

METRIC

1. ALL DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE NOTED.
2. ALL WEIGHTS ARE IN KILOGRAMS.

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| FED. ROAD DIV. NO. | STATE | FED. AID PROJ. NO. |
| | VT | |

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 1995, AND ITS LATEST REVISIONS.

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

MAGNETIC PARTICLE INSPECTION IS REQUIRED ON AT LEAST 300 mm OF EVERY 3000 mm LENGTH OF FILLET WELD 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.

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

CLEANING:
ALL STEEL TO BE BLAST CLEANED TO SSPC-SP10 (NEAR WHITE).

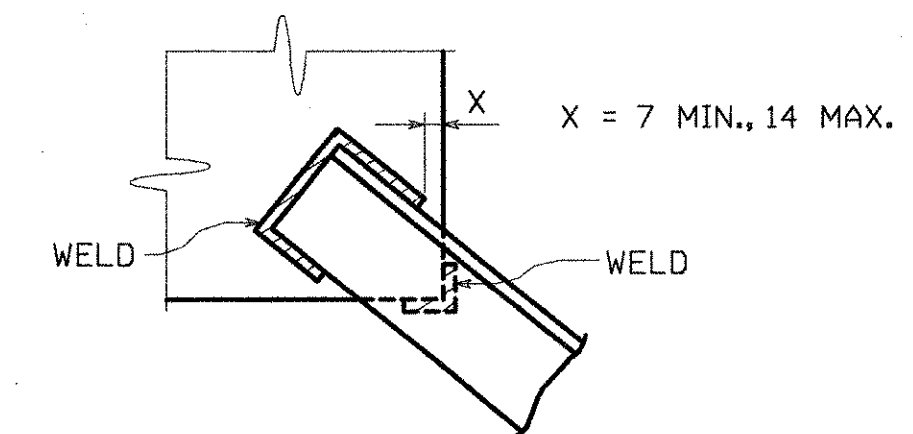
PAINTING:
NO PAINT

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 LEVELING PLATE.
ONLY LOW STRESS DIE STAMPS MAY BE USED FOR MARKING IN AREAS NOT EXPOSED ON THE FINISHED STRUCTURE.

INSPECTION:
SHOP INSPECTION BY TO BE DETERMINED

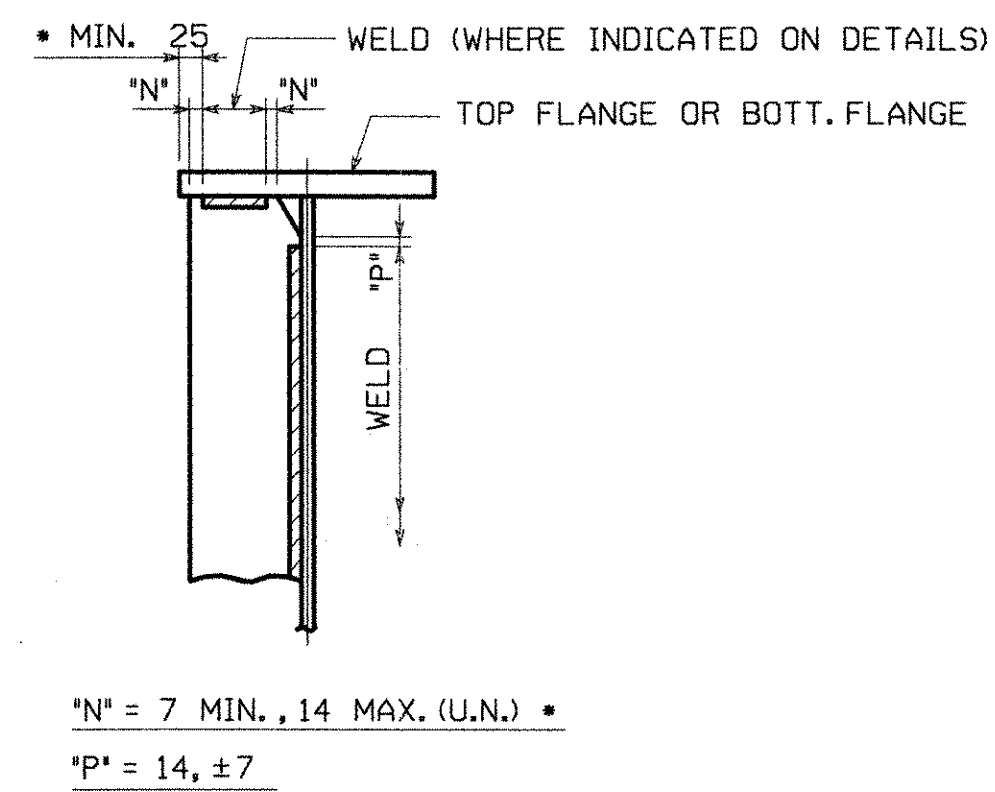
WELDING:
ALL WELDING IS TO CONFORM TO AWS D1.5-96.
WELDING METHODS, PROCEDURES, AND MATERIALS SHALL COMPLY WITH THE SPECIFIC PROCEDURE DESIGNATED IN THE WELD SYMBOL TAIL.
FOR WELDING STIFFENERS AND CONNECTION PLATES TO GIRDERS, SEE STIFFENER WELDING DETAIL.

ALL CROSSFRAME WELDS ARE TO BE TERMINATED FROM EDGE OF GUSSET PLATES, FILL PLATES OR ANGLES AS INDICATED.



SECONDARY MEMBER WELDING DETAIL

DRAWING REFERENCE:
FLANGE SPLICES -PREFIXED 'FS'
WEB CAMBERS -PREFIXED 'WC'
GIRDER JOB STANDARDS -PREFIXED 'X'
CROSSFRAME JOB STDS. -PREFIXED 'M'



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

RECEIVED
 CK'D BY *awc* OK'D BY *AP*
 NOV 16 1999
 RESUBMIT _____ APPROVED *Δ*
 BY _____ DATE: 12/14/99

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|--|----------------------------|------------|----------------|
| NO. | REVISION | BY | DATE |
| | | | |
| HIGH STEEL STRUCTURES, INC. | | | |
| 1770 Hempstead Road Lancaster, PA 17605-0008 Phone 717/299-5281 A Division of High Industries, Inc. | | | |
| GENERAL SHOP NOTES | | | |
| VT. 116 OVER NEW HAVEN RIVER | | | |
| VT. 116 STA. 1+255.00 TO STA. 1+299.00 | | | |
| TOWN OF BRISTOL, BRIDGE NO. 10 | | | |
| STATE OF VERMONT | | | |
| AGENCY OF TRANSPORTATION | | | |
| STATE CONTRACT OR REF. NO. | PROJECT NO. ER 021-1(13) | | 079 |
| CONTRACTOR BECK & BELLUCCI, INC. | | | |
| IN CHARGE: ALLEN (IH) | MADE: <i>Kma</i> | CHK'D: SLK | DATE: 10-11-99 |
| CONTRACT NUMBER: VT-99109-1 | DRAWING NUMBER: GN1 OF GN1 | | |