



MATERIAL SPECIFICATION	
SHAFT	STEEL OF SOLID P-51 MINIMUM YIELD AFTER FABRICATION ASTM A-572 GR.50 ASTM A-36 OR A ASTM A-500 GR.50 ASTM A-1011 GR.50, ASTM A-1018 GR.50 THE ABOVE LISTED MATERIALS ARE USED BASED UPON AVAILABILITY AT THE TIME OF PURCHASE OF MATERIAL. LOTS FOR PRODUCING POLE AND ARM SHAFTS
BOTTOM & TOP SLIP PLATE ANCHOR PLATE MEDIAN BARRIER BASE	ASTM A-572 GR. 50 STEEL
MISC. PLATE	ASTM A-36
PIPE	ASTM A-53 GRADE B OR ASTM A-500 GRADE B
ANCHOR BOLTS	ASTM F-1554 GR. 105
POLE	HOT DIP GALVANIZED PER ASTM A-123
HARDWARE FINISH	HOT DIP GALVANIZED PER ASTM F2329
WELDS	BE WELDED BY THE ELECTRICAL RESISTANCE PROCESS
LONGITUDINAL WELDS	BUTT WELD WITH PERMANENT BACK-UP RING (CONTINUOUS)
CIRCUMFERENTIAL WELDS	ASTM A-572 GR. 50 STEEL
TOP SLIP PLATE	ASTM A-572 GR. 50 STEEL
MEDIAN BARRIER PLATE	ASTM A-572 GR. 50 STEEL

NOTES

1. WELD: ALL BUTT WELDS TO BE GROUND FLUSH WITH BASE METAL. WELDING OF STRUCTURES SHALL BE IN ACCORDANCE WITH THE LATEST EDITION OF THE AWS STRUCTURAL WELDING CODE D1.1 - STEEL. LONGITUDINAL SEAM WELD IS 80% MIN. PENETRATION, EXCEPT FOR 6" FROM END OF SECTION AT FLANGE, BASEPLATE AND SLIP JOINT ARE 100% PENETRATION.

ORDERING INFO

SERIES: T-4010D-SB-W3720
LUMINAIRE MOUNTING HEIGHT: D = DOUBLE ARM

LEGEND:
SB = SLIP BASE
FB = FIXED BASE
BM = BRIDGE MOUNT
MB = MEDIAN BARRIER

- DOUBLE ARM CONNECTIONS ARE FABRICATED FROM TWO PIPE ELBOWS WELDED BACK TO BACK AND A 1/4" [6] GUSSET.
- POLES WITH DOUBLE ARMS ARE TO HAVE A 7 GA. THICKNESS. ALL DAVIT SECTIONS ARE TO BE 11 GA.
- FOR POLES REQUIRING DIFFERENT POLE LENGTHS "T" THAN SHOWN, ADJUST POLE BASE DIAMETER BY USING A TAPER OF (0.14 IN/FT) [12mm/m].
- ALL WIREWAYS SHALL BE DEBURRED, ROUNDED AND SMOOTH FOR WIRE PROTECTION PURPOSES.
- THE TOP SLIP PLATE WITHOUT BOTTOM SLIP PLATE AND ANCHOR PLATE IS A FIXED BASE. WHEN A FIXED BASE IS REQUIRED BY THE CONTRACT PLANS, ROTATE THE ANCHOR BOLT PATTERN SHOWN ON STANDARD PLAN J-28.30-00 AND INSTALL THE TOP SLIP PLATE DIRECTLY ON THE FOUNDATION.
- THE MEDIAN BARRIER SHALL BE USED ON 50' MAXIMUM LIGHTING STANDARDS WITH 16' MAXIMUM LENGTH DOUBLE ARMS.
- 3 1/2" SCH. 40 PIPE FOR LUM. ARMS 10'-0" [3] AND LESS. 4" SCH. 40 PIPE FOR LUM. ARMS 12'-0" [3.7] AND LONGER.
- 3" SCH. 40 PIPE FOR LUM. ARMS 10'-0" [3] AND LESS. 3 1/2" SCH. 40 PIPE FOR LUM. ARMS 12'-0" [3.7] AND LONGER.
- WHEN NEEDED FOR GALVANIZING LIFTING PURPOSES, A NOMINAL 3/8" DIAMETER HOLE WILL BE PLACED AT APPROXIMATELY 1" FROM END OF SHAFT.
- TACK WELD BACK-UP RING AT ROOT (FROM OUTSIDE), WHERE FULL PEN WELD IS PLACED BETWEEN SHAFT WALL AND BASE PLATE.



APPROVED

Manufacturer's Pole Plan
Approved For Listing As A
Pre-Approved Drawing
WSDOT Bridge & Structures Office
By *GB* Date 1-29-2015

REV	DATE	DESCRIPTION	BY	APPR
K	1/15	REV. DETAIL "A", "B" & "N"	MHM	GM
J	1/15	ADDED ANCHOR PLATE DETAIL	JJ	MHM
H	1/15	REMOVE TACK WELDS & REVISED NOTE 7	MHM	GM

Ameron POLE PRODUCTS DIVISION

STATE OF WASHINGTON
"T" SERIES LIGHTING STANDARD

DRAWN: MHM DATE: 02/03 SCALE: DWG. NO. W3720-1
APPR: *GB* DATE: 02/03 REV. K