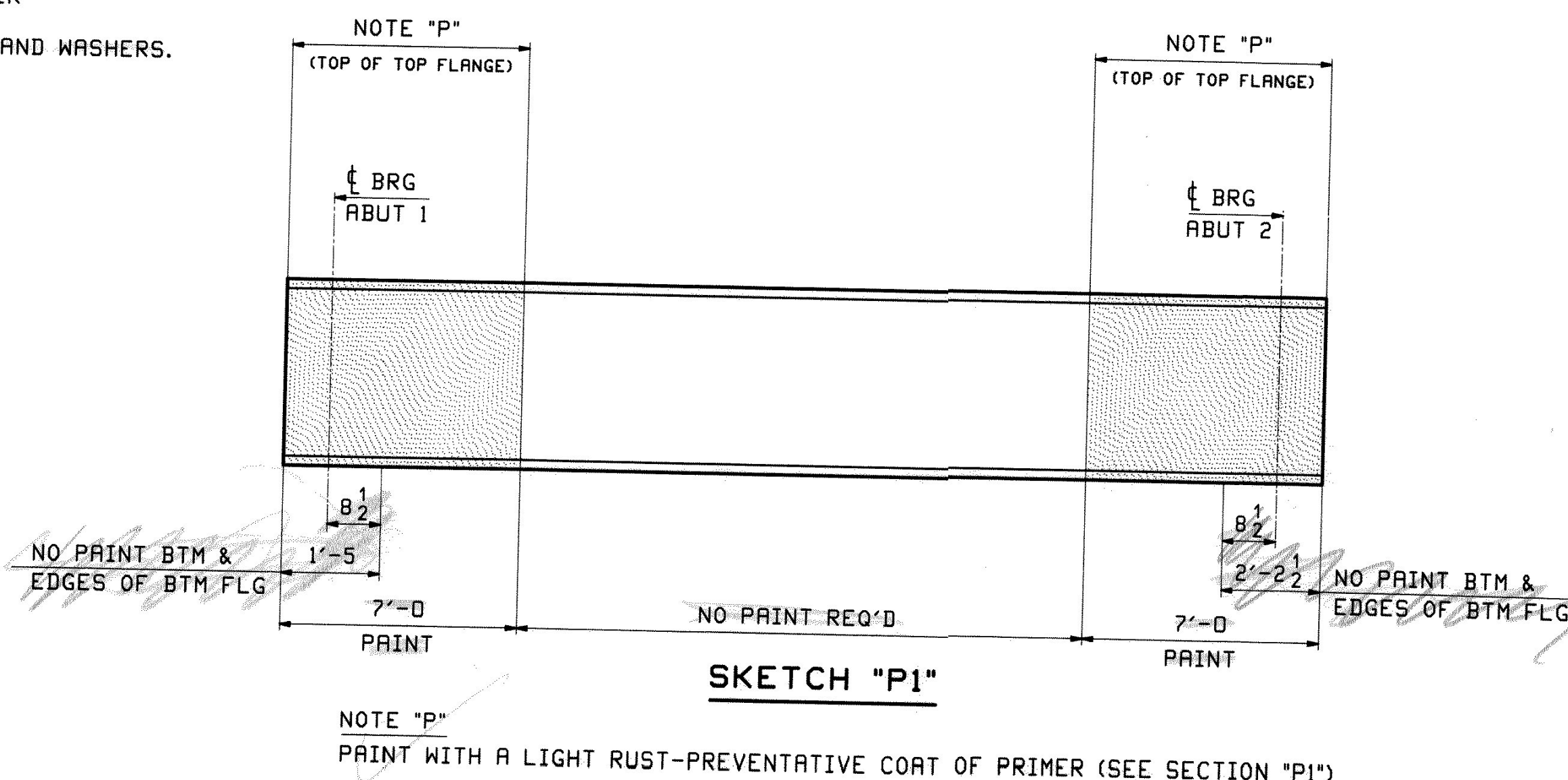
**PAINTING**

- 1) THE GIRDER ENDS & ABUTMENT DIAPHRAGMS WITHIN 7'-0" OF THE ENDS OF STEEL AT ABUT 1 & ABUT 2 SHALL BE PAINTED, EXCEPT AS NOTED (SEE SKETCH "P1").
- 2) THE PAINT SYSTEM AND ITS APPLICATION SHALL CONFORM TO SECTION 513-0F THE STANDARD SPECIFICATIONS.

THE PAINT SYSTEM SHALL BE AS FOLLOWS:  
 PRIMER: CARBOLINE 859 ORGANIC ZINC RICH PRIMER ~ 3.0 - 5.0 MILS DFT.  
 INTERMEDIATE: CARBOLINE 888 EPOXY ~ 4.0 - 6.0 MILS DFT.  
 TOPCOAT: CARBOLINE 133 HB ALIPHATIC POLYURETHANE ~ 2.0 - 4.0 MILS DFT.

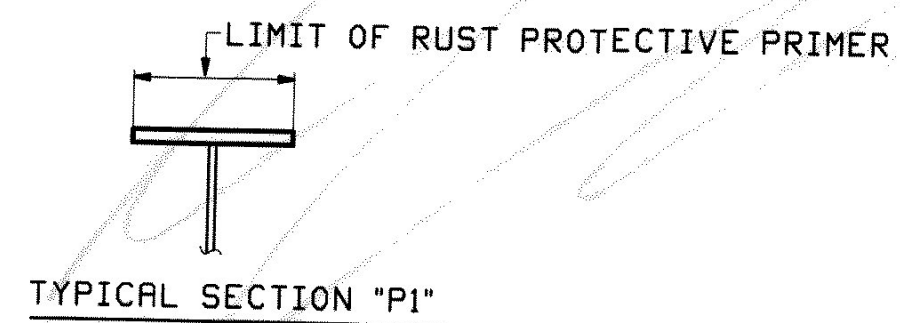
TOP COAT COLOR: DARK BROWN FED COLOR #20059

- 3) PRIME COAT ONLY WITHIN 3" OF ALL HOLES WITHIN THE PAINTED AREA.



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NOTE TO ENGINEER:  
 THESE NOTES ARE NOT INTENDED TO BE ALL INCLUSIVE AND COMPLIANCE WITH RELEVANT SPECIFICATIONS REMAIN UNCHANGED.



NO, OK AS-1A  
 IF HEAD IS TURNED, 2 WASHERS REQUIRED?

REVISIONS  
 NO. 1  
 DATE: 01/08/05  
 BY: TS

REV.	DATE	REMARKS	DWN	CHK	APVL	SHOP
MATERIAL:		SURFACE PREP. & PAINT:		HOLES:		SHOP BOLTS:
				AS NOTED		AS NOTED
DESCRIPTION: GENERAL NOTES						
CASCO BAY STEEL STRUCTURES, INC. 75 SPRING HILL ROAD SACO, MAINE 04072 PHONE (207) 282-7360 FAX. (207) 282-1179						
STRUCTURE: U.S. 5 over I-91 Bridge No. 19A Putney County of Windham			DRAWN:	DATE:		
			TS	01/05		
			CHKD:	DATE:		
			SOB	01/08		
LOCATION: Putney			JOB NO.	DWG NO.		
PROJ NO. IM 091-1(3)			438	GNI		
CUSTOMER: VT ROT				REV.		