

ENCL. 8
 PL. DATED: 1/12/2015 2:58:05 PM
 BY: mcrs@vt.gov
 SHEET NO: 8
 PROJECT: PAVING 983224 FWD 983225 SHARPECT 983226

GENERAL SHOP NOTES

SPECIFICATIONS:
 DESIGN SPECIFICATIONS: AASHTO LRFD BRIDGE DESIGN SPECIFICATIONS, DATED 2012, AND THEIR LATEST REVISIONS.
 ALL MATERIAL AND WORKMANSHIP TO BE IN ACCORDANCE WITH THE STATE OF VERMONT, AGENCY OF TRANSPORTATION, STANDARD SPECIFICATIONS FOR CONSTRUCTION DATED 2011, WITH CURRENT MODIFICATIONS AND ADDITIONS AND SPECIAL PROVISIONS.

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

DRILLING, PUNCHING, AND REAMING HOLE PROCEDURES:
 UNLESS NOTED OTHERWISE, BOLT HOLES IN MATERIAL 5/8" OR LESS IN THICKNESS MAY BE CNC (COMPUTER NUMERICALLY CONTROLLED) PUNCHED OR CNC DRILLED FULL SIZE UNASSEMBLED. ALL MATERIAL THICKER THAN 5/8" IS TO BE DRILLED.

CLEANING:
 ALL STEEL: SSPC-SP1, AS NECESSARY.
 ALL STEEL: SSPC-SP10, FINAL SURFACE PREP.

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.
 ONLY LOW STRESS DIE STAMPS MAY BE USED FOR MARKING IN AREAS NOT EXPOSED ON THE FINISHED STRUCTURE, SUCH AS EDGES OF STIFFENERS THAT WILL COME IN CONTACT WITH THE FLANGE OR WEB.

PAINTING:
 NO PAINT

INSPECTION:
 SHOP INSPECTION BY TO BE DETERMINED

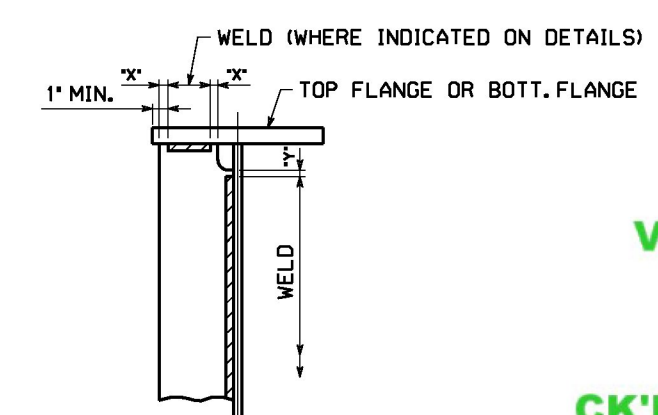
WELDING:
 ALL WELDING IS TO CONFORM TO AWS D1.5 (2010).
 WELDING METHODS, PROCEDURES, AND MATERIALS SHALL COMPLY WITH THE SPECIFIC PROCEDURE DESIGNATED IN THE WELD SYMBOL TAIL.
 FOR WELDING STIFFENERS AND CONNECTION PLATES TO GIRDERS, SEE STIFFENER WELDING DETAIL.
 FOR WELDING CROSSFRAMES, SEE CROSSFRAME WELDING DETAIL.

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

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.

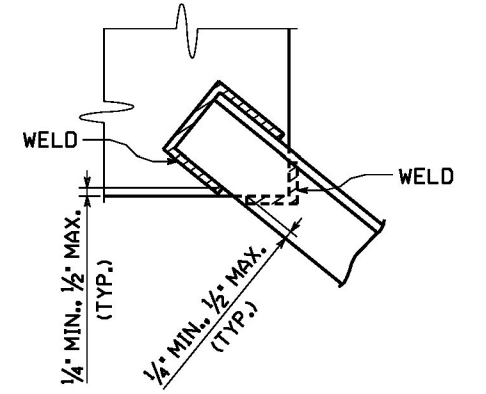
MAGNETIC PARTICLE INSPECTION IS REQUIRED ON AT LEAST 1'-0" OF EVERY 10'-0" LENGTH OF FILLET WELDS AND 1'-0" OF SUCH WELDS LESS THAN 10'-0" IN LENGTH ON GIRDER WEB TO FLANGE AND CONNECTION PLATES TO WEB AND FLANGE WELDS. TESTING PER THE YOKE METHOD, USING DC.

THICKNESS INCHES (t)	MINIMUM COLD-BENDING RADI			
	UP TO 3/4"	OVER 3/4" TO 1", INCL.	OVER 1" TO 2", INCL.	OVER 2"
ASTM A709/ AASHTO M270 GRADE				
36	1.5t	1.5t	1.5t	2.0t
50, 50W, HPS50W	1.5t	1.5t	2.0t	2.5t
HPS70W	1.5t	1.5t	2.5t	3.0t
100, 100W	1.75t	2.25t	4.5t	5.5t



X = 3/8" MIN., 7/8" MAX.
 Y = 3/8" MIN., 7/8" MAX.
STIFFENER WELDING DETAIL

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



CROSSFRAME MEMBER WELDING DETAIL

Vermont Agency of Transportation
RECEIVED
 CK'D BY CLB OK'D BY DRP
 January 23, 2015
 RESUBMIT NO Approved
 BY C. CARLSON DATE 01/23/15

APPROVAL	CHK'D	REV. NOTES	MJD	MGK	1/12/15
NO.	REVISION	BY	CHK'D	DATE	
HOLE					
BOLTS					
COATING					
CODE(S)					
SCALE	STATE CONT. BRP 02/35 (11)	FED. AID PROJ. NO.			
N.T.S.	GENERAL CONTRACTOR CCS CONSTRUCTORS LLC	PROJ. MGR	KEN GLIDDEN		
VT	DRAWING MANAGER DAVE PAINTER (IH)	MADE BY	SJA	CHK'D BY	KCL
	DATE	11/5/14			
	PROJECT NUMBER	S-1140166A-1	DRAWING NUMBER	GN1 OF GN1	