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(January 5, 2015)
Monotube Sign Structures

Bolted Connections

All bolted connections shall be made using the direct tension indicator method in accordance with Section 6-03.3(33).

Surfaces of Bolted Connections and Base Plates

All bolted connection faying surfaces shall be flat after fabrication as required to provide a solid fit upon assembly in accordance with Section 6-03.3(33). The flatness of the faying surfaces shall be flat to within a tolerance of 1/32 inch in 12 inches and a tolerance of 1/16 inch overall. Base plates with leveling nuts shall be flat to within a tolerance of 1/8 inch in 12 inches and a tolerance of 3/16 inch overall.

In order to achieve the flatness requirements, the Contractor may need to mill or machine the plates. The Contractor shall adjust plate thicknesses as required to provide the plate thickness specified in the Plans after milling or machining operations.

At bolted connections, both faying surfaces shall be at right angles to the bolt axis, parallel to each other, and shall be in full contact in the assembled condition. Full contact is defined as 90-percent of the outside and inside perimeters of the splice plates being visually in contact. The outside surface shall be inspected just inside the shell of the monotube and the inside shall be inspected at the handhole. Splices shall be fabricated such that the required camber remains continuous and smooth across the field splice.

Shop Assembly

Prior to galvanizing, the Contractor shall shop assemble the completed structure lying on its side in an undeflected position to ensure correct alignment, accuracy of holes, fit of joints, smooth camber profile, and the specified amount of camber. The joints shall be bolted with a sufficient number of bolts tightened snug tight to close the joints as they would be in the final field assembled position and as specified in the **Surfaces of Bolted Connections and Base Plates** subsection of this Special Provision. The Contractor shall not disassemble the sign structure for galvanizing as specified until receiving the Engineer's approval of the shop assembled structure.

Zinc Coating and Painting

All galvanized surfaces exposed to view after erection shall be shop painted or shop powder coated in accordance with Section 6-07.3(11), except when the Plans or Special Provisions require field painting only in accordance with Sections 6-07.3(9)I and 6-07.3(11)A. Contact surfaces of the field bolted connections shall be left as galvanized without any overcoat.

The color of the finish coat shall match color No. 35237 Federal Standard 595 latest edition when dry.

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All galvanized surfaces specified to be painted or powder coated shall be prepared for coating in accordance with the ASTM D 6386 and Section 6-07.3(11). The method of preparation shall be as agreed upon by the paint or powder coating manufacturer and the galvanizer.

After completing erection, the Contractor shall repair all metal surfaces with damaged paint or powder coatings and exposed metal with a field repair coating in accordance with Section 6-07.3(9)I and Section 6-07.3(11)A (for paint) or Section 6-07.3(11)B (for powder coating). The color of the finish coat of the field repair coating, when dry, shall match the color specified above.

Field Assembling

The Contractor shall furnish and install the vibration damper as shown in the Plans. The damper shall be installed before the sign structure is erected.

Welding Inspector Qualification

The fabricator shop will provide a Certified Welding Inspector. The inspector shall be a AWS Certified Welding Inspector (CWI) qualified and certified in accordance with the provisions of AWS QCI Standard for Qualification and Certification.

Welding Inspection

Welds for monotube sign structures shall be inspected using the methods described below.

1. Visual Inspection in accordance with Section 6-03.3(25)A1.
2. Magnetic Particle Inspection in accordance with Section 6-03.3(25)A4.
3. Ultrasonic Inspection in accordance with Section 6-03.3(25)A3.
4. Dye-Penetrant or Magnetic Particle Inspection
The post to beam connection weld shall have 100 percent of its length inspected using dye-penetrant or magnetic-particle testing techniques. The inspection shall be performed after the root pass and after completion of the weld.