

METRIC

GENERAL SHOP NOTES

SPECIFICATIONS:
 ALL MATERIAL AND WORKMANSHIP TO BE IN ACCORDANCE WITH THE STATE OF VERMONT, AGENCY OF TRANSPORTATION, STANDARD SPECIFICATIONS FOR CONSTRUCTION DATED 2001, AND ITS LATEST REVISIONS AND AASHTO "STANDARD SPECIFICATIONS FOR HIGHWAY BRIDGES", 17TH EDITION AND ITS LATEST REVISIONS.

MATERIAL:
 UNLESS NOTED OTHERWISE, ALL STEEL TO BE AASHTO M270M GRADE 345W.
 (T) INDICATES CHARPY V-NOTCH TESTING REQUIRED.

NON-DESTRUCTIVE TESTING:
 FLANGE AND WEB PLATE SPLICES TO BE RADIOGRAPHICALLY TESTED, AS CALLED FOR ON DRAWINGS PREFIXED 'FS' AND 'WC', BY H.S.I.I.

MAGNETIC PARTICLE INSPECTION IS REQUIRED ON AT LEAST 300 mm OF EVERY 3000 mm LENGTH OF FILLET WELDS AND 300 mm OF SUCH WELDS LESS THAN 3000 mm IN LENGTH ON GIRDER WEB TO FLANGE AND CONNECTION PLATES TO WEB AND FLANGE WELDS.

[DT] NOTE:
 HOLES MARKED [DT] ON DETAIL DRAWINGS ARE DRILLED FULL SIZE USING TEMPLATE WITH HARDENED BUSHINGS WHILE UNASSEMBLED.

[NCD] NOTE:
 HOLES MARKED [NCD] ON DETAIL DRAWINGS ARE DRILLED FULL SIZE USING A MACHINE CENTER, PORTABLE CNC DRILL OR DRILL LINE WHILE UNASSEMBLED.

CLEANING:
 ALL STEEL TO BE BLAST CLEANED TO SSPC-SP10 (NEAR WHITE), (ASTM D2200 GRADE SA 2-1/2). BLAST CLEANING ANCHOR PROFILE TO BE FROM 38 TO 64 MICROMETERS DEEP.

PAINTING:
 ALL STEEL TO BE PAINTED (UNLESS NOTED) WITHIN 3600 mm FROM THE END OF THE GIRDERS AT ABUTMENT 1, PIERS 7 AND 15 AND 14800 mm FROM THE END OF THE GIRDERS AT ABUTMENT 2, WITH A 3 COAT PAINT SYSTEM AS FOLLOWS:
 PRIME COAT: CARBOZINC 859 (ORGANIC ZINC) WITH 75 TO 150 MICROMETERS D.F.T.
 INTER. COAT: CARBOGUARD 888 (EPOXY) WITH 75 TO 250 MICROMETERS D.F.T.
 FINISH COAT: CARBOTHANE 133 HB (POLYURETHANE) WITH 75 TO 125 MICROMETERS D.F.T.
 FINISH COAT COLOR TO BE DARK BROWN, FEDERAL STANDARD 595, COLOR #20059.
 PRIME COAT ONLY WITHIN 75 mm OF OPEN HOLES.
 PRIME COAT TO BE APPLIED WITHIN 8 HOURS AFTER BLAST CLEANING.
 STRIPE COAT ALL EDGES OF PLATES, ANGLES OR OTHER SHAPES WITH SHARP EDGES, BOLTS, AND NUTS PRIOR TO THE APPLICATION OF THE FULL PRIME COAT.
 TOP FLANGE OF GIRDERS, AS SHOWN IN 'TYPICAL PAINT SECTION', SHALL RECEIVE A LIGHT RUST PREVENTIVE COAT OF PRIMER IN PAINTED AREAS, NOT TO EXCEED 38 MICROMETERS D.F.T.
 INTERMEDIATE AND FINISH COATS SHALL BE STAGGERED A MINIMUM OF 13 mm FROM THE FAYING SURFACES AND EACH OTHER.
 PAINT MANUFACTURER: THE CARBOLINE CO. ST. LOUIS, MO.

SHOP PROCEDURE:
 ALL FLANGE AND WEB PLATE SPLICES TO BE MADE BEFORE FINAL FITTING AND WELDING INTO GIRDER.
 CAMBER TOLERANCE: -0 mm TO +19 mm
 ALL RE-ENTRANT CUTS TO HAVE 25 MIN. RADIUS.
 BEARING AREA, AS NOTED ON GIRDER DETAILS, INDICATES AREA THAT MUST BE FLAT AND TRUE TO RECEIVE SOLE PLATE.
 ONLY LOW STRESS DIE STAMPS MAY BE USED FOR MARKING IN AREAS NOT EXPOSED ON THE FINISHED STRUCTURE.
 [DOR] INDICATES DIRECTION OF ROLLING.
 [CG] INDICATES CORNER GRINDING.
 CORNER GRINDING IS REQUIRED FOR ALL MAIN MEMBER GIRDER FLANGE PLATES AND SPLICE PLATES AND SECONDARY MEMBERS IN PAINTED AREAS, AS NOTED [CG] - NOTHING ELSE.

IDENTIFICATION OF HOLE PLACEMENT:
 UNLESS NOTED OTHERWISE, BOLT HOLES IN MATERIAL 16mm OR LESS IN THICKNESS MAY BE CNC (COMPUTER NUMERICALLY CONTROLLED) PUNCHED OR CNC DRILLED FULL SIZE UNASSEMBLED. ALL MATERIAL THICKER THAN 16mm IS TO BE DRILLED.

INSPECTION:
 SHOP INSPECTION BY THE VERMONT AGENCY OF TRANSPORTATION

WELDING:
 ALL WELDING IS TO CONFORM TO AWS D1.5-02.
 WELDING METHODS, PROCEDURES, AND MATERIALS SHALL COMPLY WITH THE SPECIFIC PROCEDURE DESIGNATED IN THE WELD SYMBOL TAIL.
 FOR WELDING STIFFENERS AND CONNECTION PLATES TO GIRDERS, SEE TYPICAL WELDING DETAIL.
 FOR WELDING CROSSFRAMES, SEE SECONDARY MEMBER WELDING DETAIL.

DRAWING REFERENCE:
 FLANGE SPLICES -PREFIXED 'FS'
 WEB CAMBERS -PREFIXED 'WC'
 GIRDER JOB STANDARDS -PREFIXED 'X'
 CROSSFRAME JOB STDS. -PREFIXED 'M'
 SHOP ASSEMBLY -PREFIXED 'SA'
 WELDING PROCEDURE -PREFIXED 'WP'

△ CONTRACT PLAN LENGTHS HAVE BEEN INCREASED AS REQUIRED TO SATISFY MEAN TEMPERATURE LENGTH AT FORTY-FIVE DEGREES WITH FABRICATION AT SIXTY-EIGHT DEGREES MEAN TEMPERATURE

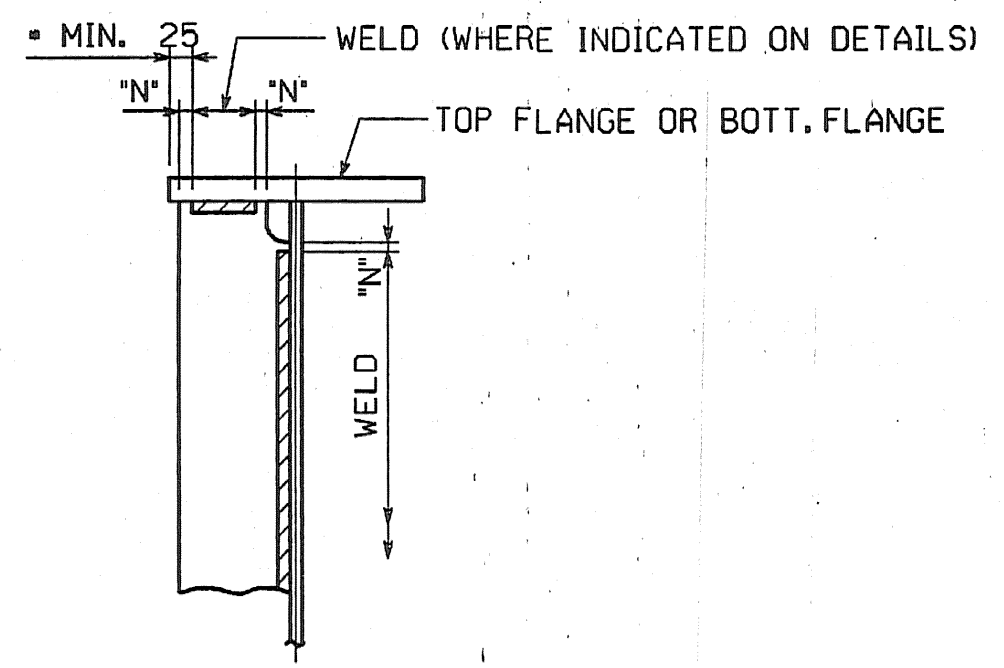
(LIGHT RUST PREVENTIVE COAT OF PRIMER (WHERE REQUIRED))

TYP. PAINT SECTION

SHOP DRAWING REVIEW

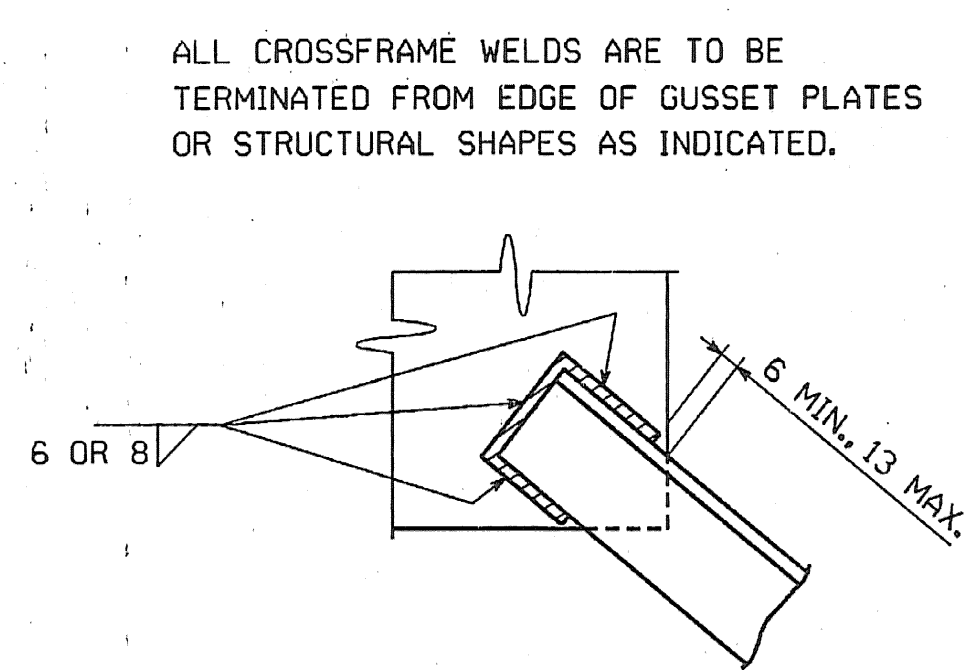
APPROVED FOR CONSTRUCTION BY THE CONTRACTOR AND REVIEWED BY THE ARCHITECT AND ENGINEER. THIS REVIEW IS LIMITED TO THE INFORMATION PROVIDED AND DOES NOT CONSTITUTE A GUARANTEE OF THE ACCURACY OF THE DRAWINGS OR THE QUALITY OF THE WORK. THE CONTRACTOR IS RESPONSIBLE FOR THE PROTECTION OF THE DRAWINGS AND FOR THE PROTECTION OF THE WORK. THE CONTRACTOR SHALL BE RESPONSIBLE FOR THE PROTECTION OF THE DRAWINGS AND FOR THE PROTECTION OF THE WORK. THE CONTRACTOR SHALL BE RESPONSIBLE FOR THE PROTECTION OF THE DRAWINGS AND FOR THE PROTECTION OF THE WORK.

DATE: 11/16/04



• "N" = 6 MIN., 13 MAX. (U.N.) •

STIFFENER WELDING DETAIL
 • WELDS MUST STOP 25 MINIMUM FROM EDGE OF FLANGE



SECONDARY MEMBER WELDING DETAIL

△			
△			
△	REVISED FOR TEMP. ADJ. NOTE	JSA	9-17-04
NO.	REVISION	BY	DATE
GENERAL SHOP NOTES VT 78 OVER MISSISSOUI BAY, BRIDGE NO. 2 VT 78 STA.10+970.425 TO STA.12+059.775 TOWNS OF ALBURG AND SWANTON COUNTIES OF GRAND ISLE AND FRANKLIN STATE OF VERMONT, AGENCY OF TRANSPORTATION			
STATE CONTRACT OR REF. NO. BRF-036-1(1)			
CONTRACTOR CIAMBRO CORPORATION			
IN CHARGE: GLIDDEN (IH)	MADE BY: KMA	CHK'D BY: SJA	DATE: 7/21/04
CONTRACT NUMBER: VT-04057-1,2&3	DRAWING NUMBER: GN1 OF GN1		

BY: dpanster
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