



Florida Department of Transportation

JEB BUSH
GOVERNOR

605 Suwannee Street
Tallahassee, FL 32399-0450


JOSÉ ABREU
SECRETARY

April 25, 2003

THIS MEMO HAS EXPIRED

MEMORANDUM NO. 07-03

TO: DISTRICT CONSTRUCTION ENGINEERS

FROM: Ananth Prasad, State Construction Engineer 

COPIES: William Nickas, Tom Malerk, Dave Sadler, and Bob Burleson (FTBA)

SUBJECT: MULTIROTATIONAL BEARINGS

The requirement to seal metal surfaces of multirotational bearings with a vinyl wash primer is being deleted since this material is highly toxic and many of the manufacturers are not licensed to apply the product. In addition, the State Materials Office has determined that the primary protective coating will be fully effective without a sealer.

Therefore, please process a \$ 0.00 specification change, as applicable, **for active contracts**. Contracts let in January 2004 and thereafter will have the revised language included in the contract.

The Specification change is as follows:

SUBARTICLE 461-2 (of the Supplemental Specifications). The first paragraph is deleted and the following substituted:

Furnish structural steel conforming to ASTM A 709 Grade 50W [ASTM A 709M Grade 345W]. Coat all exposed steel surfaces with a thermal sprayed coating (metalization). Blast clean surfaces with grit abrasive in accordance with Steel Structures Painting Council Surface Preparation Specification No. 10, SSPC-SP10, Near-White Blast Cleaning, to a surface profile of 0.002 - 0.004 inch [0.05 - 0.10 mm]. Use the electric arc spraying process. Provide wire material for the metalized primer consisting of 85% zinc and 15% aluminum, each being 99.9% pure metal. Prepare a sample coupon using the same processes used to prepare the

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surface and apply the coating to the bearing. Test the coating bond strength on the coupon in accordance with ASTM D4541. The bond strength must be a minimum of 700 psi [4.8 MPa]. If the bond strength of the coating on the coupon is deficient, test the coating on the bearing. If the required bond strength is achieved, repair the coating. Provide the Engineer with a certified statement that the coating applicator has performed successful thermal spray operations within the last 12 months.

This memorandum serves as a blanket approval to process a specification change and should be attached to the Field Supplemental Agreement/Work Order or the Supplemental Agreement.

If you have any questions, please contact Steve Plotkin at 850-414-4155 (suncom 994-4155).

AP/pw