

METRIC 1. ALL DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE NOTED.  
2. ALL WEIGHTS ARE IN KILOGRAMS.

**GENERAL SHOP NOTES**

**SPECIFICATIONS:**  
ALL MATERIAL AND WORKMANSHIP TO BE IN ACCORDANCE WITH THE STATE OF VERMONT, AGENCY OF TRANSPORTATION, STANDARD SPECIFICATIONS FOR CONSTRUCTION DATED 2006, WITH CURRENT MODIFICATIONS AND ADDITIONS.

**NON-DESTRUCTIVE TESTING:**  
WEB PLATE SPLICES TO BE RADIOGRAPHICALLY TESTED, AS CALLED FOR ON DRAWING PREFIXED "WC", BY N.S.S.L.

MAGNETIC PARTICLE INSPECTION IS REQUIRED ON AT LEAST 300 mm OF EVERY 3000 mm LENGTH OF FILLET WELDS AND 300 mm OF SUCH WELDS LESS THAN 3000 mm IN LENGTH ON GIRDER WEB TO FLANGE AND CONNECTION PLATES TO WEB AND FLANGE WELDS. TESTING PER THE YOKE METHOD, USING DC.

**MATERIALS:**  
UNLESS NOTED OTHERWISE, ALL STEEL TO BE A515/A572M GRADE 50W. (INDICATES ZONE 2 CHURRY NOTCH TESTING REQUIRED.)

**CLEANING:**  
ALL STEEL TO BE BLAST CLEANED TO SSPC-SP18 NEAR WHITE.

**PAINTING:**  
NO PAINT

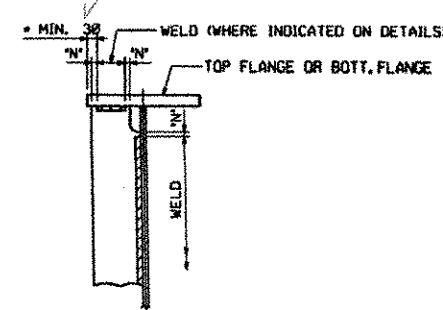
**SHOP PROCEDURES:**  
ALL WEB PLATE SPLICES TO BE MADE BEFORE FINAL FITTING AND WELDING INTO GIRDERS.  
CAMBER TOLERANCES: +8 mm TO +13 mm.  
ALL RE-ENTRANT CURS TO HAVE 25 MIN. RADIUS.  
BEARING AREA, AS NOTED ON GIRDER DETAILS, INDICATES AREA THAT MUST BE FLAT AND TRUE TO RECEIVING SILL PLATE.  
ICE3 INDICATES CORNER GRINDING.  
CORNER GRINDING IS REQUIRED FOR MAIN MEMBER FLANGE PLATES.  
ALL SHARP CORNERS AND EDGES THAT ARE MARRED, CUT OR ROUGHENED IN HANDLING SHALL BE GRIND TO 1/16" MIN.  
ONLY LOW STRESS STEEL STAMPS MAY BE USED FOR MARKING IN AREAS NOT EXPOSED ON THE FINISHED STRUCTURE.

**INSPECTION:**  
SHOP INSPECTION BY THE VERMONT AGENCY OF TRANSPORTATION

**DRAWING REFERENCES:**  
FLANGE SPLICES - PREFIXED "FS"  
WEB GIRDERS - PREFIXED "WG"  
GIRDER JOBS STANDARDS - PREFIXED "G"

**WELDING:**  
ALL WELDING IS TO CONFORM TO AWS D1.1-B.  
WELDING METHODS, PROCEDURES, AND MATERIALS SHALL COMPLY WITH THE SPECIFIC PROCEDURE DESIGNATED IN THE WELD SYMBOL, TAIL FOR WELDING STIFFENERS AND CONNECTION PLATES TO GIRDERS, SEE TYPICAL WELDING DETAIL.

**IDENTIFICATION OF HOLE PLACEMENT:**  
UNLESS NOTED OTHERWISE, ALL HOLES IN MATERIAL 16mm OR LESS IN THICKNESS MAY BE CNC COMPUTER NUMERICALLY CONTROLLED PUNCHES OR CNC DRILLED FULL SIZE UNLESS NOTED. ALL MATERIAL THICKER THAN 16mm IS TO BE DRILLED.



STIFFENER WELDING DETAIL  
WELDS MUST STOP 38 MM MINIMUM FROM EDGE OF FLANGE

RECEIVED  
OK'D BY *MIT* OK'D BY *Cue*  
MAR 17 2006  
RESUBMIT APPROVED ✓  
BY *Cue* DATE 4/11/06

NO.	REVISION	BY	DATE

DESIGNED BY: HIGH STEEL STRUCTURES, INC. (Logo)  
GENERAL SHOP NOTES  
RTE. NO. 10 BRIDGE NO. 244 OVER PACIFIC BROOK  
RTE. NO. 17 25 STA. 148+00.00 TO STA. 152+00.00  
TOWN OF MONTGOMERY  
STATE OF VERMONT, AGENCY OF TRANSPORTATION  
STATE OF VERMONT PROJECT NO. 810 14 148 120  
DESIGNED BY: ST. ONGE CONTRACTOR, INC.  
IN CHARGE: BRITISH OIL INC. DATE: 5/8 2/13/06  
CONTRACT: VT-95001-1 DRAWING: GNI OF GNI