

GENERAL SHOP NOTES

SPECIFICATIONS

- MATERIAL AND WORKMANSHIP TO BE IN ACCORDANCE WITH THE STATE OF VERMONT, AGENCY OF TRANSPORTATION, STANDARD SPECIFICATIONS FOR CONSTRUCTION DATED 2001, GENERAL SPECIAL PROVISIONS, AND THE LATEST EDITION OF AASHTO STANDARD SPECIFICATIONS FOR HIGHWAY BRIDGES.

MATERIAL

- MATERIAL SHALL CONFORM TO AASHTO M270M, GRADE 345W (UN).
- MATERIAL NOTED (M270M-345WT2) ON DETAIL DRAWINGS SHALL REQUIRE CHARPY V-NOTCH TESTING (ZONE 2).
- HIGH STRENGTH BOLTS SHALL CONFORM TO AASHTO M164 TYPE 3 WITH ONE AASHTO M291 HVY. HEX NUT & ONE AASHTO M293 TYPE 3 WASHER (UNLESS NOTED OTHERWISE).

HIGH STRENGTH BOLTS IN PAINTED AREAS SHALL CONFORM TO AASHTO M164 TYPE 1, WITH ONE AASHTO M291 HVY. HEX NUT & ONE AASHTO M293 TYPE 1 WASHER. BOLTS, NUTS & WASHERS SHALL BE GALVANIZED PER AASHTO M298 CLASS 50, TYPE 1.

FABRICATION & WORKMANSHIP

- "BEARING AREA" AS NOTED ON GIRDER DETAILS, INDICATES AREA THAT MUST BE FLAT AND TRUE TO RECEIVE SOLE PLATE.
- RE-ENTRANT CUTS TO HAVE A 25 MILLIMETER MIN. RADIUS.

SHOP WELDING AND TESTING NOTES:

- WELDING AND NON-DESTRUCTIVE TESTING SHALL BE IN ACCORDANCE WITH ANSI/AASHTO/AWS BRIDGE WELDING CODE, D1.5.
- FOR WELDING CONNECTION PLATES TO GIRDERS SEE "TYP. WELD TERMINATION DETAIL".

NON-DESTRUCTIVE TESTING:

- ALL SHOP GROOVE WELDS IN THE GIRDER WEB AND FLANGES SHALL BE INSPECTED BY RADIOGRAPHIC TESTING AS FOLLOWS:
 - FLANGE SPLICES SUBJECT TO TENSION SHALL BE INSPECTED 100%. TENSION SPLICES SHALL BE NOTED "t" ON THE DETAILS.
 - FLANGE SPLICES SUBJECT TO COMPRESSION SHALL BE INSPECTED 25%. COMPRESSION SPLICES SHALL BE NOTED "c" ON THE DETAILS.
 - WEB SPLICES SHALL BE TESTED 100% FOR 1/6 THE WEB DEPTH BEGINNING AT THE POINT OF TENSION AND 25% FOR THE REMAINDER OF THE WEB DEPTH AS INDICATED ON DETAILS.
- MAGNETIC PARTICLE INSPECTION WILL BE REQUIRED ON GIRDER FILLET WELDS AS FOLLOWS:
 - a. WEB TO FLG - 300MM OF EVERY 3 METERS LENGTH OF WELD.
 - b. BEARING STIFFENERS & CROSSFRAME CONNECTION PLATES TO WEB - 300MM OF EACH WELD LESS THAN 3 METERS IN LENGTH.
 - c. BEARING STIFFENERS AND CROSSFRAME CONNECTION PLATES TO FLANGES - 10% OF EACH WELD.
 IF UNACCEPTABLE DISCONTINUITIES ARE FOUND IN ANY TEST LENGTH OF WELD, THE FULL LENGTH OF THE WELD, OR 1.5 METERS ON BOTH SIDES OF THE TEST LENGTH, WHICHEVER IS LESS, SHALL BE TESTED.

DRAWING REFERENCE:

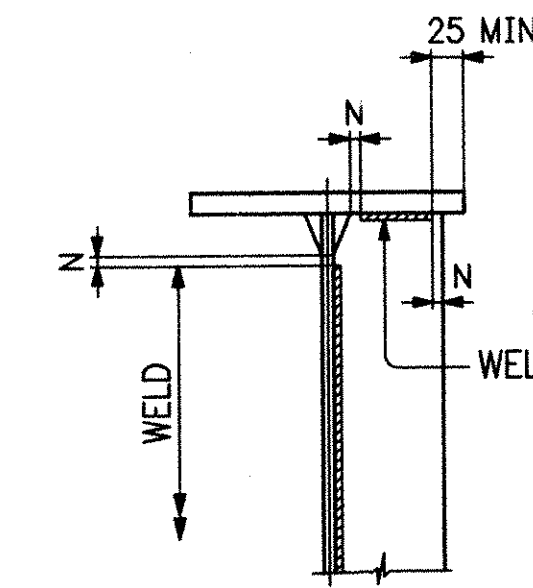
- GIRDER JOB STANDARDS - PREFIXED "X"
CROSSFRAME JOB STANDARDS - PREFIXED "M"

SHOP CLEANING NOTES:

- BLAST CLEAN ALL STEEL TO SSPC-SP10 (NEAR WHITE) AFTER FABRICATION. BLAST CLEANING PROFILE TO BE FROM 1.5 TO 2.5 MILS DEEP.

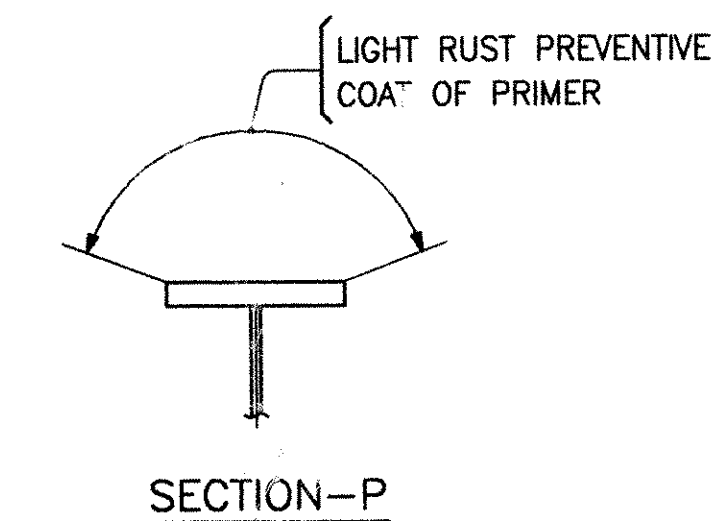
SHOP PAINTING NOTES:

- AREAS TO BE PAINTED (NOTED ON DETAIL DWGS.) SHALL BE PAINTED WITH A 3 - COAT SHOP APPLIED SYSTEM (UN) CONSISTING OF:
 - PRIME COAT - CARBOZINC 859 ORGANIC ZINC-RICH EPOXY - 3-5 MILS. DFT
 - INTERMEDIATE COAT - CARBOGUARD 888 EPOXY POLYAMIDE - 3-5 MILS. DFT
 - FINISH COAT - CARBOTHANE 133HB ALIPHATIC ACRYLIC-POLYESTER POLYURETHANE 3-5 MILS DFT. FED. STANDARD 595 COLOR CHIP NO. 14062 GREEN.
 - GREASE COATING - BY OTHERS / FIELD APPLIED.
- INTERMEDIATE AND TOP COATS SHALL BE STAGGERED A MIN. OF 12MM FROM THE FAYING SURFACES AND EACH OTHER.
- PRIME COAT TO BE APPLIED WITHIN 8 HRS. OF BLAST CLEANING.
- STRIPE COAT ALL EDGES OF PLATES, ANGLES OR OTHER SHAPES, BOLTS AND NUTS PRIOR TO THE APPLICATION OF THE PRIME COAT.
- FIELD BOLTED CONTACT SURFACES WITHIN THE AREAS TO BE PAINTED SHALL RECEIVE THE PRIME COAT ONLY WITHIN 75MM OF OPEN HOLES.
- SURFACES IN CONTACT WITH CONCRETE WITHIN THE AREAS TO BE PAINTED SHALL RECEIVE A LIGHT RUST PREVENTIVE COAT OF PRIMER, NOT TO EXCEED 1.5 MILS DFT. THESE SURFACES ARE NOTED ON THE DETAIL DRAWINGS.
- TOP FLANGE OF GIRDER AS SHOWN IN SECTION-P SHALL RECEIVE A LIGHT RUST PREVENTIVE COAT OF PRIMER, NOT TO EXCEED 1.5 MILS DFT.

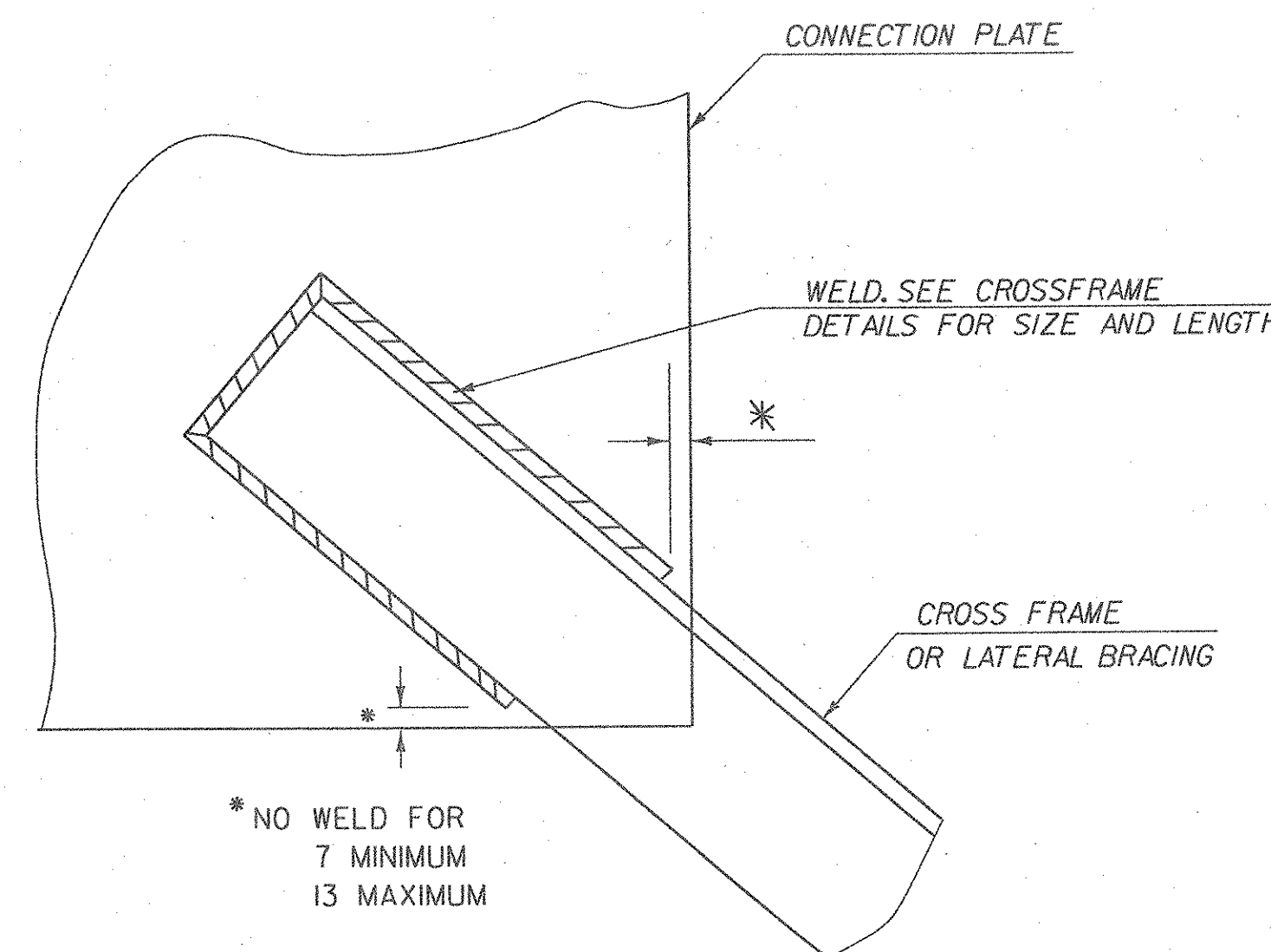


N = 7 MIN., 13 MAX.
(EXCEPT MUST MAINTAIN 25 FROM FLANGE)

TYP. WELD TERMINATION DETAIL



SECTION-P



WELD LOCATION DETAIL
AT CROSS FRAMES AND
LATERAL BRACING
NOT TO SCALE

See cross frame details

RECEIVED
OK'D BY: *WWS* OK'D BY: _____
MAY 18 2006
RESUBMIT: _____ APPROVED: *As Notd*
BY: *WWS* DATE: *6/9/06*

REV.	DATE	DESCRIPTION	QTY.	DATE	ISSUED TO	FOR
8	5/15/06	FW White				

PROJECT: T.H.1 OVER MENDON BROOK (BRIDGE NO. 3)	
LOCATION: TOWN OF MENDON COUNTY OF RUTLAND	
ENGINEER: STATE OF VERMONT AGENCY OF TRANSPORTATION	
CUSTOMER: FRANK W. WHITE CIVIL CONSTRUCTION	
DRAWING TITLE: GENERAL NOTES	JOB NUMBER: 6035
DRAWN BY: WCG 4-21-03	SHEET NUMBER: GN1
CHECKED BY: FM 5-3-06	

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