

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:

DESIGN SPECIFICATIONS: THE LATEST EDITION OF THE AASHTO LRFD BRIDGE DESIGN SPECIFICATIONS.  
 CONSTRUCTION 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.

STANDARD SPECIFICATIONS FOR HIGHWAY BRIDGES

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.

MATERIAL:

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

CLEANING:

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

PAINTING:

NO PAINT

SHOP PROCEDURE:

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.  
 ALL SHARP CORNERS AND EDGES THAT ARE MARRED, CUT OR ROUGHENED IN HANDLING SHALL BE GROUND TO 1.6 mm RADIUS.  
 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:

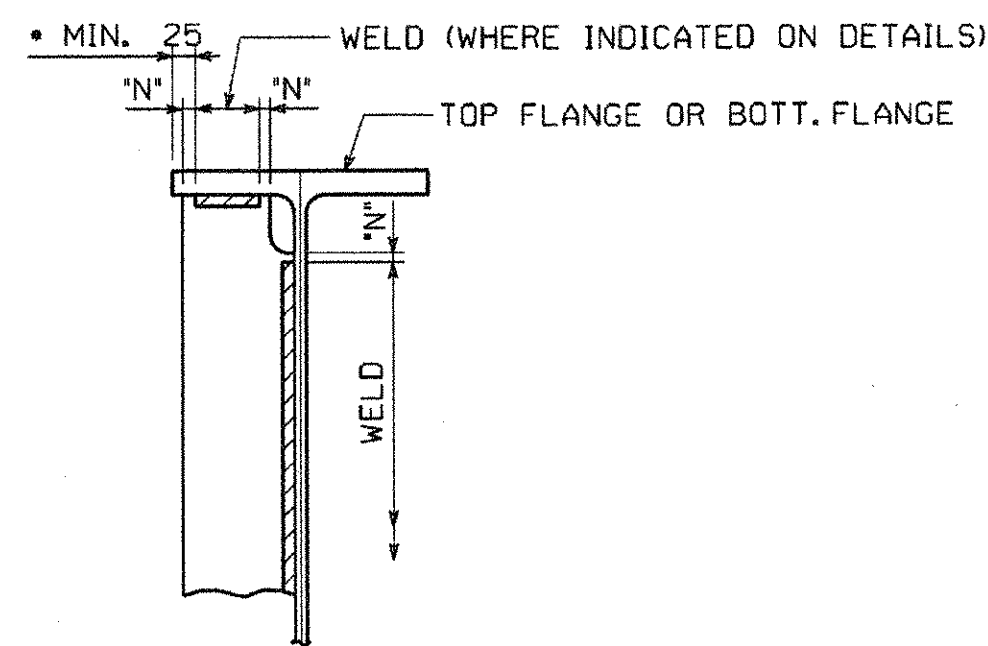
ALL WELDING IS TO CONFORM TO AWS D1.5-02.  
 WELDING METHODS, PROCEDURES, AND MATERIALS SHALL COMPLY WITH THE SPECIFIC PROCEDURE DESIGNATED IN THE WELD SYMBOL TAIL.  
 FOR WELDING STIFFENERS AND CONNECTION PLATES TO STRINGERS, SEE TYPICAL WELDING DETAIL.

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.

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: VHB OK'D BY: \_\_\_\_\_  
 AUG 21 2006  
 RESUBMIT APPROVED BY: [Signature] DATE: 9/18/06

NO.	REVISION	BY	DATE

1770 Hempstead Road  
 Lancaster, PA 17609-0008  
 Phone 717/299-5271  
**HIGH STEEL STRUCTURES, INC.**  
 A Division of High Industrial, Inc.

FAYSTON

**SHOP DRAWING REVIEW**

REVIEWED AS REQUIRED BY THE CONSTRUCTION CONTRACT DOCUMENTS AND APPROVED, BUT ONLY FOR CONFORMANCE TO THE DESIGN CONCEPT OF THE WORK, AND SUBJECT TO FURTHER LIMITATIONS AND REQUIREMENTS CONTAINED IN THE CONSTRUCTION CONTRACT DOCUMENTS.

REJECTED  REVISE AND RESUBMIT  FURNISH AS CORRECTED

CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DO NOT RELIEVE CONTRACTOR FROM COMPLIANCE WITH REQUIREMENTS OF THE DRAWINGS AND SPECIFICATIONS. THIS CHECK IS ONLY FOR REVIEW OF GENERAL CONFORMANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND GENERAL COMPLIANCE WITH THE INFORMATION GIVEN IN THE CONTRACT DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR: COORDINATING AND CORRELATING ALL QUANTITIES AND DIMENSIONS; SELECTING FABRICATION PROCESSES AND TECHNIQUES OF CONSTRUCTION; COORDINATING HIS WORK WITH THAT OF ALL OTHER TRADES; AND PERFORMING HIS WORK IN A SAFE AND SATISFACTORY MANNER.

Venuesse Hengen Bruatin, Inc.  
 Engineers, Planners, and Scientists  
 One Bedford Farm, Bedford Rd.  
 Bedford, NH 03110 603 664 2208

Job Number: 5054-3  
 Reviewed By: L.S. GARBER  
 Date: 9/6/06

GENERAL SHOP NOTES  
 VT 17 OVER MILL BROOK  
 VT 17 STA. 0+944.700 TO STA. 0+968.560  
 TOWN OF FALSTON, WASHINGTON COUNTY, VT  
 STATE OF VERMONT  
 AGENCY OF TRANSPORTATION

STATE CONTRACT OR REF. NO. BRIDGE NO. 36  
 CONTRACTOR WINTERSET, INC.  
 IN CHARGE: CHRISTMAN (IH) MADE BY: KMA CHK'D BY: SJA DATE: 7-27-06  
 CONTRACT NUMBER: VT-06062-1&2 DRAWING NUMBER: GN1 OF GN1

08855

BY: McCreel  
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