

**SPECIFICATIONS**

CONSTRUCTION - VERMONT AGENCY OF TRANSPORTATION 2001 STANDARD SPECIFICATIONS FOR HIGHWAY AND BRIDGE CONSTRUCTION & LATEST REVISIONS.  
AASHTO STANDARD BRIDGE SECTION SPECIFICATIONS FOR HIGHWAY BRIDGES, 2002 EDITION, WITH LATEST REVISIONS.  
GENERAL SPECIAL PROVISIONS & SUPPLEMENTAL SPECIFICATIONS DATED 12-27-05  
WELDING - AWS/AASHTO/AWS BRIDGE WELDING CODE D1.5-02

**MATERIALS**

ALL STRUCTURAL STEEL SHALL COMPLY WITH AASHTO M207, GRADE 50W.  
UNPAINTED WEATHERING REQUIREMENTS UNLESS NOTED OTHERWISE.  
ALL MATERIAL SHALL BE DOMESTIC.

**FABRICATION NOTES**

V - INDICATES CHAMFY V-NOTCH TESTED PER SPECIAL PROVISIONS (SUBSECTION 714.01) DATED 12/6/05  
HEAT NUMBERS SHALL BE PRESERVED AND VISIBLE TO THE INSPECTOR.  
THE BOTTOM FLANGE OF ORDERS AT BEARINGS SHALL BE SHOP STRAIGHTENED AS REQUIRED TO PROMOTE UNIFORM CONTACT BETWEEN THE ORDER FLANGE AND THE BEARINGS AT THE BRIDGE SEAT.  
THERE SHALL BE NO PAINT, CHALK, OR CHALK MARKS ON THE STEEL EXCEPT WHERE NOTED "PAINTED".  
FIELD SPLICES SHALL BE SHOP ASSEMBLED, AND THE HOLES IN THE WEB AND FLANGES SHALL BE DRILLED FROM THE SOLID USING THE OUTSIDE SPICE PLATES AS TEMPLATES.

Ⓢ INDICATE NONDESTRUCTIVE INSPECTION REVD-D-ULTRASONIC INSPECTION MAY BE USED PER STANDARD SPEC SECTION 306.06(a)  
Ⓣ INDICATE WELDS SUBJECTED TO TENSION

ORDERS LESS THAN 250' AND SHALL BE FABRICATED BY CUTTING THE FLANGE PLATE TO THE REQUIRED CURVATURE. EACH PL SHALL BE FLAME CUT SIMULTANEOUSLY ON BOTH EDGES TO REDUCE UNBALANCED SHRINKAGE.

**IDENTIFICATION MARKING STEEL MEMBERS**

ALL STEEL MILL AND FABRICATOR IDENTIFICATION MARKINGS FOR STEEL PLATES, SHAPES, OR FABRICATED MEMBERS SHALL BE BY METAL TAGS, COMPASSION OF SOME OTHER READILY REMOVABLE MATERIAL, OR SHALL BE MARKED IN AN AREA OF THE COMPLETED MEMBER WHICH WILL BE ENCLOSED OR COVERED WITH CONCRETE. MARKING METHODS AND LOCATIONS ARE SUBJECT TO APPROVAL OF THE ENGINEER.  
DO NOT USE PAINT OR INK-BASED CHALKS FOR MARKINGS

RECEIVED

OK'D BY \_\_\_\_\_ OK'D BY \_\_\_\_\_  
FEB 7 - 2007  
RESUBMIT \_\_\_\_\_ APPROVED \_\_\_\_\_  
BY \_\_\_\_\_ DATE \_\_\_\_\_

**PAINT NOTES**

SURFACE PREPARATION - SSPC-SP10 (NEAR WHITE BLAST CLEANING)  
PRIOR TO BLAST CLEANING, ALL OIL, GREASE OR OTHER FOREIGN MATTER SHALL BE REMOVED BY SOLVENT CLEANING (SSPC-SP11).

ORDERS WILL BE COATED IN PAINTED AREA WITH A 3-COAT PAINT SYSTEM PER MANUFACTURING RECOMMENDATIONS  
FINAL PAINT COAT TO BE DARK BROWN, FEDERAL COLOR CHIP NO.20059

SHOP PAINT - NO PAINT, UNLESS NOTED TO BE PAINTED ON DETAILS.

PAINT AREAS ARE PER SECTION 513 OF AUG. 2000 SUPPLEMENTAL SPECIFICATIONS

PRIMER - EPOXY PRIMER CARBOLINE 850R (SHOP APPLIED)

INTERMEDIATE - EPOXY CARBOLINE 850R (SHOP APPLIED)

TOP COAT - 13LB ALIPHATIC POLYURETHANE (SHOP APPLIED)

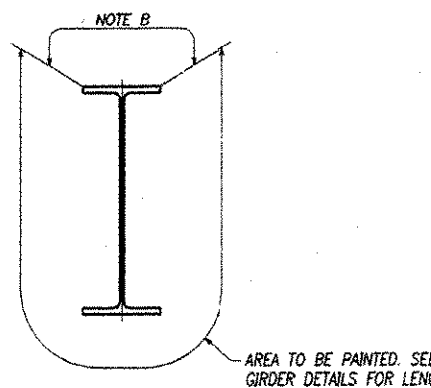
COLOR TO BE FED STANDARD 3005, AND THE GLOSS AT AN ANGLE OF 60 DEGREES SHALL NOT EXCEED 25.

PAINT MANUFACTURER: CARBOLINE

SEE DETAIL BELOW AND INDIVIDUAL ORDER DETAILS FOR "NO PAINT" AREAS WITHIN THE AREAS DESIGNATED TO BE PAINTED.

NOTE B - WEST COAT PRIMER ONLY (1.5 MILS DFT)

NOTE C - INDICATE PRIMER ONLY INTERMEDIATE AND TOP COATS TO BE STAGERED A MINIMUM OF 1" FROM PAINT SURFACES AND EACH OTHER.



AREA TO BE PAINTED. SEE ORDER DETAILS FOR LENGTH.

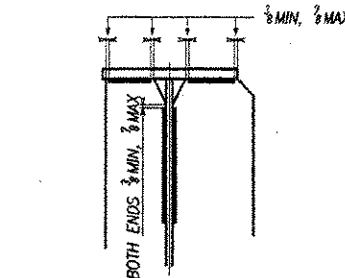
**ERECTION NOTES**

1/4" HEAVY HEX HIGH STRENGTH BOLTS (M16 TYPE 3) WITH ONE HARDENED WASHER ARE PROVIDED FOR THIS PROJECT AT UNPAINTED AREAS.

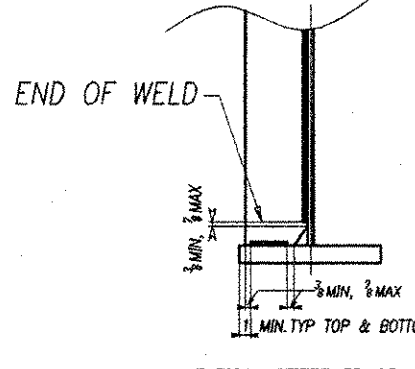
1/4" HEAVY HEX HIGH STRENGTH BOLTS (M16 TYPE 1) WITH ONE HARDENED WASHER ARE PROVIDED FOR THIS PROJECT AT PAINTED AREAS.

PLACE WASHER UNDER THE TURNED ELEMENT.

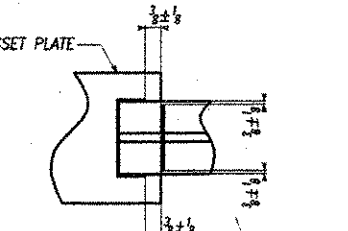
FIELD WELDS ARE NOT BY CAROLINA STEEL CORPORATION



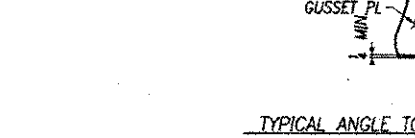
TYPICAL STIFFENER OR CONNECTOR PLATE CONNECTIONS.



TYPICAL STIFFENER OR CONNECTOR PLATE CONNECTIONS.



TYPICAL WT TO GUSSET WELD DETAIL.



TYPICAL ANGLE TO GUSSET PL CONNECTION.

**WELD TERMINATION DETAILS**

Form with fields for FABRICATED BY, WELD, SHOP PAINT, GENERAL NOTES, and PROJECT INFORMATION.

Revised sheets re: shop paint at diaphragm connections