

**GENERAL NOTES**

**CONSTRUCTION SPECIFICATIONS**

1. ALL MATERIAL AND CONSTRUCTION TO BE IN ACCORDANCE WITH THE STATE OF VERMONT AGENCY OF TRANSPORTATION STANDARD SPECIFICATIONS FOR CONSTRUCTION (2011) WITH ITS LATEST REVISIONS, AND THE AASHTO LRFD BRIDGE DESIGN SPECIFICATIONS, 5TH EDITION (2010) WITH ITS LATEST REVISIONS.

**MATERIAL SPECIFICATIONS**

1. ALL STRUCTURAL STEEL TO BE UNPAINTED AASHTO M270 (ASTM A709) GRADE 50W, UNLESS NOTED.
2. MATERIAL NOTES "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 SHALL BE 7/8" DIAMETER, ASTM A325 (TYPE 3), IN 15/16" DIAMETER HOLES. NUTS SHALL BE A563 (TYPE 3) GRADE C3, AND WASHERS SHALL BE F436 (TYPE 3).

BOLTS & NUTS SHALL BE ROTATIONAL CAPACITY TESTED. DO NOT MIX BOLTS & NUTS FROM DIFFERENT CONTAINERS UNLESS ALL BOLTS & NUTS HAVE THE SAME LOT NUMBER.

**FABRICATION**

1. ALL HOLES SHALL BE DRILLED FULL SIZE, UNLESS NOTED.

**MELDING**

1. THE CONFIGURATION OF THE WELD JOINTS AND ALL WELDING PROCEDURES SHALL BE IN ACCORDANCE WITH AASHTO/AWS D1.5-10 BRIDGE WELDING CODE; IN ADDITION TO THE PROVISIONS OF VERMONT STANDARD SPECIFICATIONS SECTION 506.10. 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. SUBMERGED ARC WELDS, WHERE USED, ARE SUBJECT TO TESTING REQUIREMENTS OF AWS D1.5, SECTION 5. ALL WELDS ARE CONTINUOUS, UNLESS NOTED.
3. NON-DESTRUCTIVE TESTING OF WELDS SHALL BE IN ACCORDANCE WITH THE REFERENCED SPECIFICATION.
4. SEE DETAIL "MS1" FOR THE WELD TERMINATION DETAIL.

**FIELD CONNECTIONS**

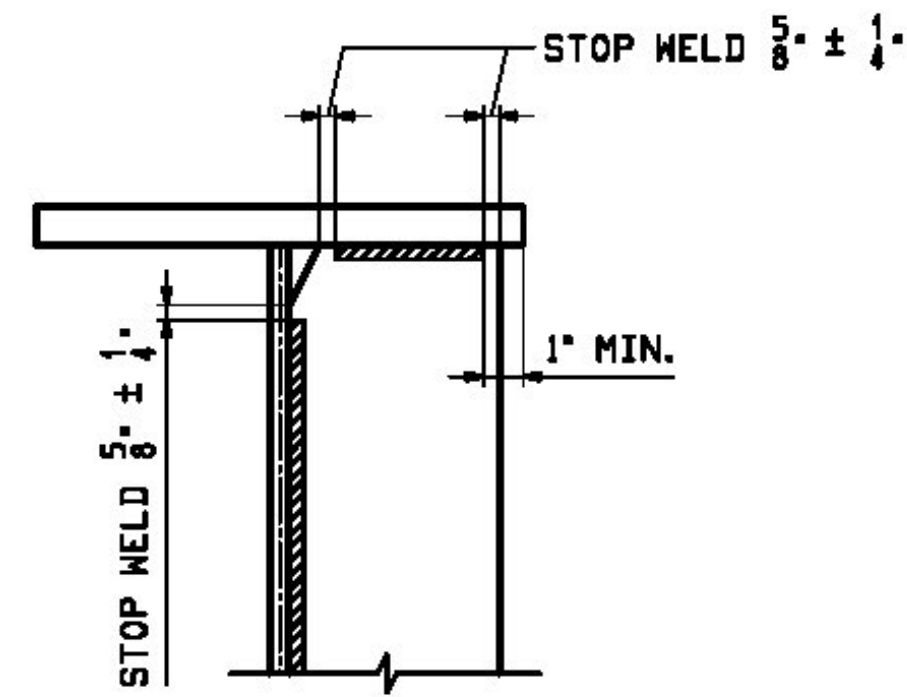
1. ALL FIELD CONNECTIONS SHALL BE MADE WITH 7/8" DIAMETER HIGH STRENGTH A325 BOLTS, INSTALLED PER SECTION 506.19(c).
2. BOLTS SHALL HAVE A HEAVY HEX HEAD, HEAVY HEX NUT, AND AT LEAST ONE HARD FLAT WASHER EACH. WASHER TO BE PLACED UNDER THE TURNED ELEMENT.
3. PIECE MARKS WILL BE LOCATED AS SHOWN ON SHEET E1.

**CLEANING**

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

**PRINTING**

1. STRUCTURAL STEEL SHALL BE UNPAINTED.



**DETAIL "MS1"**  
STIFF. WELD TERMINATION

Vermont Agency of Transportation  
**RECEIVED**  
 ON: **January 29, 2014**  
 and Checked for  
**CONFORMANCE**  
 BY: **Rob Young** DATE: **02/18/2014**

<input checked="" type="checkbox"/> Reviewed	<input type="checkbox"/> Furnish As Corrected
<input type="checkbox"/> Rejected	<input type="checkbox"/> Revise and Resubmit

This review is only for general conformance with the design concept and the information given in the Construction Documents. Corrections or comments made on the shop drawings during the review do not relieve the Contractor from compliance with the requirements of the Plans and Specifications. Review of a specific item shall not include review of an assembly of which an item is a component. The Contractor is responsible for dimensions to be confirmed and corrected at the job site, information that pertains solely to the fabrication process or to the means, methods, techniques, sequences and procedures of construction; coordination of the Work with that of other trades and performing all Work in a safe and satisfactory manner.

Date February 12, 2014  
 By D. Kull

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

REV.	DATE	REMARKS	DMN	CHK	APVL	SHOP
0						
MATERIAL:		SURFACE PREP. & PAINT:	HOLES:		SHOP BOLTS:	
DESCRIPTION: GENERAL NOTES						
CASCO BAY STEEL STRUCTURES, INC. 1 WALLACE AVE. PHONE (207) 780-6722 SOUTH PORTLAND, ME 04106 FAX. (207) 780-6726						
STRUCTURE: VT ROUTE 100 (MINOR ARTERIAL) OVER MAD RIVER BRIDGE NO. 166 WARREN COUNTY OF WASHINGTON				DRAWN:	DATE:	
				CRK	01/07	
				CHKD:	DATE:	
				DO	01/08	
LOCATION: TOWN OF WARREN			JOB NO.		DWG NO.	
PROJ NO. BRF 013-4(32)			548		GNI	
CUSTOMER: VT AOT					REV.	