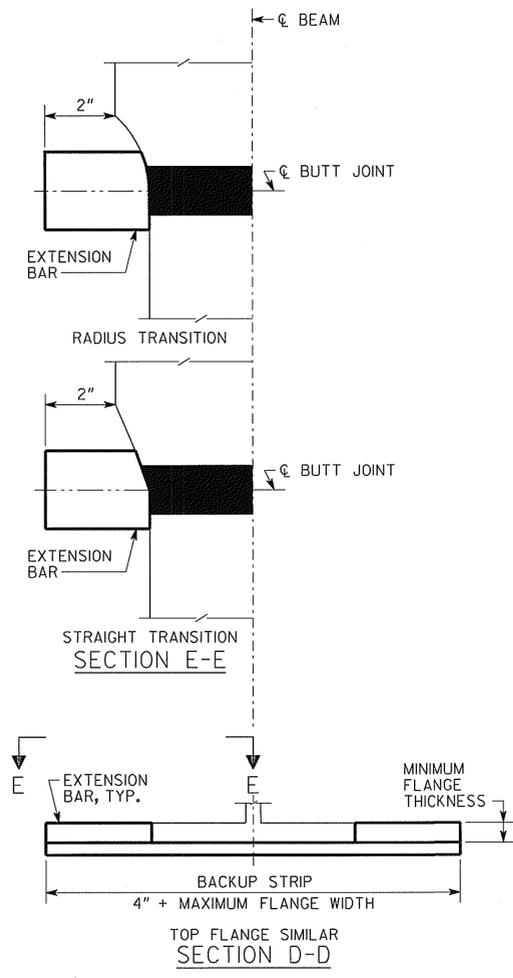
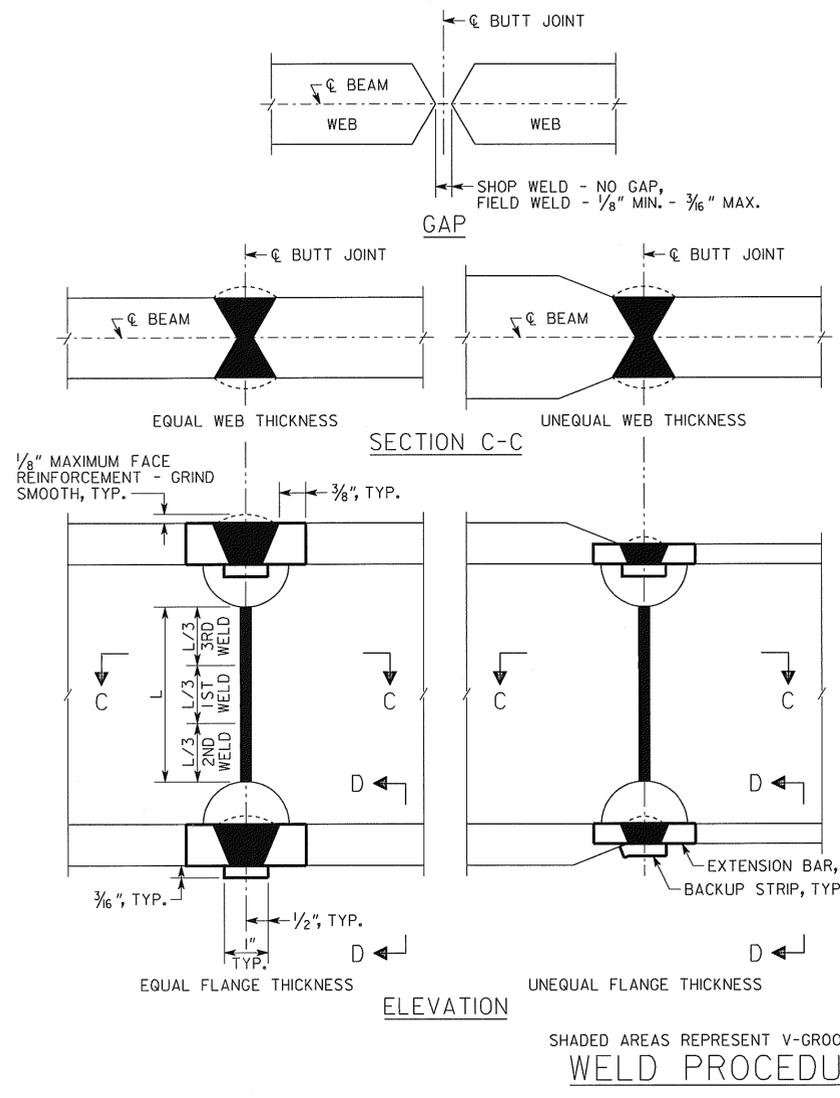


SHOP PREPARATION

SHOP PREPARATION WELD PROCEDURES
FOR DETAILS NOT SHOWN, SEE REMAINING PORTIONS OF THIS SHEET
BOTTOM FLANGES - W36



WELD PROCEDURES
SHADED AREAS REPRESENT V-GROOVE WELDS.

NOTES

- 1) THE TERM "SPlice" AS USED IN THESE NOTES AND GEORGIA DOT SPECIFICATIONS IS SYNONYMOUS WITH THE TERM "BUTT JOINT".
- 2) THE CONTRACTOR SHALL SUBMIT HIS PROPOSAL FOR ALTERNATE LOCATIONS OF SPLICES TO THE BRIDGE ENGINEER, WHOSE WRITTEN APPROVAL SHALL BE REQUIRED BEFORE THE WORK PROCEEDS. SEE SUB-SECTION 501.1.03.B.6 OF THE GEORGIA DOT SPECIFICATIONS.
- 3) DETAILS ARE SYMMETRICAL ABOUT C SPLICED AND C BEAM UNLESS NOTED. C BEAM EQUALS C GIRDER.
- 4) THE BOTTOMS OF THE TOP FLANGES SHALL BE ALIGNED.
- 5) SPLICE SHALL BE FURNISHED IN CONFORMANCE WITH SECTION 501 OF THE GEORGIA DOT SPECIFICATIONS.
- 6) WORK SHALL BE PROTECTED FROM MOISTURE DURING WELDING AND UNTIL PARTS WELDED HAVE COOLED TO ATMOSPHERIC TEMPERATURE. LEAVE COPE HOLES OPEN.
- 7) WHEN WELDING ASTM A709 GRADE 36 AND ASTM A709 GRADE 50, WELDING SHALL BE DONE USING SPECIFICATIONS OF ASTM A709 GRADE 50.
- 8) ONLY E70XX (EXCLUDING E7014 AND E7024) LOW HYDROGEN ELECTRODES SHALL BE USED FOR MANUAL SHIELDED METAL ARC WELDING.
- 9) SEQUENCE OF WELDS: FIRST - WEB, SECOND - BOTTOM FLANGE, THIRD - TOP FLANGE. USE TWIN ARC TECHNIQUE ON WEB AND BOTTOM FLANGE.
- 10) AFTER WELDING REMOVE THE BACKUP STRIPS AND EXTENSION BARS. WELDS SHALL BE GROUND SMOOTH. GRINDING SHALL BE DONE PARALLEL TO THE LENGTH OF THE BEAM. CHIPPING WILL NOT BE ALLOWED. ANY VISUAL IMPERFECTIONS SHALL BE REPAIRED BY WELDING AND GRINDING AS STATED ABOVE.
- 11) AFTER REMOVING BACKUP STRIPS AND EXTENSION BARS CLEAN AND PAINT THE SPLICE AREA IN ACCORDANCE WITH GEORGIA DOT SPECIFICATION SECTION 535.

MINIMUM PREHEAT AND INTERPASS TEMPERATURE
THICKNESS OF THICKEST PART AT POINT OF WELDING

THICKNESS	TEMPERATURE	
	ASTM A 709 GRADE 36	ASTM A 709 GRADE 50
ZERO TO 3/4" INCLUSIVE	NONE	NONE
OVER 3/4" TO 1 1/2" INCLUSIVE	150° F	50° F
OVER 1 1/2" TO 2 1/2" INCLUSIVE	225° F	150° F
OVER 2 1/2" TO 4" INCLUSIVE	300° F	225° F

BRIDGE NO. 1

GEORGIA
DEPARTMENT OF TRANSPORTATION
PRECONSTRUCTION DIVISION-OFFICE OF BRIDGE DESIGN

BUTT JOINT DETAILS
SR 9 (ROSWELL ROAD) OVER I-285
FULTON COUNTY CSMSL-0009-00(159)

DRAWING NO.
35-12
BRIDGE SHEET
12 OF 18

DATE	02/7/11
BY	JPT
PROJ. & SHEET NOS.	

DESIGNED	MLC II	CHECKED	JPT	REVIEWED	WMD/WEI
DRAWN	EJW/MLC II	DESIGN GROUP		APPROVED	PVL

MAY 1991

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