

ENGLISH

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

GENERAL SHOP NOTES

SPECIFICATIONS:

ALL MATERIAL AND CONSTRUCTION SHALL CONFORM TO THE AGENCY OF TRANSPORTATION'S STANDARD SPECIFICATIONS FOR CONSTRUCTION, DATED 2001, AND ITS LATEST REVISIONS, AND THE AASHTO DESIGN CODE SHALL BE THE AASHTO STANDARD SPECIFICATIONS FOR HIGHWAY BRIDGES, SEVENTEENTH EDITION, AND ITS LATEST REVISIONS.

MATERIAL:

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

NON-DESTRUCTIVE TESTING:

FLANGE AND WEB PLATE SPLICES TO BE ULTRASONICALLY AND 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 $\frac{1}{4}"$ 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), AFTER FABRICATION.

PAINTING:

NO PAINT

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 MAIN MEMBER FLANGE PLATES, ALL FIELD SPLICE PLATES AND CROSSFRAME GUSSETS. ALL SHARP CORNERS AND EDGES THAT ARE MARRED, CUT OR ROUGHENED IN HANDLING SHALL BE GROUND TO $1/16"$ RADIUS BY GRINDING. IDENTIFICATION MARKS ON UNPAINTED STEEL SHALL BE IMPRESSED INTO THE MEMBER WITH A LOW-STRESS STAMP IN A NON-STRESSED OR LOW STRESSED AREA OF THE MEMBER. TIGHT FIT FOR ALL INTERMEDIATE CONNECTION P'S AND ABUTMENT BEARING STIFFENERS SHALL CONFORM TO AWS SECTION 3.5.1.10

TIGHT FIT FOR PIER BEARING STIFFENERS SHALL CONFORM TO STATE OF VERMONT STANDARD SPECIFICATIONS FOR CONSTRUCTION, SECTION 506.12 (g), 1

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 STIFFENER WELDING DETAIL.
FOR WELDING CROSSFRAMES, SEE SECONDARY MEMBER WELDING DETAIL.

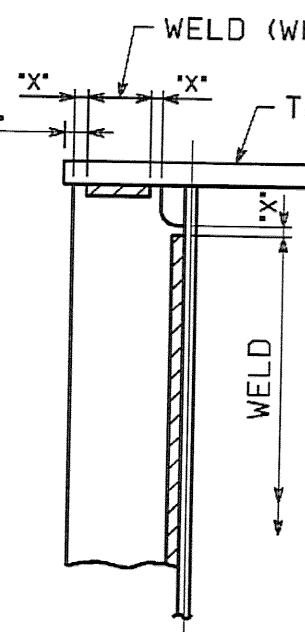
IDENTIFICATION OF HOLE PLACEMENT:

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.

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' |

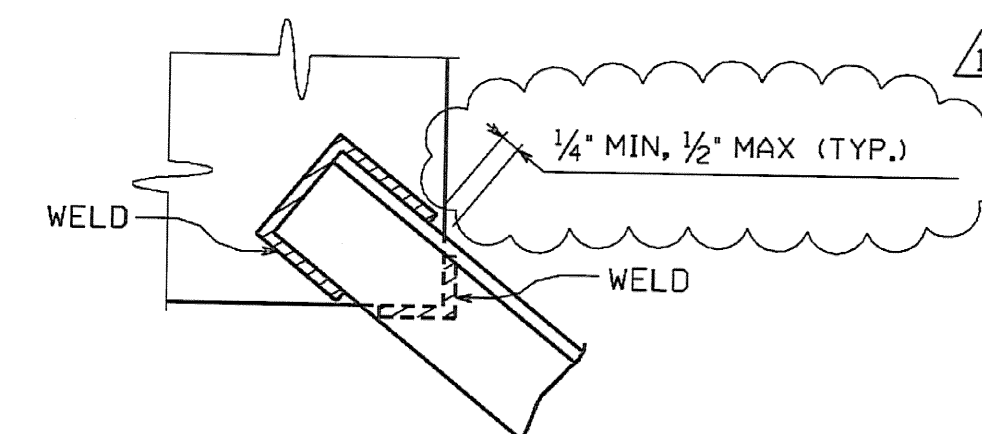
WELD (WHERE INDICATED ON DETAILS)
MAINTAIN 1" MINIMUM FROM EDGE OF FLG. TOP FLANGE OR BOTT. FLANGE



$$X = \frac{3}{8}" \text{ MIN. } \frac{7}{8}" \text{ MAX}$$

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

RECEIVED
CHK'D BY: JK OK'D BY: _____
JAN 30 2007
RESUBMIT _____ APPROVED JK
BY: WY DATE: 1-31-2007

NO.	REVISION	BY	DATE
1	ADDED NOTES TO SPECIFICATIONS AND SHOP PROCEDURES; ADDED DIMENSIONS TO DETAIL	MF	1-19-07

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

GENERAL SHOP NOTES	
VT. 12 (MAIN ST.) OVER THIRD BRANCH OF THE WHITE RIVER	
VT. 12 STA. 15+36.00 TO STA. 17+36.00	
TOWN OF RANDOLPH, ORANGE COUNTY, VT. BRIDGE NO. 42	
STATE OF VERMONT	
AGENCY OF TRANSPORTATION	
STATE CONTRACT OR REF. NO.	PROJECT NO. RANDOLPH BR 0241 (29)
CONTRACTOR	WINTERSET, INC.
IN CHARGE: BRITIGAN (IH)	MADE BY: <u>KTK</u> CHK'D BY: <u>SJA</u> DATE: 11-1-06
CONTRACT NUMBER: VT-06215-1	DRAWING NUMBER: GN1 OF GN1

BY: astolby

68
PLOTTED: 01/22/07 09:29:42 PM