GENERAL SHOP NOTES

SPECIFICATIONS:

VERMONT AGENCY OF TRANSPORTATION (VAOT) STANDARD SPECIFICATIONS FOR CONSTRUCTION DATED 2006, AND ITS LATEST REVISIONS, AND THE AASHTO STANDARD SPECIFICATIONS FOR HIGHWAY BRIDGES, SEVENTEENTH EDITION, DATED 2002 AND ITS LATEST REVISIONS

ALL FABRICATION TO BE IN ACCORDANCE WITH SECTION 506 OF THE VAOT STANDARD SPECIFICATIONS

MATERIALS:

ALL STEEL SHALL BE OF DOMESTIC ORIGIN.

ALL STEEL SHALL BE AASHTO M 270M/M 270 GR 345W (ASTM A709 GR 50W) UNO IN SHOP BILL

PROVIDE TYPE C CERTIFICATION TO VAOT INSPECTOR PRIOR TO FABRICATION AS PER VAOT 506.07a & 700.2a

ALL MAIN LOAD CARRYING MEMBERS AND COMPONENTS OF ROLLED OR WELDED SECTIONS SUBJECT TO TENSILE STRESS SHALL MEET THE LONGITUDINAL CHARPY V-NOTCH (CVN) IMPACT REQUIREMENTS SPECIFIED IN AASHTO M 270M/M 270 (ASTM A709), SUPPLEMENTARY REQUIREMENT TABLES FOR NONFRACTURE CRITICAL STEEL FOR ZONE 2. IMPACT TEST SAMPLING AND TESTING PROCEDURES SHALL BE IN ACCORDANCE WITH AASHTO T243 (ASTM A673)

MATERIAL ON THESE DWGS. SHALL BE FURNISHED UNDER ITEM NUMBER 900.675

PRIOR TO USE OF ALL BOLT, NUT, & WASHER ASSEMBLIES, TYPE(S) D, A, & C CERTIFICATIONS SHALL BE PROVIDED AND APPROVED PER 714.05 AND 700.2a OF THE VAOT STANDARD SPEC.

BOLTS: 7/8"ø AASHTO M164 (ASTM A325) TYPE 3
NUTS: 7/8"ø AASHTO M291 (ASTM A563) (GR – DH3)
WASHERS: 7/8"ø AASHTO M293 (ASTM F436) TYPE 3

SHEAR CONNECTORS 7/8"ø x 4" AASHTO M169 (ASTM A108) GRADES 1015, 1018, OR 1020

MEET REQUIREMENTS OF 714.05

SHOP PROCEDURES:

MAINTAIN MATERIAL TRACEABILITY FOR ALL STEEL (VAOT 506.07(b))

ALL DIMENSIONS ARE GIVEN IN MILLIMETERS UNO
BOLTS, HOLES, AND SHEAR STUD UNITS ARE GIVEN IN INCHES

ALL RE-ENTRANT CUTS TO HAVE 3/4"(19.05mm) MIN. RADIUS 1"
ON MAIN MATL. 2"(50.8mm) MIN. RADIUS

REMOVE ANY BURRS, AND EASE SHARP EDGES

A 25mm CAMBER SHALL REMAIN IN THE BEAMS AFTER ALL DEAD LOADS HAVE BEEN APPLIED. THE CAMBER SHALL APPROXIMATE A SIMPLE CURVE

CONNECTION/STIFFENER PLATE LENGTHS ARE THEORETICAL, AND SHALL BE ADJUSTED TO SUIT MILL TOLERANCE AND FIT-UP TOLERANCE OF WIDE FLANGE SHAPES

PIECE MARKS: USE LOW STRESS STEEL STENCILS

WELDING:

ALL WELDING IS TO CONFORM TO THE REQUIREMENTS OF AWS D1.5 (PER APPROVED WELDING PROCEDURES)

FINISH:

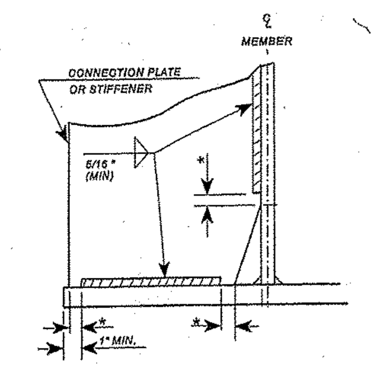
CLEANING;

ALL STEEL SHALL BE PREPARED FOR BLASTING BY REMOVING OIL, GREASE, DIRT, SALT OR OTHER CONTAMINANTS BY THE METHODS SPECIFIED IN SSPC-SP1, SOLVENT CLEANING.

BLAST CLEAN ALL STEEL TO SSPC-SP10 (COMMERCIAL) AFTER FABRICATION.

PAINTING;

THIS IS AN UNPAINTED BRIDGE.



*NO WELD FOR 1/4" MIN. 1/2" MAX.
(EXCEPT MUST MAINTAIN 1" MINIMUM FROM EDGE OF FLANGE)

Weld termination for steel members.

ADD VTRANS WELD TERMINATION DETAIL TO DRAWINGS

DIMENSIONAL TOLERANCES: (PER SECTION 3.5 OF AASHTO/AWS D1.5)

BEFORE WELDING, DIMENSIONS OF SHAPES AND PLATES SHALL CONFORM TO THE TOLERANCES DESCRIBED IN ASTM DESIGNATION AASHTO M160 (ASTM A6). AFTER WELDING, ALL MEMBERS SHALL CONFORM TO THE DIMENSIONS AND TOLERANCES OF SECTION 3.5 OF AWS D1.5, AWS D1.5 SECTION 7.4.5, AND FORT MILLER PREFABRICATED SUPERSTRUCTURE UNIT TOLERANCES.

ALL MEASUREMENTS SHALL BE COMPARED TO THE DIMENSIONS SHOWN ON THE APPROVED SHOP DRAWINGS.

ALL MEMBERS MAY VARY FROM THE DETAILED LENGTH BY +/- 1/4"(6.35mm) MAXIMUM, AS PER FORT MILLER PREFABRICATED SUPERSTRUCTURE UNIT TOLERANCES, UNLESS OTHERWISE APPROVED.

CAMBER TOLERANCE = SEE CAMBER DIAGRAMS ON GIRDERS

INTERMEDIATE CONNECTION PLATES AND STIFFENERS MAY VARY +/- 1/2"(12.7mm) FROM THE DETAILED LOCATION.
THE DEVIATION FROM STRAIGHTNESS OF INTERMEDIATE CONNECTION PLATES AND STIFFENERS SHALL NOT EXCEED 1/2"(12.7mm) IN THE LENGTH OF THE PLATE.
THE EDGE OF THE PLATE THAT IS WELDED TO THE WEB OF THE GIRDER SHALL BE STRAIGHT AND, WHEN FIT TO THE WEB, SHALL HAVE NO GAPS IN EXCESS OF 3/32"(2.38mm) BETWEEN THE WEB AND THE PLATE.
WHERE TIGHT FIT OF CONNECTION OR STIFFENER PLATES IS SPECIFIED, A GAP OF UP TO 1/16"(1.58mm) BETWEEN PLATE AND FLANGE IS ALLOWED.

INSPECTION:

SHOP INSPECTION BY:

GC – PLEASE PROVIDE

☐ Reviewed
☐ Rejected
☒ Furnish as Corrected
☐ Revise and Resubmit
☐ Submit Specified Item

This review is only for general conformance with the design concept and the information given in the Construction Documents. Corrections or comments made on the shop drawings during this review do not relieve the contractor from compliance with the requirements of the plans and specifications. Review of a specific item shall not include review of an assembly of which the item is a component. The Contractor is responsible for: dimensions to be confirmed and correlated at the jobsite; information that pertains solely to the fabrication process or to the means, methods, techniques, sequences and procedures of construction; coordination of the Work with that of all other trades and performing all Work in a safe and satisfactory manner.

McFarland-Johnson, Inc. ______

Date 7/9/2010

By RMR

RETURN TO Sherrod

NO.	DATE	BY	REVISION

STS STEEL, INC.
ENGINEERS • FABRICATORS • ERECTORS
PH: (518) 370-2693 FAX: (518) 370-2696

DRAWING TITLE
GENERAL NOTES

ARCHITECT : VERMONT AGENCY OF TRANSPORTATION
CUSTOMER : THE FORT MILLER CO., INC.
PROJECT : RIPTON FH 010-1(2) TH 18 OVER SOUTH BRANCH MIDDLEBURY RIVER
TOWN OF RIPTON, STATE OF VERMONT

HOLES: AS NOTED	FINISH: AS NOTED			DATE:	5-11-10
BOLTS: AS NOTED	DR.BY:	WMN	JOB NO.		1060
WELDS: AS NOTED	CHK.BY:	DT 6-16-10	DWG NO.		GN1