

GENERAL SHOP NOTES

SPECIFICATIONS:

1. ALL MATERIALS & WORKMANSHIP TO BE IN ACCORDANCE WITH THE STATE OF VERMONT AGENCY OF TRANSPORTATION STANDARD SPECIFICATIONS FOR CONSTRUCTION, DATED 2001, AND ITS LATEST REVISIONS, AND THE AASHTO STANDARD SPECIFICATIONS FOR HIGHWAY BRIDGES, SIXTEENTH EDITION, AND ITS LATEST REVISIONS.

MATERIALS:

1. UNLESS OTHERWISE NOTED, ALL STRUCTURAL STEEL TO BE AASHTO M270, GR. 345W. STEEL NOTED T2 SHALL MEET CVN TESTING REQUIREMENTS PER VERMONT AOT SPECIFICATIONS.
2. HIGH STRENGTH BOLTS TO BE ASTM A325, TYPE 3 (WEATHERING), WITH STD. HEAVY HEX NUTS & HARDENED FLAT WASHERS. ALL H.S. BOLTS TO BE ROTATIONAL CAPACITY TESTED.

SHOP PROCEDURES:

1. ALL RE-ENTRANT CUTS TO HAVE A 50 mm MIN. RADIUS.
2. CAMBER TOLERANCE: -0 TO +20 mm.

WELDING:

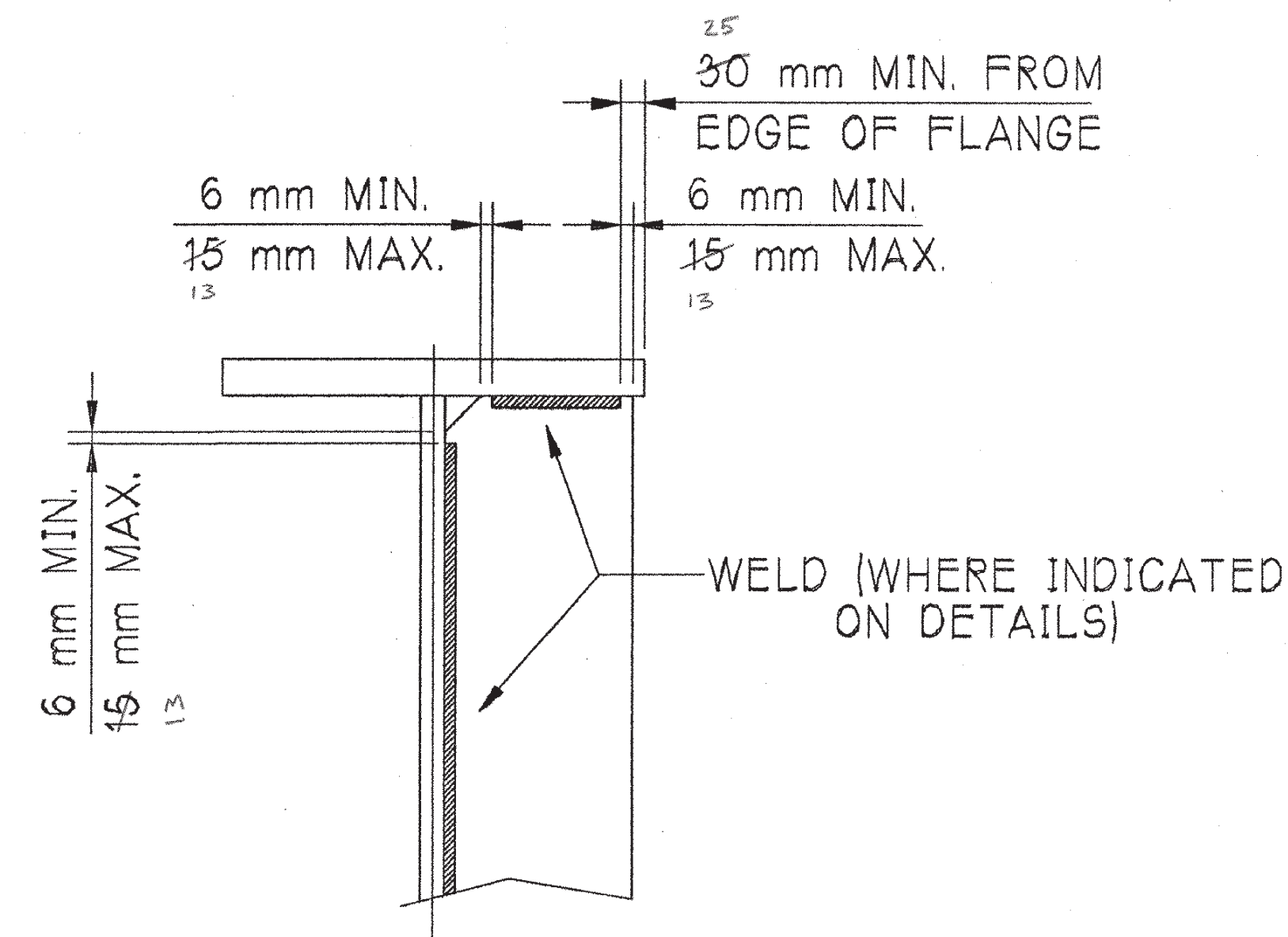
1. ALL WELDING TO BE IN ACCORDANCE WITH AASHTO/AWS D1.5-95 BRIDGE WELDING CODE, AS AMENDED BY VERMONT AGENCY OF TRANSPORTATION STANDARD SPECIFICATIONS, DATED 2001, SECTION 506.10.
2. STIFFENER AND/OR CONNECTION PLATE WELDS SHALL BE TERMINATED AS INDICATED IN "TYPICAL FILLET WELD TERMINATION DETAIL".

NON-DESTRUCTIVE TESTING:

1. ALL GIRDER WEB TO FLANGE FILLET WELDS TO BE INSPECTED BY THE MAGNETIC PARTICLE METHOD. TEST 300 mm OF EACH 3000 mm OF ALL WEB TO FLANGE WELDS AS NOTED ON DETAILS.
2. ALL GIRDER CONNECTION STIFFENER FILLET WELDS TO BE INSPECTED BY THE MAGNETIC PARTICLE METHOD. TEST 300 mm OF EACH 3000 mm OF ALL STIFFENER WELDS AS NOTED ON DETAILS.
3. MULTIPLE PASS FILLET WELDS, INSPECTED BY THE MAGNETIC PARTICLE METHOD, SHALL HAVE EACH PASS OR LAYER INSPECTED AND ACCEPTED BEFORE PROCEEDING TO THE NEXT PASS OR LAYER.

CLEANING:

1. ALL STRUCTURAL STEEL TO BE UNPAINTED & CLEANED FOR WEATHERING, PER VERMONT AOT STANDARD SPECIFICATIONS.
2. ALL STRUCTURAL STEEL TO BE BLAST-CLEANED FOR WEATHERING TO SPPC-SPI0. BLAST CLEANING MAY BE PERFORMED EITHER BEFORE OR AFTER FABRICATION.



TYP. FILLET WELD TERMINATION DETAIL

RECEIVED
 OK'D BY *ML* OK'D BY *Ca*
 MAR 25 2003
 RESUBMIT APPROVED *As noted*
 BY *CSR* DATE *4/15/03*

FOR APPROVAL

ITEM NO. 506.55	BR. NO. 6	PROJ. NO. BRO 1443(32)
TITLE: GENERAL NOTES		
APPROVED:		 national eastern STRUCTURAL STEEL FABRICATORS MAJOR STEEL BRIDGES PLAINVILLE, CT 860-747-3700
6	3/25/03 APPR.	
ORIG.	FAB.	
JOB:		CL 2 LOCAL BRIDGE NO. 6 RTE. TH 6 OVER THE POULTNEY RIVER RUTLAND COUNTY FAIRHAVEN, VERMONT - HAMPTON, NEW YORK
CUSTOMER:		AUSTIN CONSTRUCTION, INC.
DESIGNER:		VERMONT AGENCY OF TRANSPORTATION
CHECKED	DS/NEC	3/24/03
DRAWN	RAB/NEC	3/18/03
WORK ORDER NO. 15948		DRAWING NO. GN1
		REV.