

## GENERAL SHOP NOTES

### CONSTRUCTION SPECIFICATIONS

- 1). ALL MATERIALS AND CONSTRUCTION SHALL CONFORM TO THE STATE OF VERMONT, AGENCY OF TRANSPORTATION STANDARD SPECIFICATIONS FOR CONSTRUCTION, DATED 1990, AND IT'S LATEST REVISIONS, AND THE AASHTO STANDARD SPECIFICATIONS FOR HIGHWAY BRIDGES, DATED 1996, AND IT'S LATEST REVISIONS.

### MATERIAL SPECIFICATIONS

- 1). ALL STRUCTURAL STEEL SHALL BE ASTM A709M GRADE 50W
- 2). HIGH STRENGTH BOLTS SHALL CONFORM TO THE FOLLOWING:  
HIGH STRENGTH BOLTS: ASTM A325M TYPE-3  
HARD FLAT WASHERS: ASTM F436M TYPE-3  
HEAVY HEX NUTS: ASTM A563M TYPE-3  
  
BOLTS & NUTS SHALL BE ROTATIONAL CAPACITY TESTED AND MEET ALL OTHER REQUIREMENTS OF SUBSECTION 11.3.2 OF THE AASHTO STANDARD SPECIFICATIONS FOR HIGHWAY BRIDGES. DO NOT MIX NUTS & BOLTS FROM DIFFERENT CONTAINERS UNLESS ALL BOLTS & NUTS HAVE THE SAME LOT NUMBER.
- 3). MAIN LOAD CARRYING MEMBERS SHALL MEET THE NOTCH TOUGHNESS REQUIREMENTS OF ZONE 2, H FREQUENCY:  
15 FT LBS AT 40° F (UP TO 2" WELDED)  
20 FT LBS AT 40° F (2" TO 4" WELDED)  
  
DRAWINGS SHALL CALL OUT 'CVN' FOR EACH APPLICABLE ITEM IN THE BILLS OF MATERIAL.
- 4). ALL MATERIAL SUBSTITUTIONS SHALL BE SUBMITTED TO THE STRUCTURES ENGINEER FOR APPROVAL PRIOR TO FABRICATION.

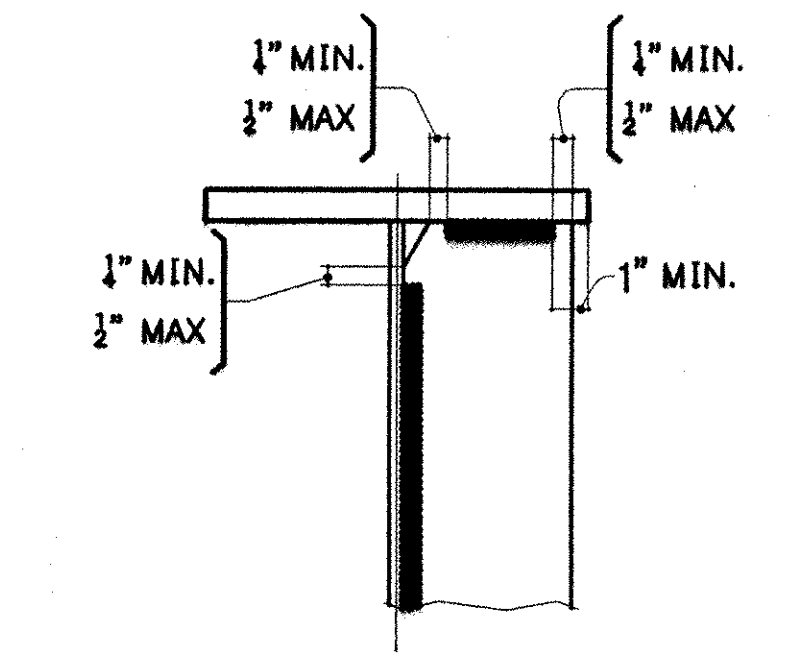
### FABRICATION

- 1). ALL WELDING AND DIMENSIONAL TOLERANCES OF WELDED MEMBERS SHALL CONFORM TO THE LATEST ANSI/AASHTO/AWS BRIDGE WELDING CODE AND IT'S LATEST REVISIONS.
- 2). NON DESTRUCTIVE TESTING OF WELDS SHALL BE IN ACCORDANCE WITH THE REFERENCED SPECIFICATIONS.  
  
MAGNETIC PARTICLE INSPECTION:  
WEB TO FLANGES 10% OR 300mm MINIMUM.  
CONN. PLATES TO WEB 10% OR 300mm MINIMUM.  
CONN. PLATES TO FLANGES 10% OR 300mm MINIMUM  
UNLESS NOTED, ALL WELDS ARE CONTINUOUS.

**GROOVE WELD INSPECTION:**  
BUTT GROOVE WELDS IN TENSION: 100% RT  
BUTT GROOVE WELDS IN COMPRESSION: 25% UT

### SURFACE PREPARATION

- 1). ALL CORNERS AND EDGES OF STEEL WHICH HAVE BEEN FLAME CUT OR OTHERWISE HARDENED SHALL BE SOFTENED BY GRINDING OR BLAST-CLEANING TO PROVIDE A SUITABLE SURFACE FOR THE SPECIFIED PAINT SYSTEM.
- 2). ALL STEEL SURFACES ARE TO BE BLAST CLEANED IN ACCORDANCE WITH THE PROVISIONS OF SSPC-SP10 "NEAR-WHITE BLAST CLEANING". ALL SURFACES SHALL BE FREE OF ALL OIL, DIRT, GREASE, MILL SCALE AND OTHER FOREIGN MATERIAL.



TYP. WELD TERMINATION DETAIL

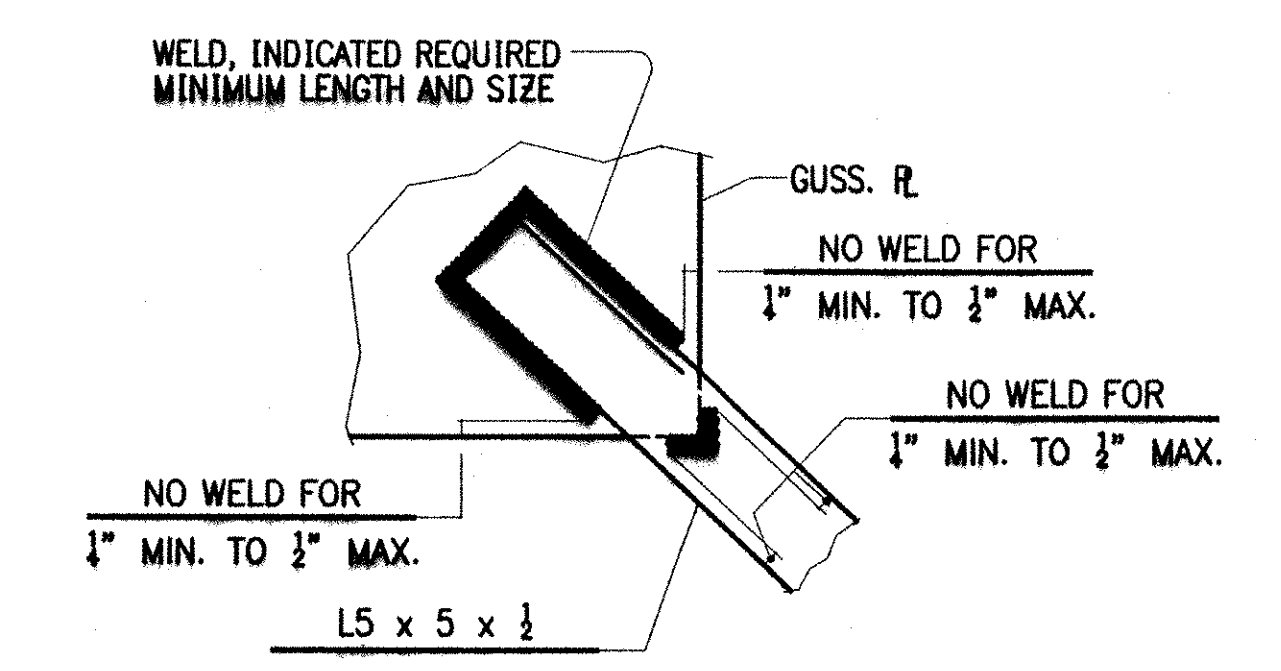
### PAINT

ALL STEEL 6'-6 FROM THE ENDS OF GIRDERS SHALL BE PAINTED WITH THE FOLLOWING THREE COAT PAINT SYSTEM, EXCEPT AS NOTED:

- 1). PRIME COAT: CARBOLINE 11HS 0300 GREEN, 2-6 MILS D.F.T.
- 2). INTERMEDIATE COAT: CARBOLINE 0893 0800 WHITE, 4-10 MILS D.F.T.
- 3). TOP COAT: CARBOLINE 133HB 2248 DARK BROWN, 3-5 MILS D.F.T.

THE FOLLOWING SURFACES SHALL RECEIVE THE PRIME COAT ONLY:

- ALL SURFACES WITHIN 3" OF OPEN HOLES.
- ALL SURFACES IN CONTACT WITH CONCRETE.
- ALL SURFACES TO BE FIELD WELDED.



WELD LOCATION DETAIL AT CROSSFRAMES

### FIELD CONNECTIONS

- 1). FIELD BOLTS SHALL HAVE HEAVY HEX NUT, HEX HEAD AND ONE HARD WASHER EACH.
- 2). PIECE MARKS WILL BE LOCATED AS SHOWN ON ERECTION DRAWINGS. ALL ERECTION MARKS, MATCH MARKS AND WEIGHT MARKS MUST NOT BE EXPOSED IN THE FINISHED STRUCTURE.

**RECEIVED**  
OK'D BY WES OK'D BY \_\_\_\_\_  
SEP 13 2001  
RESUBMIT \_\_\_\_\_ APPROVED   
BY CPW DATE 9/12/01

ITEM NO. 506.55	BR. NO. 3	PROJ. NO. BRZ 1444(22)
TITLE: GENERAL NOTES		<b>FOR APPROVAL</b>
APPROVED: 9-5-01		 <b>National Eastern Corporation</b> Plainville, Connecticut  JOB: T.H. 1 OVER THE WHITE RIVER ROYALTON, VERMONT  <b>REVISED</b>
PRINT DIST.		
5	4-7-01 APPR.	
ORIG.	9-5-01 FAB.	
5	7-13-01 APP	
5	8-24-01 APP	
5	9-10-01 APP	
11	9-10-01 FAB	
CUSTOMER: BECK & BELLUCCI, INC.		
DESIGNER: VERMONT AGENCY OF TRANSPORTATION		
CHECKED	TS	3/01
DRAWN	AV	3/01
WORK ORDER NO.	DRAWING NO.	REV.
15873	GN1	1

△ GROOVE WELD INSPECTION 9-10-01 JCM

OK