

METRIC

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

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 2001, AND ITS LATEST REVISIONS, AND THE AASHTO STANDARD SPECIFICATIONS FOR HIGHWAY BRIDGES, 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 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.

MT IS ALSO REQUIRED ON CROSS FRAME WELDS ON CURVED GIRDERS

MATERIAL:

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

RA NOTE:

HOLES MARKED RA ON DETAIL DRAWINGS TO BE SUB-PUNCHED/SUB-DRILLED 6# UNDER SIZE AND REAMED TO FULL SIZE OR DRILLED FROM SOLID WITH CONNECTING PARTS ASSEMBLED AND MATCH MARKED.

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 2500mm 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 COLOR TO BE DARK BROWN, FEDERAL STANDARD 595, COLOR *20059.
PRIME COAT ONLY WITHIN 75mm 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 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 THE PAINTED AREAS, NOT TO EXCEED 38 MICROMETERS D.F.T.
INTERMEDIATE AND FINISH COATS SHALL BE STAGGERED A MINIMUM OF 12mm FROM THE FAYING SURFACES OF 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.

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.

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.

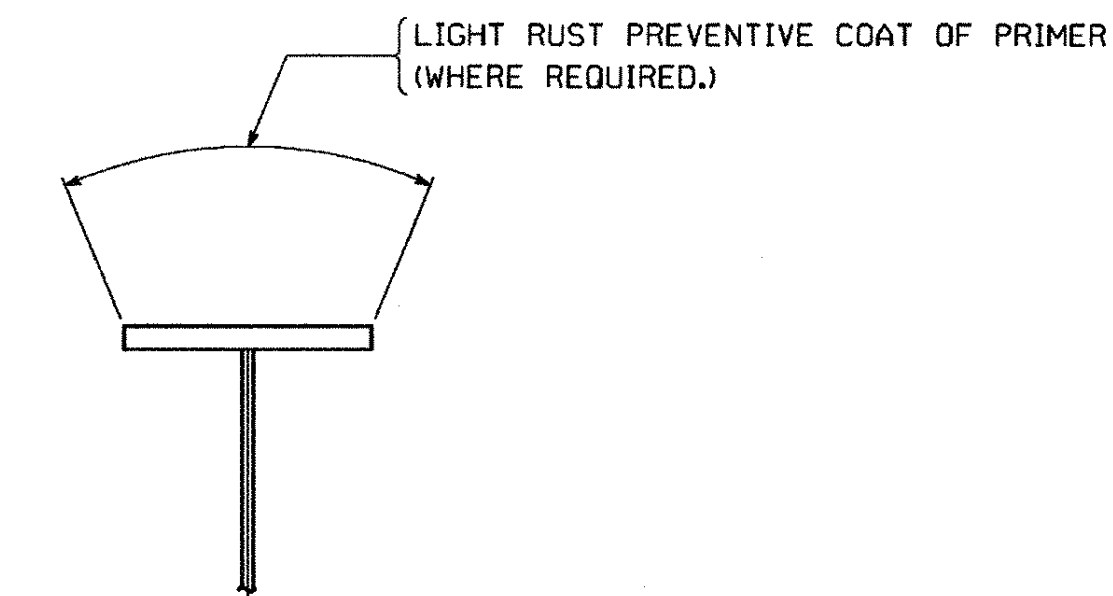
DRAWING REFERENCE:

FLANGE SPLICES -PREFIXED 'FS'
WEB CAMBERS -PREFIXED 'WC'
GIRDER JOB STANDARDS -PREFIXED 'X'
CROSSFRAME JOB STDS. -PREFIXED 'M'
SHOP ASSEMBLY -PREFIXED 'SA'
HORIZONTAL CURVE -PREFIXED 'HC'
WELDING PROCEDURE -PREFIXED 'WP'

Reviewed
 Rejected
 Furnish as Corrected
 Revise and Resubmit
 Submit Specified Item

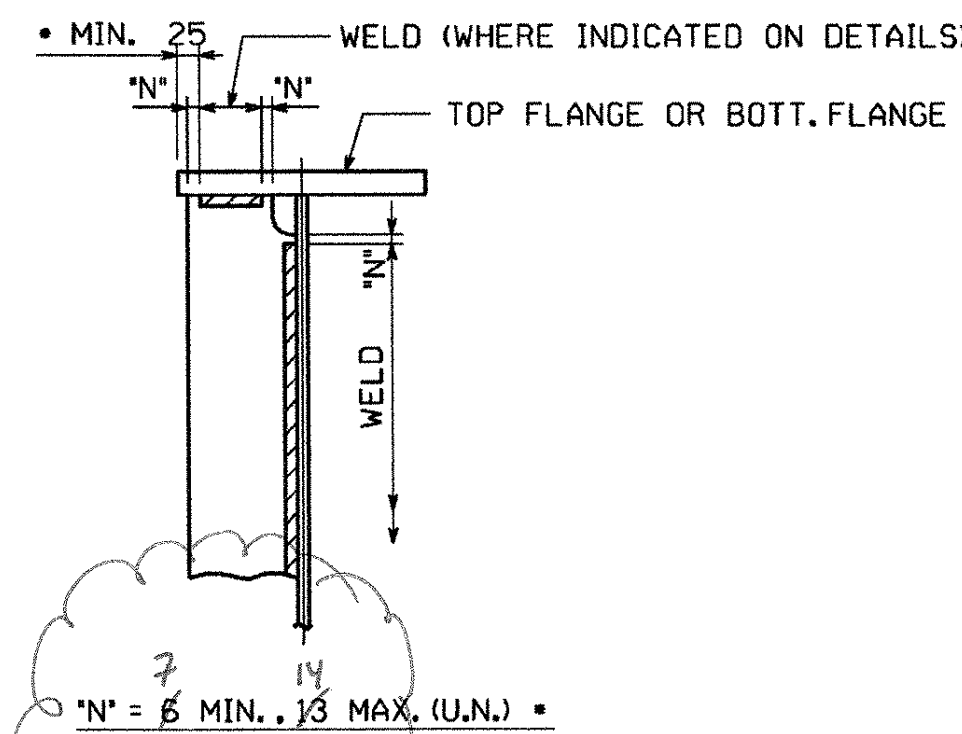
This review is only for general conformance with the design contract and the information given in the Construction Documents. Corrections or comments made on the shop drawings during this review do not relieve the contractor from compliance with the requirements of the plans and specifications. Review of a specific item shall not include review of an assembly of which the item is a component. The contractor is responsible for dimensions to be confirmed and correlated at the job site. Information that pertains solely to the fabrication process or to the means, methods, techniques, sequences and procedures of construction; coordination of the Work with that of all other trades and performing all work in a safe and satisfactory manner.

McFarland-Johnson, Inc.
Date: 6/10/05
By: CCB



TYP. PAINT SECTION

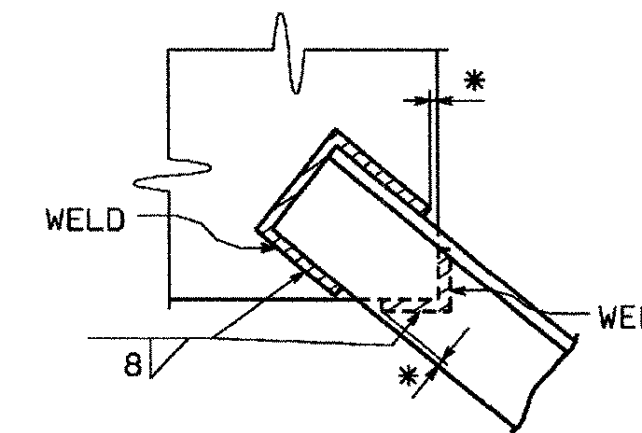
VTrans RECEIVED
OK'D BY: JWC
JUN 21 2005
RESUBMIT: _____ APPROVED: _____
BY: _____ DATE: _____



STIFFENER WELDING DETAIL

* WELDS MUST STOP 25 MINIMUM FROM EDGE OF FLANGE

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



* NO WELD FOR 7 MIN., 14 MAX.

SECONDARY MEMBER WELDING DETAIL

NO.	REVISION	BY	DATE

1770 Hempstead Road
Lancaster, PA 17605-0008
Phone 717/299-5211
HIGH STEEL STRUCTURES, INC. **HSI**
A Division of High Industrial, Inc.

GENERAL SHOP NOTES
U.S. RTE. 5 (BRIDGE #60) OVER LULLS BROOK
U.S. RTE. 5 STA. 3+080.77 TO STA. 3+123.110
TOWN OF HARTLAND
WINDSOR COUNTY, VERMONT
STATE OF VERMONT, AGENCY OF TRANSPORTATION
STATE CONTRACT OR REF. NO. PROJECT NO. BRS-0113(22)
CONTRACTOR MILLER CONSTRUCTION, INC.
IN CHARGE: GLIDDEN (IH) MADE BY: Kma CHK'D BY: SJA DATE: 3/4/05
CONTRACT NUMBER: VT-05017-1 DRAWING NUMBER: GN1 OF GN1

11855