

1 (August 5, 2013)  
2 The girders shall also be shop assembled either completely or progressively in  
3 the transverse direction. The transverse shop assembly shall consist of a  
4 minimum of two adjacent girders, with pier diaphragms, intermediate  
5 diaphragms and cross bracing, and temporary bracing between girders at the  
6 end of the shop assembly (longitudinally). Staging of the transverse shop  
7 assembly shall proceed along with the longitudinal shop assembly. Each next  
8 stage of the transverse shop assembly shall be assembled to one of the  
9 previous transverse shop assemblies, repositioned if necessary, and pinned to  
10 ensure accurate alignment. Unless otherwise specified, the girders shall be  
11 blocked or supported in the no-load position.  
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13 After acceptance of the shop assembly by the Engineer, pier diaphragms,  
14 intermediate diaphragms and cross bracing utilized in the transverse shop  
15 assembly shall be removed from the girders and shipped to the bridge  
16 construction site each as individual units. Shop bolted connections in the  
17 diaphragms and cross bracing shall be completed and fully tightened to the  
18 minimum tension specified during the shop assembly. Fully tightened  
19 connections shall be inspected prior to shipping.