



1. MATERIAL-HIGH STRENGTH LOW ALLOY STEEL 55,000 PSI MIN
YIELD PER ASTM A572. POST AND MAST ARM MOUNTING BASE
MATERIAL PER ASTM A36.

2. FINISH- HOT DIP GALVANIZED PER ASTM A123 WITH TOP COAT PAINTED
MILLEBERBERG PLAT BLACK MILLEBERBERG OPT-1-17-PTU-093-FR.

3. POST TO BE RING TUBE FABRICATED WITH ONE SUBMERGED ARC
LONGITUDINAL SEAM WELD WITH 100% PENETRATION 6" FROM BASE
PLATE AND 50% FOR REMAINDER. GAS METAL ARC WELDING
PROCESS TO BE USED FOR REMAINDER OF WELDED FABRICATION
WITH 100% PENETRATION WELD FOR BASE PLATE TO SHAFT
CIRCUMFERENTIAL WELD

4. WELD TESTING-100% PENETRATION WELDS ULTRASONIC TESTED
OUT) USING THE CYCLICALLY LOADED ACCEPTANCE/REJECTION
CRITERIA TABLE 6.3 OF AWS D9.1 SPECIFICATION. 100% OF THE
POST/MAST ARM CONNECTION WELDS MAGNETIC PARTICLE TESTED
(MT) AND A RANDOM 30% OF REMAINING FILLET WELDS &
PARTICLE PENETRATION LONGITUDINAL SEAM WELDS MAGNETIC
PARTICLE TESTED (MT)

5. HEX HD BOLTS & NUTS (UNLESS SPECIFIED) ASTM A325 GALV A193
FOR SIZES 1/4 TO 1 1/2 DIA & ASTM A354BC GV A193 FOR
SIZES OVER 1 1/2 DIA.

6. THE POST AND THE FOLLOWING ITEMS WILL BE SHIPPED
UNASSEMBLED:

- (1) 500345 M16 FH COVER
- (1) 500344-2 M16 FH LATCH
- (2) 5/16-18NC X 2 1/2 LG HEX SOCKET FL HD SCREW (10-B SS)
- (1) 500311-23 STEEL CAP
- (1) 1/4-20NC X 3" LG SLOTTED RD HD MACHINE SCREW (10-B SS)
- (1) 1/4 PLAT WASHER (10-B SS)
- (1) 500343-1 M16 FH COVER
- (1) 500343-2 M16 FH LATCH
- (1) 5/16-18NC X 2" LG HEX SOCKET FL HD SCREW (10-B SS)

IDENTIFICATION TAG EXAMPLE

PART (#)	QTY	DESCRIPTION	'A' POST TAG INFORMATION	'B' HAST ARM TAG INFORMATION
76000012	1	SIGNAL POST	DALLAS/IRVING GRADE 55	3/16 X 3.0 X 5.5 X 250 GRADE 85

PC#2250-2128 / VT DOT: SKP.0284	(17) RICHMOND / US ROUTE 3, VT ROUTE 117, US ROUTE 2, OFF-RAMP
(RAMP 2) / MILLBERRAND #51660	SP204-100/205-1200-117 DUNDON SIGNAL POST

DWN DDDG F.	RE2HA-180/286-J300-VT ROUND SIGNAL POST	
DATE: 11-4-13	3/16 X 12.0 X 28'-6" POST	
CHK: RESEKAH	LUMINAIRE ARM AT 300 DEG	
SCALE: NTS	Millerbernd MANUFACTURING CO. WIDIST, WA	780B1312