

**GENERAL NOTES**

**CONSTRUCTION SPECIFICATIONS**

ALL MATERIAL AND WORKMANSHIP TO BE IN ACCORDANCE WITH THE STATE OF VERMONT AGENCY OF TRANSPORTATION STANDARD SPECIFICATIONS FOR CONSTRUCTION DATED 2011 WITH LATEST REVISIONS AND THE FHWA LFD BRIDGE CONSTRUCTION SPECIFICATIONS FOR HIGHWAY BRIDGES 8th EDITION, AND ITS LATEST REVISIONS.

**MATERIAL SPECIFICATIONS**

- 1) ALL STEEL TO BE UNPAINTED A570 M570 (ASTM A709) GRADE 50W (LW).
- 2) MATERIAL NOTED 'CVM' OR 'T2' ON DETAIL DRAWINGS SHALL BE CHIPPY V-NOTCH TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF VERMONT STANDARD SPECIFICATIONS SECTION 714.01.
- 3) HIGH STRENGTH BOLTS:  
-ASTM A325 (FHWA M54) TYPE 3 W/ A563 GRADE C3 NUTS, F438 (TYPE 3) WASHERS, F438 (TYPE 3) DIRECT TENSION INDICATORS.  
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 FINIS, BLIVERS AND TEARS SHALL BE REMOVED.
- 2) ALL ROUGH SURFACES SHALL BE GROUND SMOOTH.

**WELDING**

- 1) THE CONFIGURATION OF THE WELD JOINTS AND ALL WELDING PROCEDURES SHALL BE IN ACCORDANCE WITH THE CURRENT FHWA/AASHTO D-5 BRIDGE WELDING CODE AND IN ADDITION TO SPECIFICATIONS SHOWN ABOVE, ALL WELDING SHALL BE DETAILED TO PRE-QUALIFIED JOINTS, UNLESS PROHIBITED BY THE DESIGNER.
- 2) WELDING OF MAIN LOAD CARRYING MEMBERS AND ATTACHMENTS SHALL BE PERFORMED USING THE AUTOMATIC SUBMERGED ARC & SHIELDED METAL ARC PROCESSES. ALL WELDS ARE CONTINUOUS U.W.
- 3) NON DESTRUCTIVE TESTING OF WELDS SHALL BE IN ACCORDANCE WITH THE REFERENCED SPECIFICATION.
- 4) SEE DETAIL "WT" ON THIS DRAWING FOR WELD TERMINATION DETAIL.

**WELD PROCEDURE**

THE FOLLOWING CARCO WELDING PROCEDURES SHALL BE USED:

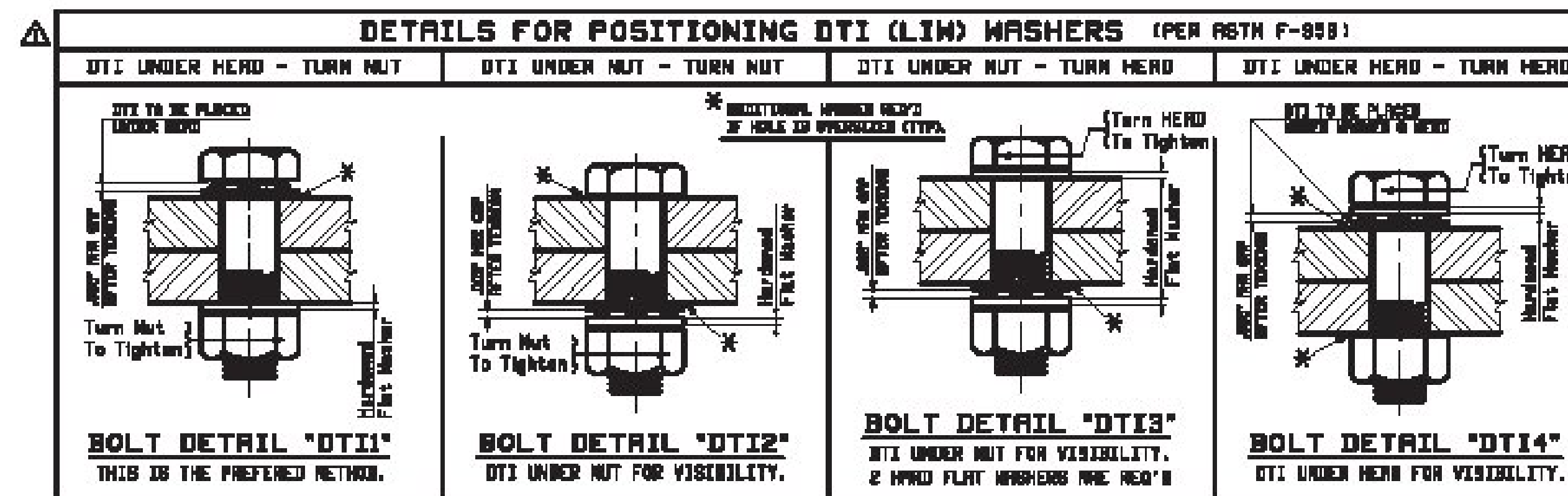
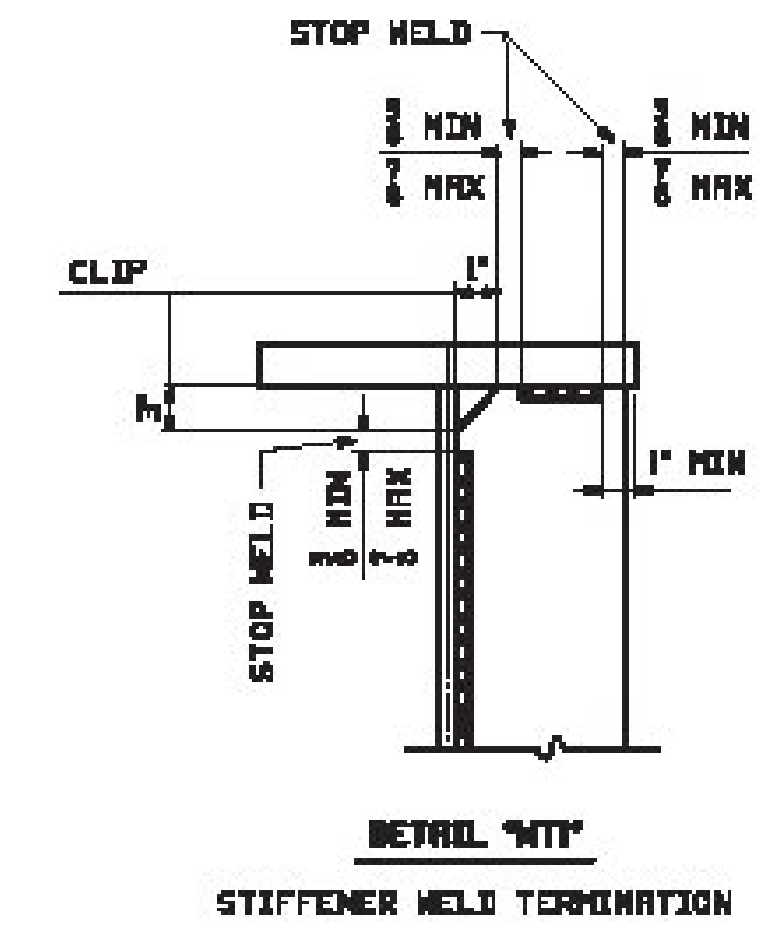
WELD DESCRIPTION	RYL. GRADE	MP	CARCO WELD PROC.
BORDER WEB TO FLANGE FILLET WELD	M570-S0M TO M570-S0M	MPS	201
CORNER WEB BUTT WELDS (U-LW-S)	M570-S0M TO M570-S0M	MPS	202
CORNER FLANGE BUTT WELDS (U-LW-S)	M570-S0M TO M570-S0M	MPS	202
BORDER STIFFENER TO WEB FILLET WELDING	M570-S0M TO M570-S0M	MPS	203
BORDER STIFFENER TO FLANGE FILLET WELDING	M570-S0M TO M570-S0M	MPS	482
BRIDGE PLATE TO SUMMER FLANGE	M570-S0M TO M570-S0M	MPS	482 or 483

**CONNECTIONS**

- 1) ALL CONNECTIONS SHALL BE MADE WITH A-325 HB BOLTS, INSTALLED PER SECTION 506.19(a).
- 2) BOLTS SHALL HAVE HEAVY HEX NUT, HEAVY HEX HEAD, DTI, AND AT LEAST ONE HARDENED FLAT WASHER EACH. WASHERS TO BE PLACED UNDER TURNED ELEMENT.
- 3) PIECE MARKS WILL BE LOCATED AS SHOWN ON ERECTION DRAWINGS.

**CLEANING & PAINTING**

UNPAINTED STEEL SHALL BE BLAST CLEANED TO SSPC SP-10 TO ACHIEVE A UNIFORM WEATHERED APPEARANCE.  
ALL STEEL SHALL BE UNPAINTED.



**NOTE TO DESIGNER:**  
STEEL WELDS ARE NOT REQUIRED TO BE ALL WELDED AND COMPLIANT WITH REFERENCED SPECIFICATIONS THROUGH USE OF CARCO.

APPROVAL COMMENTS	JTB	JBH		
REV. DATE	REMARKS	DWN	CHK	APVL
MATERIAL:	SURFACE PREP. & PRDIT:	HOBLES:	SHOP BOLTS:	
DESCRIPTION:		GENERAL NOTES		
		CASCO BAY STEEL STRUCTURES, INC. 1 MILLAGE LANE, SOUTH PORTLAND, ME 04106 PHONE: (207) 760-5700 FAX: (207) 760-5700		
STRUCTURE:	TH-1, FAS RT. 0211 / HUNTINGTON RIVER RURAL MAJOR COLLECTOR BRIDGE #	DATE:	01/12	
LOCATION:	TOWN OF HUNTINGTON, VERMONT	DATE:	01/18	
PROJECT NO.:	STATE PROJ. 8F-0211(32)	JOB NO.:	695-1	
CUSTOMER:	VERMONT AGENCY OF TRANSPORTATION	ENG. NO.:	GN1	

WPS's to be used are in the tails of the weld.

Vermont Agency of Transportation  
**RECEIVED**  
OK'D BY Rob Young  
February 16, 2017  
Approved As Noted  
DATE 03/05/2017