

GENERAL NOTES

CONSTRUCTION SPECIFICATIONS

ALL MATERIAL AND WORKMANSHIP TO BE IN ACCORDANCE WITH THE STATE OF VERMONT AGENCY OF TRANSPORTATION STANDARD SPECIFICATIONS FOR CONSTRUCTION DATED 2011 WITH LATEST REVISIONS AND THE AASHTO LRFD BRIDGE CONSTRUCTION SPECIFICATIONS FOR HIGHWAY BRIDGES 6th EDITION.

MATERIAL SPECIFICATIONS

- 1) ALL STEEL TO BE UNPAINTED AASHTO M270 (ASTM A709) GRADE 50 (UN).
- 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) TYPE 1 W/ A563 GRADE C NUTS, F436 (TYPE 1) WASHERS, F959 (TYPE 1) DIRECT TENSION INDICATORS (ALL GALVANIZED).
BOLTS & NUTS SHALL BE ROTATIONAL CAPACITY TESTED. DO NOT MIX NUTS & BOLTS FROM DIFFERENT CONTAINERS UNLESS ALL BOLTS & NUTS HAVE THE SAME LOT NUMBER.

BOLTS, NUTS AND WASHERS SHALL BE MECHANICALLY Δ GALVANIZED IN ACCORDANCE WITH ASTM B695, CLASS 50, TYPE I. GALVANIZED NUTS SHALL BE OVERTAPPED TO THE MINIMUM REQUIRED FOR FASTENER ASSEMBLY AND SHALL MEET THE REQUIREMENTS OF ASTM A153, SUPPLEMENT S1.

FABRICATION

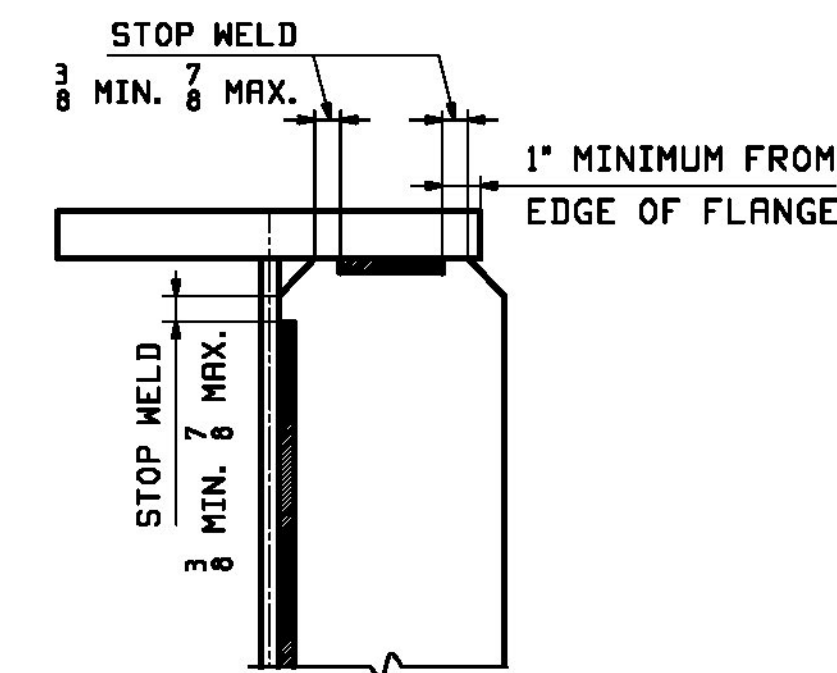
- 1). ALL HOLES SHALL BE DRILLED FULL SIZE (UN).
- 2). ALL FABRICATED STEEL MUST BE ASSEMBLED AND MATCH MARKED IN THE SHOP BEFORE SHIPPING.
- 3). PRIOR TO METALIZING, ALL CORNERS AND EDGES OF STEEL PLATES, SHAPES, ETC, SHALL BE GROUND TO 1/16" RADIUS.

CONNECTIONS

- 1) ALL CONNECTIONS SHALL BE MADE WITH A-325 HS BOLTS, INSTALLED PER SECTION 506.19(c).
- 2) BOLTS SHALL HAVE HEAVY HEX NUT, HEAVY HEX HEAD, DTI, AND AT LEAST ONE HARDENED FLAT WASHER EACH. WASHER TO BE PLACED UNDER TURNED ELEMENT.
- 3) PIECE MARKS WILL BE LOCATED AS SHOWN ON ERECTION DRAWINGS.

WELDING

- 1) THE CONFIGURATION OF THE WELD JOINTS AND ALL WELDING PROCEDURES SHALL BE IN ACCORDANCE WITH THE CURRENT AASHTO/AWS D1.5 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 "WT1" ON THIS DRAWING FOR WELD TERMINATION DETAIL.

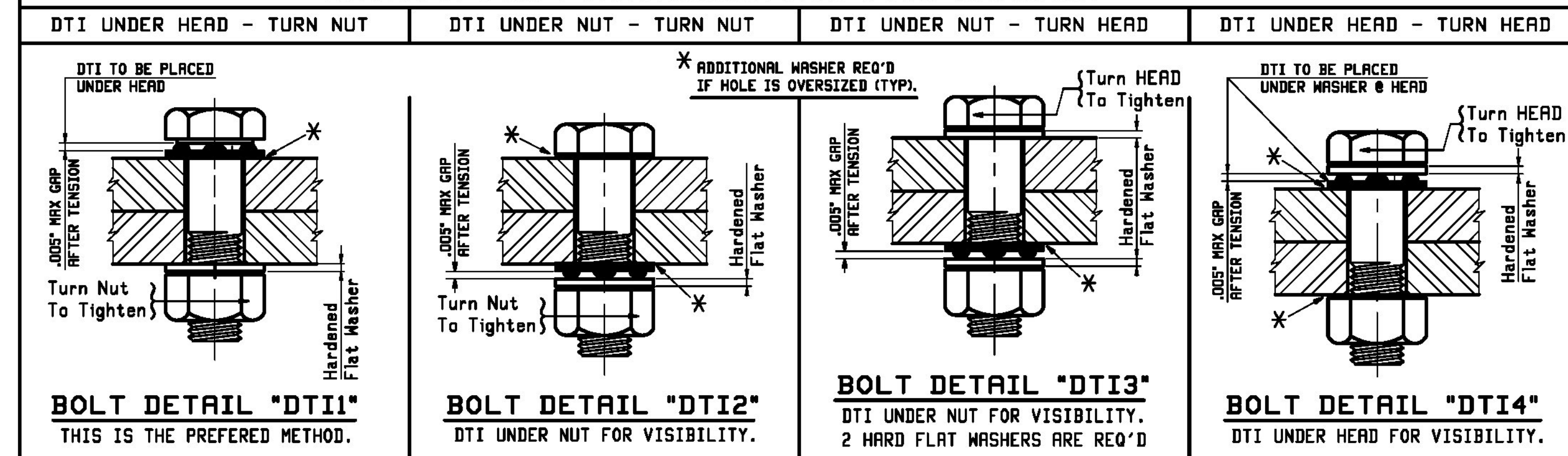


DETAIL "WS1"

METALIZING:

METALIZING, SURFACE PREP & SEAL COAT SHALL BE IN ACCORDANCE WITH CASCO BAY STEEL STRUCTURES, INC. APPROVED METALIZING PROCEDURE AND PER THE STANDARD SPECIFICATIONS.

DETAILS FOR POSITIONING DTI (LIW) WASHERS (PER ASTM F-959)



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

5/2/17	APPROVAL COMMENT	JTB	DBH		
REV. DATE	REMARKS	DWN	CHK	APVL	SHOP
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

Vermont Agency of Transportation
RECEIVED
CK'D BY _____ OK'D BY GFR
May 7, 2017
RESUBMIT No Approved
BY C. Carlson DATE 05/09/2017

STRUCTURE:	ROUTE VT 25B OVER WAITS RIVER RURAL MAJOR COLLECTOR BRIDGE No. 1 BRADFORD COUNTY OF ORANGE	DRAWN:	JTB	DATE:	02/27
LOCATION:	TOWN OF BRADFORD, VERMONT	CHKD:	DBH	DATE:	03/13
PROJ NO.	BF D191(29)	JOB NO.	706-1	DWG NO.	GN1
CUSTOMER:	A.L.ST. ONGE	REV.			Δ