

GENERAL NOTES

CONSTRUCTION SPECIFICATIONS

- 1). ALL MATERIAL AND CONSTRUCTION SHALL CONFORM TO STATE OF VERMONT, AGENCY OF TRANSPORTATION STANDARD SPECIFICATIONS FOR CONSTRUCTION, DATED 2011, AND ITS LATEST REVISIONS, AND THE AMERICAN ASSOCIATION OF STATE HIGHWAY AND TRANSPORTATION OFFICIALS (A.A.S.H.T.O.) BRIDGE DESIGN SPECIFICATIONS DATED 2010, AND ITS LATEST REVISIONS.

MATERIAL SPECIFICATIONS

- 1). UNLESS NOTED, ALL NEW STRUCTURAL STEEL CONFORM TO AASHTO M270 GRADE 50 (ASTM A709-50).
- 2). MATERIAL NOTED "T2" ON DETAIL DRAWINGS SHALL BE CHARPY V-NOTCH TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF VERMONT STANDARD SPECIFICATIONS (SUBSECTION 714.01).
- 3). HIGH STRENGTH BOLTS: AASHTO M164 (ASTM A325) TYPE 1, 7/8" DIA. IN 15/16" DIAMETER HOLES. BOLT, NUT AND WASHER SHALL BE MECHANICALLY GALVANIZED IN ACCORDANCE WITH AASHTO M 298, CLASS 50, TYPE 1.
- 4). DIRECT TENSION INDICATOR (DTI) WASHERS CONFORMING TO ASTM F959 SHALL BE INSTALLED WITH ALL HIGH STRENGTH BOLTS.

FABRICATION

- 1). BOLT HOLES SHALL BE FABRICATED TO THE REQUIREMENTS OF THE 2012 AASHTO LRFD BRIDGE CONSTRUCTION SPECIFICATIONS, SECTION 11.4.8, EXCEPT THAT HOLES SHALL NOT BE PUNCHED FULL SIZE.
- 2). EACH MEMBER SHALL BE IDENTIFIED WITH AN ERECTION MARK CORRESPONDING WITH THE MEMBER IDENTIFICATION MARK ON THE APPROVED SHOP DRAWINGS.
- 3). TIGHT FIT (WELDED ENDS ONLY). 50% OF THE PROJECTED BEARING AREA SHALL BE IN CONTACT WITHIN 0.5mm (0.02") WITH A PERMISSIBLE VARIATION OF 1.6mm (1/16") FOR THE REMAINING 50% OF THE PROJECTED AREA.
- 4). GRIND TO BEAR. 75% OF THE PROJECTED AREA SHALL BE IN CONTACT WITHIN 0.25mm (0.01") WITH A PERMISSIBLE VARIATION OF 0.8mm (1/32") FOR THE PROJECTED AREA.
- 5). MILL TO BEAR. 100% OF THE PROJECTED AREA SHALL BE IN FULL CONTACT.

WELDING

- 1). THE CONFIGURATION OF THE WELD JOINTS AND ALL WELDING PROCEDURES SHALL BE IN ACCORDANCE WITH AASHTO/AWS 2010 D1.5 BRIDGE WELDING CODE AND WITH SPECIFICATIONS SHOWN BESIDE. ALL WELDING WILL BE DETAILED TO PRE-QUALIFIED JOINTS, UNLESS PROHIBITED BY THE DESIGNER.
- 2). WELDING OF MAIN LOAD CARRYING MEMBERS AND ATTACHMENTS SHALL BE PERFORMED USING THE AUTOMATIC SUBMERGE ARC & SHIELDED METAL ARC PROCESS. ALL WELDS ARE CONTINUOUS U.N.
- 3). NON-DESTRUCTIVE TESTING OF WELDS SHALL BE IN ACCORDANCE WITH THE REFERENCED SPECIFICATIONS.

FIELD CONNECTIONS

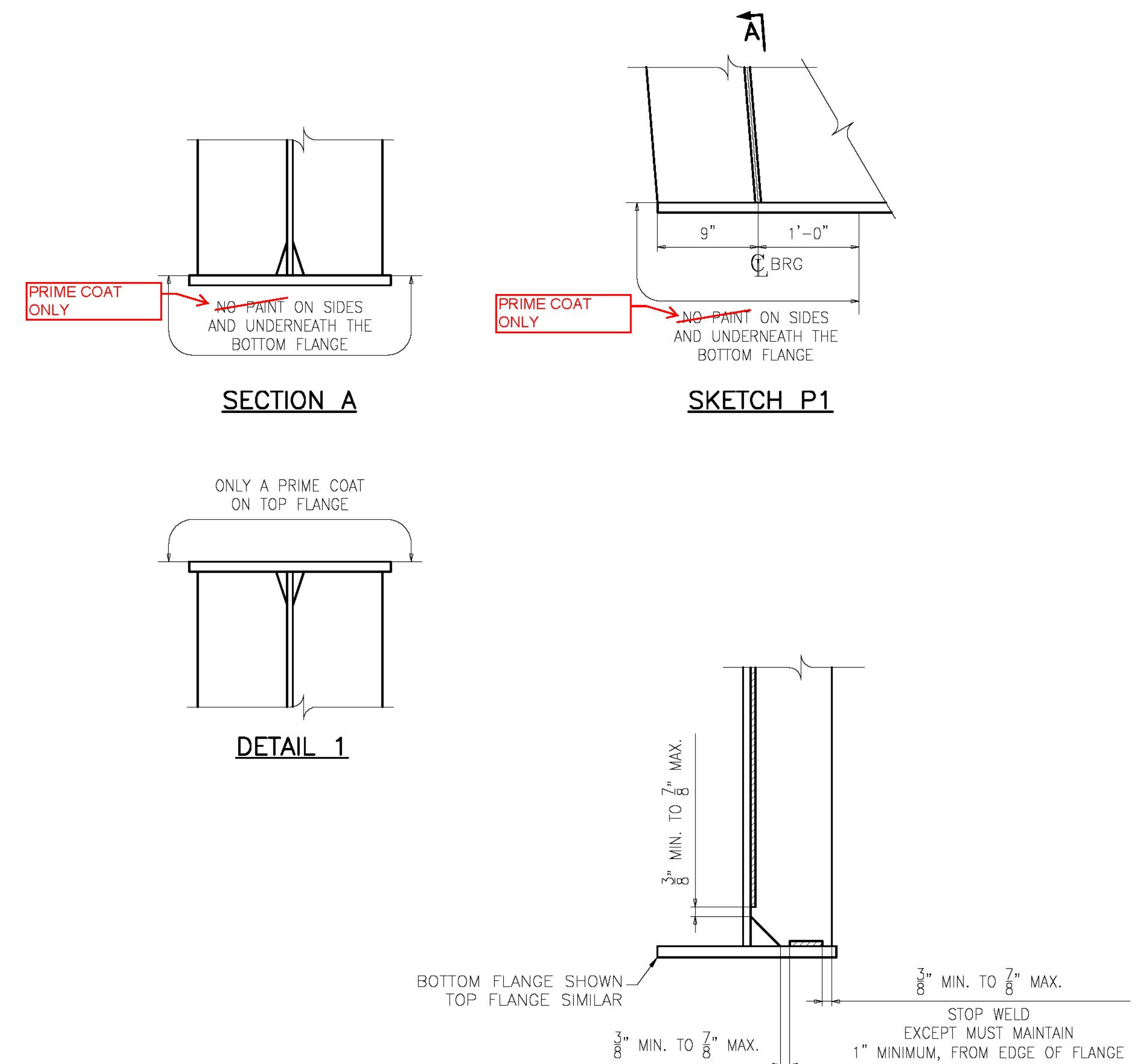
- 1). ALL FIELD CONNECTIONS SHALL BE MADE WITH 7/8" DIAMETER HIGH STRENGTH BOLTS AASHTO M164 (ASTM A325) TYPE 1, IN 15/16" DIAMETER HOLES UNLESS OTHERWISE NOTED. INSTALLED PER 506.19(c) AND SPECIAL PROVISIONS.
- 2). BOLTS SHALL HAVE HEAVY HEX. NUT, HEX. HEAD AND ONE DTI'S/LOAD INDICATOR FLAT WASHER AND 1 HARDENED WASHER EACH (HARDENED WASHER TO BE PLACED UNDER TURNED ELEMENT (NUT), DTI TO BE PLACED UNDER THE HEAD OF THE BOLT WITH THE PROTRUSIONS FACING THE HEAD OF THE BOLT). BOLT, NUT AND WASHER SHALL BE MECHANICALLY GALVANIZED IN ACCORDANCE WITH AASHTO M 298, CLASS 50, TYPE 1.
- 3). PIECE MARKS WILL BE LOCATED AS SHOWN ON ERECTION DRAWING.
- 4). BOLTS INSTALLED WITH THE STEM VERTICAL SHALL HAVE HEADS UP. BOLTS INSTALLED WITH THE STEM HORIZONTAL SHALL HAVE HEADS TOWARDS THE WEATHER UNLESS CLEARANCE RESTRICTIONS DICTATE OTHERWISE.

CLEANING:

- 1). ALL STEEL SHALL BE BLAST CLEANED AS PER SSPC SP-10 (NEAR WHITE) PER SPEC. 506.14(c).

PAINTING:

- 1). ALL STRUCTURAL STEEL SHALL BE PAINTED IN ACCORDANCE WITH THE CONTRACT DOCUMENTS.
- 2). THE FINAL COLOR SHALL BE BROWN IN ACCORDANCE WITH SUBSECTION 708.03 (FED. STD 595, COLOR CHIP 20059).
- 3). GREASE SHALL BE APPLIED FOR A DISTANCE OF 10'-0" STARTING AT THE ABUTMENT #1 END OF THE SPAN. ALL CHANNELS AND CONNECTION PLATES LOCATED IN THIS AREA SHALL ALSO BE GREASED. THE GREASE SHALL BE BROWN.
- 4). PAINT SYSTEM SHALL BE AS FOLLOWS FROM CARBOLINE COMPANY:
PRIME COAT: CARBOZINC 859 ORGANIC ZINC RICH EPOXY PRIMER (3.5-5 MILS DFT) Δ
INTERMEDIATE COAT: CARBOGUARD 893 EPOXY INTERMEDIATE (3-6 MILS DFT)
TOP COAT: CARBOTHANE 133 VOC ALIPHATIC POLYURETHANE (2.5-4 MILS DFT) Δ
 Δ TOTAL THICKNESS SHALL BE BETWEEN 5.5 AND 10.0 MILS
- 5). TOP OF GIRDER TOP FLANGES SHALL ONLY RECEIVE A PRIME COAT (LESS THAN 1.5 MILS OF PRIMER). (SEE DETAIL 1)
- 6). FAYING SURFACES OF BOLTED CONNECTION (BOTH SIDES OF ALL PLIES) SHALL ONLY RECEIVE A PRIME COAT FOR A DISTANCE OF 1 1/2" AROUND HOLES.
- 7). FIELD WELD AREAS AT BEARING SOLE PLATES SHALL BE LEFT UNPAINTED (SEE SKETCH P1).



DETAIL "WS1"
STIFF. WELD TERMINATION

1	06/05/15	PER APPROVAL COMMENTS	EG	YT		
0						
REV.	DATE	REMARKS	DWN	CHK	APVL	SHOP
MATERIAL:		SURFACE PREP. & PAINT:		HOLES:		SHOP BOLTS:
				AS NOTED		AS NOTED
DESCRIPTION: GENERAL NOTES						
CASCO BAY STEEL STRUCTURES, INC. 1 WALLACE AVE. SOUTH PORTLAND, ME 04106 FAX. (207) 780-6726 PHONE (207) 780-6722 						
STRUCTURE:			DRAWN:	DATE:		
REPLACEMENT OF BRIDGE NO. 12 ON TH27 INCLUDING APPROACH ROADWAY AND CHANNEL WORK TOWN OF COLCHESTER, COUNTY OF CHITTENDEN STATE OF VERMONT AGENCY OF TRANSPORTATION			BK	04/21		
			CHKD:	DATE:		
			YT	04/28		
LOCATION: COLCHESTER / CHITTENDEN, VT			JOB NO.	DWG NO.		
PROJ NO. STP 5600(12)			629-1	GN1		
CUSTOMER: A.L. ST. ONGE				REV.	Δ	

Vermont Agency of Transportation
RECEIVED
CBS 629 Colchester, VT - REV. 04
CK'D BY FDB **OK'D BY HIS**
June 10, 2015
RESUBMIT No **Approved AsNoted**
BY Carolyn Carlson **DATE 06/11/05**

ENGINEERING REVIEW STAMP