



Casco Bay Steel Structures, Inc.
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Projects: Bridge #11 and Bridge #9, Chelsea, VT
 Project No. BHF 0169(10) and BHF 0169(9)
 CBSS Job: 696 & 697
 Subject: Structural Steel Painting Procedure – REV 1

Scope

This procedure is to be used to blast and paint the new tub girder structural steel on this project in accordance with Item 900.645, “Special Provision (QC/QA Cleaning and Painting Structural Components for Bridges 11 and 9)”

Industry Specifications

1. SSPC Visual Standards VIS 1; Guide and Reference Photographs for Steel Surfaces Prepared by Dry Abrasive Blast Cleaning
2. SSPC PA 2; Measurement of Dry Coating Thickness with Type 2 Electronic Gauge
3. SSPC SP 5 / NACE No.1; White Metal Blast Cleaning
4. ASTM D4541; Standard Test Method for Pull-Off Strength of Coatings
5. ASTM D4285; Standard Test Method for Indicating Oil or Water in Compressed Air

Material

1. Primer Coat shall be Carboline Carbozinc 859 Organic Zinc Primer
2. Intermediate Coat shall be Carboline Carboguard 893 Epoxy
3. Top Coat shall be Carboline Carbothane 133 VOC Aliphatic Polyurethane
4. Blast Media shall be Bellemare Steel Grit

Equipment

1. Equipment includes, but not limited to:
 - a. (2) 10,000 cfm dust collection systems with self-cleaning filters
 - b. 200hp electric compressor
 - c. 2,000 gallon air storage tank
 - d. Air dryer
 - e. Oil trap system
 - f. 3 outlet constant flow Schmidt blast pot
 - g. 4’ root vacuum grit handling and air wash cleaning unit
 - h. 16’ x 25’ x 50’ blast room with expandable wall
 - i. 20 barrel grit hopper
 - j. Hand-held bristle blaster
 - k. Multiple 30:1 + spray pumps
 - l. Thinner recycling system

Vermont Agency of Transportation
RECEIVED
 CK'D BY TYLin OK'D BY TYLin
 March 24, 2017
 RESUBMIT No Approved AsNoted
 BY Kristin Higgins DATE 3/27/2017

T.Y. LIN INTERNATIONAL
 THE STAMPED DOCUMENTS ARE HEREBY:
 APPROVED
 APPROVED AS NOTED
 REVISE AND RESUBMIT
 SEE TRANSMITTAL FOR ADDITIONAL INFORMATION AS APPLICABLE.
 THIS REVIEW IS FOR GENERAL CONFORMANCE WITH DESIGN CONCEPT ONLY. ANY DEVIATION FROM THE PLANS OR SPECIFICATIONS NOT CLEARLY NOTED BY THE CONTRACTOR HAS NOT BEEN REVIEWED. REVIEW BY THE ENGINEER SHALL NOT RELIEVE THE CONTRACTOR OF THE CONTRACTUAL RESPONSIBILITY FOR ANY ERRORS OR DEVIATION FROM THE CONTRACT REQUIREMENTS.
 JOSH OLUND March 24, 2017
 REVIEWER DATE