# GENERAL NOTES

## CONSTRUCTION SPECIFICATIONS

1. ALL MATERIAL AND WORKMANSHIP TO BE IN ACCORDANCE WITH THE STATE OF VERMONT AGENCY OF TRANSPORTATION STANDARD SPECIFICATIONS FOR CONSTRUCTION DATED 2006 WITH LATEST REVISIONS AND THE AASHTO LRFD BRIDGE CONSTRUCTION SPECIFICATIONS FOR HIGHWAY BRIDGES 4th EDITION WITH INTERIMS THROUGH 2010.
2. THE PREFABRICATED STEEL TRUSS BRIDGE FOR THIS PROJECT SHALL MEET THE SPECIFICATION REQUIREMENTS FOR ITEM 900.645 SPECIAL PROVISIONS (PREFABRICATED TRUSS BRIDGE). THE TRUSS SHALL BE DESIGNED, DETAILED, FABRICATED AND TRANSPORTED TO THE SITE AND ERECTED BY THE FABRICATOR/CONTRACTOR.

## MATERIAL SPECIFICATIONS

1. ALL STEEL SHALL BE AASHTO M270 GRADE 50 AND SHALL BE GALVANIZED PER SUBSECTION 506.15.
2. MATERIAL NOTED "T2" OR CVN ON DETAIL DRAWINGS SHALL BE CHARPY V-NOTCH TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF VERMONT STANDARD SPECIFICATIONS SECTION 714.01.
3. MATERIAL NOTED "F2" OR FCM (FRACTURE CRITICAL MEMBERS) ON DETAIL DRAWINGS SHALL MEET THE FOLLOWING CONSTRUCTION AND TESTING REQUIREMENTS:
   A. ALL FRACTURE CRITICAL MEMBERS SHALL BE FABRICATED ACCORDING TO SECTION 12 OF THE AASHTO/AWS D1.5 BRIDGE WELDING CODE.
   B. ALL FRACTURE CRITICAL MEMBERS SHALL BE FABRICATED IN A PLANT HAVING AN AISC FRACTURE CRITICAL ENDORSEMENT OR THE FABRICATOR SHALL PROVIDE TO THE STRUCTURES ENGINEER AN ACCEPTABLE FRACTURE CONTROL PLAN MEETING THE REQUIREMENTS OF AASHTO/AWS D1.5, PRIOR TO FABRICATION.
   C. ALL FRACTURE CRITICAL MEMBERS SHALL BE IMPACT TESTED TO THE FRACTURE CRITICAL REQUIREMENTS AS SPECIFIED IN AASHTO M270.
4. HIGH STRENGTH BOLTS: ASTM A325 TYPE 1 GALVANIZED PER SECTION 506 (UN).
   NUTS SHALL BE A563 GRADE DH GALVANIZED.
   LOAD INDICATOR WASHERS (LIW) SHALL BE USED AS THE METHOD FOR PRETENSIONING ALL BOLTED TRUSS CONNECTIONS.
   BOLTS & NUTS SHALL BE ROTATIONAL CAPACITY TESTED.
   DO NOT MIX NUTS & BOLTS FROM DIFFERENT CONTAINERS UNLESS ALL BOLTS & NUTS HAVE THE SAME LOT NUMBER.

## FABRICATION

1. ALL HOLES SHALL BE DRILLED FULL SIZE (UN).
2. NO FIELD DRILLING, REAMING, OR CUTTING OF TRUSS OR CONNECTION MEMBERS.

[X] NO EXCEPTION TAKEN  [ ] MAKE CORRECTIONS NOTED
[ ] REJECTED  [ ] REVISE AND RESUBMIT
[ ] SUBMIT SPECIFIED ITEM

CHECKING IS ONLY FOR THE GENERAL CONFORMANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND GENERAL COMPLIANCE WITH THE INFORMATION GIVEN IN THE CONTRACT DOCUMENTS. ANY ACTION SHOWN IS SUBJECT TO THE REQUIREMENTS OF THE PLANS AND SPECIFICATIONS. CONTRACTOR IS RESPONSIBLE FOR DIMENSIONS WHICH SHALL BE CONFIRMED AND CORRELATED AT THE JOB SITE; FABRICATION PROCESSES AND TECHNIQUES OF CONSTRUCTION; COORDINATION OF HIS WORK WITH THAT OF ALL OTHER TRADES AND THE SATISFACTORY PERFORMANCE OF THE WORK.

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DATE 1/29/2016 BY J. Najdowski

## WELDING

1. ALL WELDING SHALL CONFORM TO THE PROVISIONS OF SUBSECTION 506.10.
2. NON DESTRUCTIVE TESTING OF WELDS SHALL BE IN ACCORDANCE WITH THE REFERENCED SPECIFICATION.
3. SHEAR CONNECTORS FOR FLOORBEAMS & SIDEWALK TOP STRUTS SHALL BE ATTACHED IN THE SHOP, PRIOR TO GALVANIZING. WELDING AND INSPECTION OF SHEAR CONNECTORS SHALL CONFORM TO THE PROVISIONS OF SECTION 508.
4. SEE DETAIL "WT1" ON THIS DRAWING FOR WELD TERMINATION DETAIL.
5. THE FOLLOWING CASCO WELDING PROCEDURES SHALL BE USED:

| WELD DESCRIPTION | MAT'L GRADE | WP | CASCO WELD PROC. |
|---|---|---|---|
| FLOOR BEAM STIFFENER TO WEB FILLET WELDING | M270 GR50 | WP1 | 250 |
| FLOOR BEAM STIFFENER TO FLANGE FILLET WELDING | M270 GR50 | WP2 | 470 or 480 |
| ALL OTHER FILLET WELDS | M270 GR50 | WP3 | 470 or 610 |
| TRUSS END POST TO BASE PLATE CJP WELDING (TC-U5b) | M270 GR50 | WP4 | 471 |

## SURFACE PREPARATION

1. PRIOR TO GALVANIZING, ALL CORNERS AND EDGES OF STEEL PLATES, SHAPES, ETC., SHALL BE GROUND TO A 1/16" RADIUS.
2. ALL STEEL TO BE GALVANIZED SHALL BE CLEANED TO BE AT LEAST EQUIVALENT TO SURFACE PREPARATION GRADE SSPC-SP8, UNLESS OTHERWISE APPROVED BY THE ENGINEER.

## GALVANIZING

1. ALL STEEL SHALL BE HOT DIP GALVANIZED IN ACCORDANCE WITH SUBSECTION 506.15.
2. ALL FAYING SURFACES SHALL BE HAND WIRE BRUSHED, OR BRUSH BLASTED, AFTER GALVANIZING TO ACHIEVE AN AASHTO CLASS C SURFACE CONDITION. NO MECHANICAL OR POWER BRUSHING ALLOWED.
3. BOLT HOLES SHALL BE CLEANED OF GALVANIZATION TO RE-ESTABLISH 15/16" DIA. HOLE.
4. NO FIELD GALVANIZING PERMITTED.

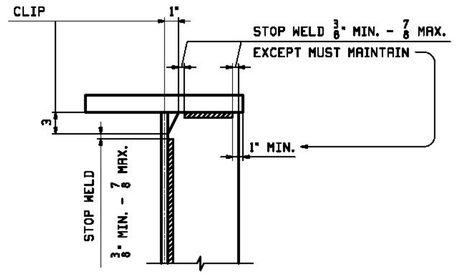
## PAINTING

1. ALL STEEL SHALL BE PAINTED AFTER GALVANIZING. PAINT SYSTEM SHALL BE DETERMINED.

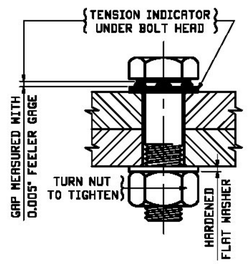
## FIELD CONNECTIONS

1. ALL FIELD CONNECTIONS SHALL BE MADE WITH 7/8" DIAMETER HIGH STRENGTH A325 TYPE 1 GALVANIZED BOLTS (UN), INSTALLED PER SECTION 506.19(c).
2. BOLTS SHALL HAVE A HEAVY HEX HEAD, ONE HEAVY HEX NUT, ONE LOAD INDICATOR WASHER (LIW), AND AT LEAST ONE FLAT WASHER EACH. WASHER TO BE PLACED UNDER TURNED ELEMENT. SEE "TYPICAL BOLT DETAIL" ON THIS DRAWING.
3. PIECE MARKS WILL BE LOCATED AS SHOWN ON ERECTION DRAWINGS.

Vermont Agency of Transportation
RECEIVED
ON: March 21, 2016
and Checked for
CONFORMANCE
BY: ABC DATE:




**DETAIL "WT1"**
STIFFENER WELD TERMINATION




**TYPICAL BOLT DETAIL**

NOTE TO ENGINEER:
THESE NOTES ARE NOT INTENDED TO BE ALL INCLUSIVE AND COMPLIANCE WITH RELEVANT SPECIFICATIONS REMAIN UNCHANGED.

| REV. | DATE | REMARKS | DWN | CHK | APVL | SHOP |
|---|---|---|---|---|---|---|
| 1 | 1/6/16 | ADDED WELDING PROCEDURE | RB | WJL | | |
| 0 | | | | | | |

MATERIAL: | SURFACE PREP. & PAINT: | HOLES: | SHOP BOLTS:

DESCRIPTION: GENERAL NOTES

CASCO BAY STEEL STRUCTURES, INC.
1 WALLACE AVE. SOUTH PORTLAND, ME 04106
PHONE (207) 780-6722 FAX. (207) 780-6726
TEMBOR 3285

STRUCTURE: TH-10 OVER OTTER CREEK PONY TRUSS BRIDGE
DRAWN: RB DATE: 10/7/15
CHK'D: WJL DATE: 10/16/15
LOCATION: RUTLAND CITY, VERMONT
JOB NO. 598
DWG NO. GN1
PROJ NO. BRF 3000 (19)
CUSTOMER: KUBRICKY CONSTRUCTION CORP.
REV. 1

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