

METRIC

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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.

NON-DESTRUCTIVE TESTING:

WEB PLATE SPLICES TO BE RADIOGRAPHICALLY TESTED, AS CALLED FOR ON DRAWING PREFIXED 'WC', BY H.S.S.I.

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 GIRDER WEB TO FLANGE AND 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).

PAINTING:

NO PAINT

SHOP PROCEDURE:

ALL WEB PLATE SPLICES TO BE MADE BEFORE FINAL FITTING AND WELDING INTO GIRDER.
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.
(CG) INDICATES CORNER GRINDING.
CORNER GRINDING IS REQUIRED FOR MAIN MEMBER FLANGE PLATES.
ALL SHARP CORNERS AND EDGES THAT ARE MARRED, CUT OR ROUGHENED IN HANDLING 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

DRAWING REFERENCE:

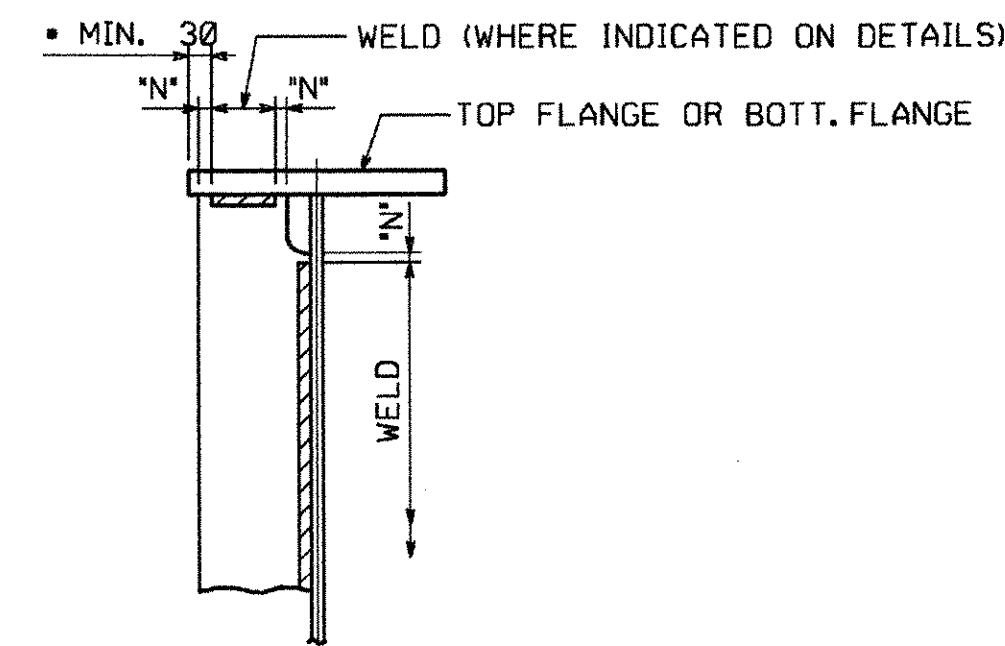
FLANGE SPLICES -PREFIXED 'FS'
WEB CAMBERS -PREFIXED 'WC'
GIRDER JOB STANDARDS -PREFIXED 'X'

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 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.



STIFFENER WELDING DETAIL

• WELDS MUST STOP 30 MINIMUM FROM EDGE OF FLANGE

RECEIVED

OK'D BY: WKL OK'D BY: _____
APR 27 2006
RESUBMIT _____ APPROVED ✓
BY: PLW DATE: 5/2/06

NO.	REVISION	BY	DATE
<p>1770 Hempstead Road Lancaster, PA 17605-0008 Phone 717/299-5211</p> <p>HIGH STEEL STRUCTURES, INC.</p> <p>A Division of High Industries, Inc.</p>			
GENERAL SHOP NOTES			
RTE. NO. TH 35 (BRIDGE NO. 24) OVER PACIFIC BROOK			
RTE. NO. TH 35 STA. 1+085.800 TO STA. 1+112.300			
TOWN OF MONTGOMERY			
FRANKLIN COUNTY, VERMONT			
STATE OF VERMONT, AGENCY OF TRANSPORTATION			
STATE CONTRACT OR REF. NO. PROJECT NO. BRO 1448 (20)			
CONTRACTOR A.L. ST. ONGE CONTRACTOR, INC.			
IN CHARGE: BRITIGAN (IH) MADE: <u>Kma</u> CHK'D: <u>SJA</u> DATE: 2/13/06			
CONTRACT NUMBER: VT-06001-1 DRAWING NUMBER: GN1 OF GN1			

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