

DRAWING LIST:	
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S-8	DIAPHRAGM SHOP DRAWINGS

16-181

STRAFFORD, VT

BRIDGE REPLACEMENT

GENERAL NOTES:

MATERIAL SPECIFICATIONS

1. ALL MATERIALS AND CONSTRUCTION SHALL CONFORM TO THE VERMONT AGENCY OF TRANSPORTATION 2011 STANDARD SPECIFICATIONS FOR CONSTRUCTION, THE 2014 AASHTO LRFD BRIDGE DESIGN SPECIFICATIONS AND THEIR LATEST REVISIONS
2. ALL MATERIAL SHALL BE AASHTO M270 (ASTM A709) GR.50 U.N.O.
3. ALL MATERIAL DENOTED "CVN" IN THE BILL OF MATERIAL SHALL MEET THE CHARPY V-NOTCH TESTING REQUIREMENTS OF ZONE 2, H FREQUENCY: 15 FT-LB AT 40 ° (UP TO 2" WELDED)
4. BOLTS SHALL BE H.S. ASTM A325 TYPE 1 - HEAVY HEX NUTS ASTM A563 GRADE DH - HARDENED WASHERS ASTM F436 TYPE 1 - DTI WASHERS ASTM F-959
5. A DTI INSPECTION REPRESENTATIVE SHALL BE PRESENT DURING INSTALLATION OF BOLTS THAT UTILIZE A DTI WASHER.
6. BOLTS AND NUTS SHALL BE SUBJECTED TO A ROTATIONAL CAPACITY TEST. DO NOT MIX NUTS AND BOLTS FROM DIFFERENT CONTAINERS UNLESS THEY HAVE THE SAME DESIGNATED LOT NUMBER.

FABRICATION

7. DIE STAMPING IS ALLOWED IN SPECIFIC LOCATIONS WITH THE APPROVAL OF THE ENGINEER.
8. ALL SHARP CORNERS OR EDGES SHALL BE ROUNDED TO A MINIMUM RADIUS OF 1/16" PER STANDARD SPEC. 506.14(b)
9. ALL PLATE MEMBERS SHALL BE CUT SO THAT THE PRIMARY DIRECTION OF ROLLING IS PARALLEL TO THE MAIN TENSILE OR COMPRESSIVE STRESS PER STANDARD SPEC. 506.08
10. FLANGE PLATE MATERIAL SHALL HAVE AN EDGE HARDNESS NOT GREATER THAN HRC 30 PER STANDARD SPEC. 506.09
11. ALL WELDING PROCEDURES SHALL BE IN ACCORDANCE WITH SUBSECTION 506.10
12. NON DESTRUCTIVE TESTING OF WELDS SHALL BE IN ACCORDANCE WITH ANSI/AASHTO/AWS D1.5 - SECTION 6.

FIELD CONNECTIONS

13. FIELD BOLTS SHALL HAVE A HEAVY HEX NUT, HEX HEAD, ONE HARDENED WASHER & ONE DTI WASHER EACH.
14. PIECE MARKS WILL BE LOCATED AS SHOWN IN FRAMING PLAN. ALL ERECTION MARKS, MATCH MARKS & WEIGHT MARKS MUST NOT BE EXPOSED IN THE FINISHED STRUCTURE.
15. ANY HOLES IN THE DIAPHRAGM STIFFENER PLATES AFTER REMOVAL OF THE TEMPORARY DIAPHRAGMS SHALL BE FILLED WITH BUTTON HEAD BOLTS (FURNISHED BY OTHERS). THESE BOLTS SHALL BE TIGHTENED IN ACCORDANCE WITH SUBSECTION 506.19.

COATINGS & FINISH

16. ALL STEEL IS TO BE HOT-DIP GALVANIZED IN ACCORDANCE WITH SUBSECTION 726.08.
17. ALL HARDWARE IS TO BE MECHANICALLY GALVANIZED IN ACCORDANCE WITH AASHTO M298, CLASS 50, TYPE 1.



TYP. ALL SHEETS

Vermont Agency of Transportation

RECEIVED

CK'D BY RSF, TAM OK'D BY JDG

February 9, 2017

RESUBMIT No Approved

BY Kristin Higgins DATE 2/14/2017

FINISH:	HOT-DIP GALVANIZED		
MATERIAL:	AASHTO M270 GR.50		
HOLES:	Ø15/16" U.N.O		
ELECTRODES:	PER WELD PROCEDURE	⚠	REVISED PER REVIEWER COMMENTS 1/6/17
WELDS:	PER WELD PROCEDURE	⚠	ISSUED FOR APPROVAL 12/6/16
SURFACE PREP:	SSPC-SP6	No.	Revision Date
Fabricator: ARC ENTERPRISES INC.		Detailer: DRAFTWORKS DETAILING 11 CHESTNUT ST. AMESBURY, MA	
Job Number:	16-181	Cover Sheet	Sheet No: 1 OF 10
Original Submittal Date:	12/6/16	VTRANS, STRAFFORD VT BRIDGE REPLACEMENT PROJ# BF 0177 (10)	
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		QC:	MILLER CONSTRUCTION
			Drawing No: C-1