

GENERAL SHOP NOTES

SPECIFICATIONS:

DESIGN SPECIFICATIONS: THE AASHTO LRFD BRIDGE DESIGN SPECIFICATIONS, 4TH EDITION, AND ITS LATEST REVISIONS.
 ALL MATERIAL AND WORKMANSHIP TO BE IN ACCORDANCE WITH THE STATE OF VERMONT, AGENCY OF TRANSPORTATION, STANDARD SPECIFICATIONS FOR CONSTRUCTION DATED 2006, WITH CURRENT MODIFICATIONS AND ADDITIONS.

MATERIAL:

UNLESS NOTED OTHERWISE, ALL STEEL TO BE AASHTO M270 GRADE 50W
 (T) INDICATES ZONE 2 CHARPY V-NOTCH TESTING REQUIRED.

SHOP PROCEDURE:

ALL FLANGE AND WEB PLATE SPLICES TO BE MADE BEFORE FINAL FITTING AND WELDING INTO GIRDER.
 CAMBER TOLERANCE: -0" TO +3/4"
 ALL RE-ENTRANT CUTS TO HAVE 1" MIN. RADIUS.
 BEARING AREA, AS NOTED ON GIRDER DETAILS, INDICATES AREA THAT MUST BE FLAT AND TRUE TO RECEIVE SOLE PLATE.

DOR INDICATES DIRECTION OF ROLLING.

(CG) INDICATES CORNER GRINDING.
 CORNER GRINDING IS REQUIRED FOR ALL MAIN MEMBER FLANGE PLATES, FIELD SPLICE PLATES AND CROSSFRAMES.

INSPECTION:

SHOP INSPECTION BY TO BE DETERMINED

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:

ALL HOLES IN ALL MEMBERS SHALL BE DRILLED.

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 1'-0" OF EVERY 10'-0" LENGTH OF FILLET WELDS AND 1'-0" OF SUCH WELDS LESS THAN 10'-0" IN LENGTH ON GIRDER WEB TO FLANGE, CONNECTION PLATES TO WEB AND FLANGE AND CROSSFRAME WELDS. TESTING PER THE YOKE METHOD, USING DC.

[RA] NOTE:

HOLES MARKED [RA] ON DETAIL DRAWINGS TO BE SUB-PUNCHED/SUB-DRILLED 1/4" UNDER SIZE AND REAMED TO FULL SIZE OR DRILLED FROM SOLID WITH CONNECTING PARTS ASSEMBLED AND MATCH MARKED.

CLEANING:

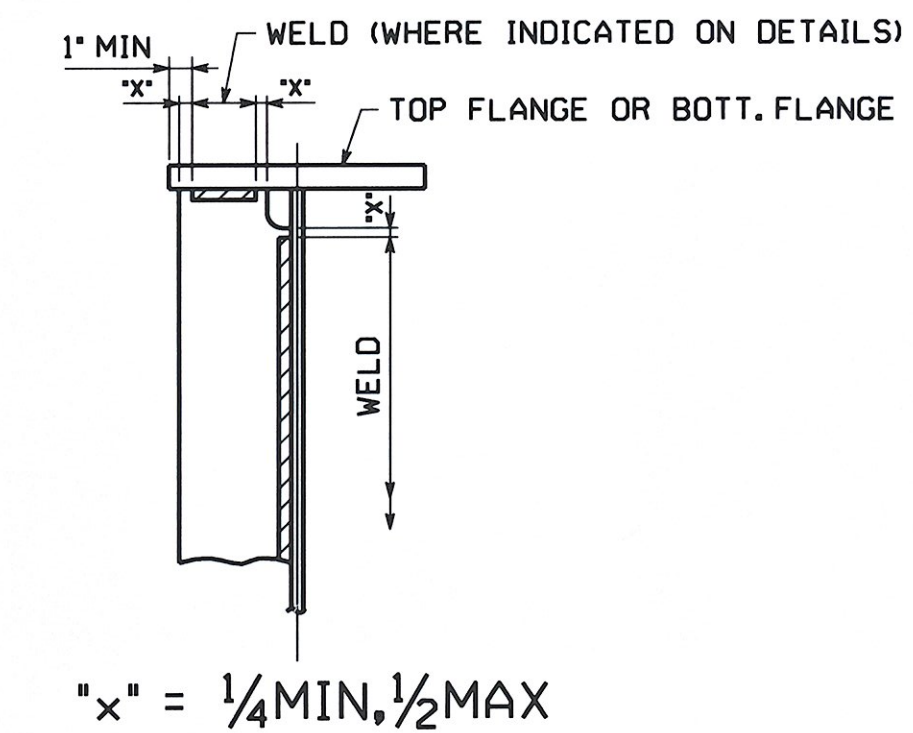
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PAINTING:

NO PAINT

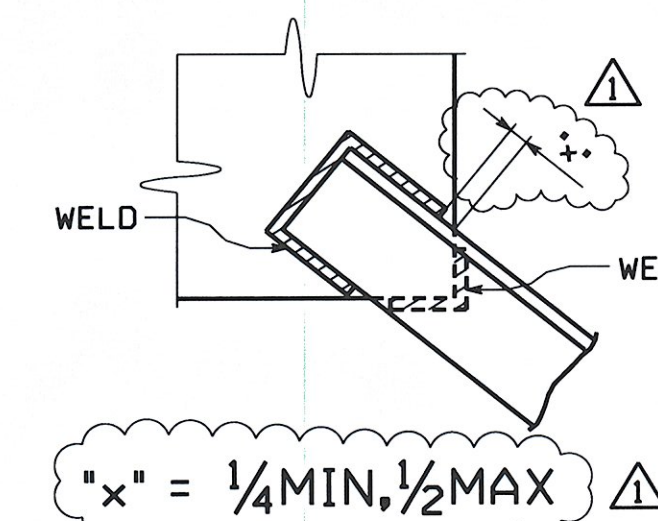
DRAWING REFERENCE:

- 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'



STIFFENER WELDING DETAIL
 WELDS MUST STOP 1" MIN. FROM THE EDGE OF FLANGE.

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



SECONDARY MEMBER WELDING DETAIL

RECEIVED
 OK'D BY JEL OK'D BY JEL
 AUG 18 2008
 RESUBMIT ✓ APPROVED ✓
 BY KMH DATE 8/19/08

△					
△					
△	REVISED SECONDARY MEMBER WELDING DETAIL	MGK	WW	8/2/08	
NO.	REVISION	BY	CHK'D	DATE	
HOLES					
BOLTS					
COATING	VT ROUTE 100 (MINOR ARTERIAL) OVER WHITE RIVER VT ROUTE 100 STA. 141+39.00 TO STA. 143+61.00 TOWN OF STOCKBRIDGE, COUNTY OF WINDSOR, VERMONT STATE OF VERMONT AGENCY OF TRANSPORTATION				
SCALE	STATE CONT. PROJECT NO. (STP) BRP FED. AID OR REF. NO. 013-4(21)	PROJ. NO.	PROJ. MGR	PROJ. NO.	
SCALE N.T.S.	GENERAL CONTRACTOR WINTERSET, INC.	PROJ. MGR	HSSI PROJ. MGR	DEB KUPRES	
SHPMT	1 DRAWING MANAGER KREIDER (IH)	MADE BY	Kma	CHK'D BY	SJA DATE 5/22/08
STATE	VT HSSI PROJECT NUMBER S-1080077	HSSI STRUCT. ID	A	DRAWING NUMBER	GN1 OF GN1

ENGLISH

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BY: beever

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