

STRUCTURAL STEEL NOTES TO BE SHOWN ON CONTRACT PLANS

ISSUED: 2009

PLATE
3.9-26

1. WELDING SHALL CONFORM TO THE CURRENT AASHTO/AWS D1.5 WELDING CODE WITH NJDOT AMENDMENTS. WELDING AND NONDESTRUCTIVE TESTING SYMBOLS SHALL CONFORM TO AWS A2.4 SYMBOLS FOR WELDING, BRAZING AND NONDESTRUCTIVE EXAMINATION.
2. JOINT WELDING PROCEDURES, OVERALL FABRICATION METHODS, AND QUALITY CONTROL INSPECTION PROCEDURE SHALL BE INCLUDED AS WRITTEN PROCEDURE SPECIFICATIONS WITH THE SHOP PLAN SUBMISSION.
3. FLANGE AND WEB SHOP SPLICES SHALL BE LOCATED WHERE SHOWN ON PLANS. MINOR CHANGES IN LOCATION, TOGETHER WITH ANY ADDITIONAL SPLICES REQUESTED, SHALL BE SUBJECT TO THE APPROVAL OF THE ENGINEER. LENGTHS OF PLATES SHALL BE CONSISTENT WITH LENGTHS OF PLATES AVAILABLE FROM THE MILL. LOCATION SHALL BE AT POINTS OF REDUCED TENSILE STRESS. WEB SPLICES SHALL BE AT LEAST 12" FROM FLANGE SPLICES AND/OR TRANSVERSE INTERMEDIATE STIFFENER AND/OR CONNECTION PLATES FOR DIAPHRAGMS.
4. WHEN FLANGES ARE DETAILED ON THE CONTRACT PLANS AS A SERIES OF VARYING THICKNESS PLATES, THE CONTRACTOR MAY, FOR THE PURPOSE OF ELIMINATING BUTT WELDS, EXTEND THE LENGTH OF THE THICKER PLATE TO THE END OF THE NEXT THINNER PLATE OR TO THE END OF THE MEMBER, PROVIDED THE MAXIMUM PLATE THICKNESS DOES NOT EXCEED 1.5 TIMES THE THICKNESS OF THE THINNER PLATE PLUS $\frac{3}{8}$ ", SUBJECT TO APPROVAL BY THE ENGINEER. IF THE CONTRACTOR INCREASES THE THICKNESS OF THE BOTTOM FLANGE PLATE AT A BEARING LOCATION, HE SHALL MAINTAIN THE ORIGINAL GIRDER ELEVATION BY MAKING SUITABLE CHANGES IN THE ELEVATION OF THE CONCRETE MASONRY.
5. ALLOWANCES SHALL BE MADE IN THE SHOP FOR SHRINKAGE DUE TO WELDING AND BURNING. IF UNEVEN SHRINKAGE IS ANTICIPATED, CAMBER ORDINATES SHALL BE ADJUSTED ACCORDINGLY.
6. FLANGE AND WEB SHOP SPLICES ARE TO BE COMPLETED AND WELDMENTS INSPECTED BEFORE FITTING AND WELDING FLANGES TO WEBS. FABRICATION METHODS WHICH MAY BE REQUIRED FOR SPECIAL CONDITIONS, SHALL BE INCLUDED IN THE WRITTEN WELDING AND PROCEDURE SPECIFICATIONS OF THE SHOP PLANS.