

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, WITH CURRENT MODIFICATIONS AND ADDITIONS.

MATERIAL:

UNLESS NOTED OTHERWISE, ALL STEEL TO BE AASHTO M270M GRADE 345W.
(T) INDICATES ZONE 2 CHARPY V-NOTCH TESTING REQUIRED.

SHOP PROCEDURE:

CAMBER TOLERANCE: -0 mm TO +19 mm
FOR SOLE PLATE DETAILS, SEE DRAWING 1.
ALL CORNERS OF PLATES SHALL BE GROUND TO 1.6 mm RAD.
ONLY LOW STRESS DIE STAMPS MAY BE USED FOR MARKING IN AREAS NOT EXPOSED ON THE FINISHED STRUCTURE.

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 STRINGERS, SEE TYPICAL 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.

NON-DESTRUCTIVE TESTING:

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 CONNECTION PLATES TO WEB AND FLANGE WELDS. TESTING PER THE YOKE METHOD, USING DC.

CLEANING:

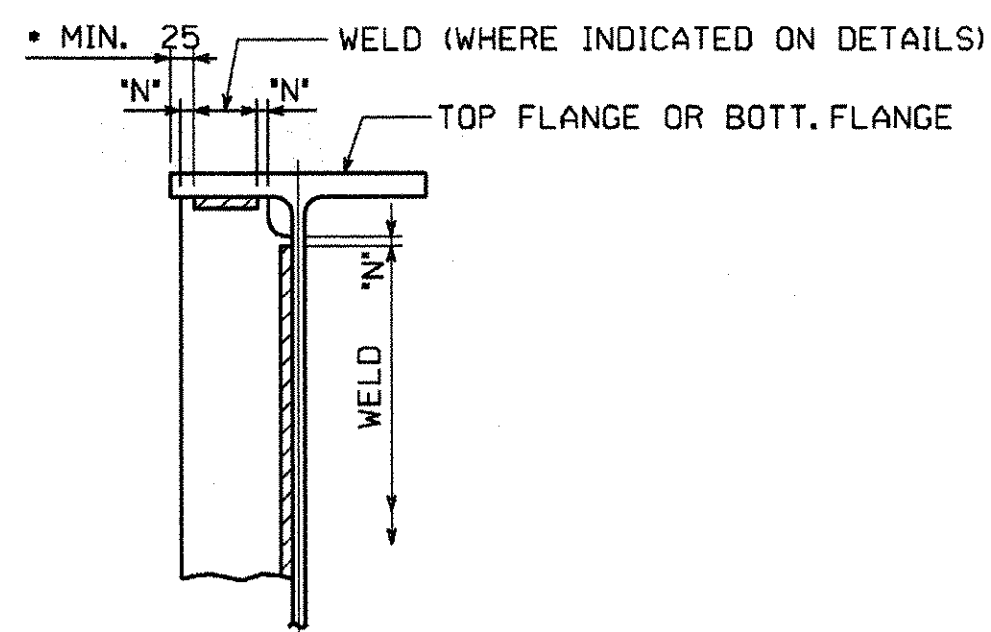
ALL STEEL TO BE BLAST CLEANED TO SSPC-SP10 (NEAR WHITE).

PAINTING:

NO PAINT

DRAWING REFERENCE:

STRINGER JOB STANDARDS -PREFIXED 'Z'
WELDING PROCEDURE -PREFIXED 'WP'



'N' = 6 MIN., 13 MAX. (U.N.)

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

RECEIVED
 OK'D BY: WRS OK'D BY: JTR
 FEB 14 2006
 RESUBMIT: _____ APPROVED:
 BY: WRS DATE: 2/14/06

NO.	REVISION	BY	DATE
1770 Hemstead Road Lancaster, PA 17605-0008 Phone 717/299-5211 HIGH STEEL STRUCTURES, INC. A Division of High Industries, Inc.			
GENERAL SHOP NOTES			
VERMONT ROUTE 100 OVER DOWSVILLE BROOK			
VERMONT ROUTE 100 STA. 0+239.930 TO STA. 0+260.070			
TOWN OF DUXBURY, WASHINGTON COUNTY, VERMONT			
STATE OF VERMONT			
AGENCY OF TRANSPORTATION			
STATE CONTRACT OR REF. NO. BRIDGE NO. 187, DUXBURY STP 013-4 (24)			
CONTRACTOR AUSTIN CONSTRUCTION, INC.			
IN CHARGE: BRITIGAN (IH) MADE: <u>Kma</u> CHK'D: <u>SJA</u> DATE: <u>2/3/06</u>			
CONTRACT NUMBER: VT-05124-1 DRAWING NUMBER: GN1 OF GN1			

07455