

EXPECTED IMPLEMENTATION (FY 2023-24)

460 STRUCTURAL STEEL AND MISCELLANEOUS METALS (REV 9-14-22) (FA 9-21-22) (FY 2023-24)

SUBARTICLE 460-1.2 is deleted and the following substituted:

460-1.2 Fabrication Categories: As a prerequisite for being on the Department's Production Facility Listing, fabricators must currently be accredited in accordance with one of the programs in Table 460-1, by fabrication category/categories of the products that they are producing.

Fabricators are required to submit their proposed fabrication Quality Control (QC) Plan for review by the Department.

Table 460-1 Fabrication Categories	
Structure Type	Accepted Accreditation Program
Simple Steel Bridge: Pedestrian bridge (prefabricated steel truss pedestrian bridges meeting the Category 1 conditions of FDOT Design Manual 266.4), bridge grid decking	AISC Simple Bridge
Steel Bridge: Vehicular bridge, Pedestrian bridge (all others)	AISC Advanced Bridge Fracture Critical Endorsement
Structural Highway Metal Components, Group I: bridge machinery, bridge bearings, modular joints, load plates, laminated bearing pads, cantilever, truss/span, monotube, gantry, mast arms, steel light poles, aluminum light poles, aluminum j-arms, drainage (welded gratings, frames, inlets)	AISC Components Manufacturer or AWS Welding Fabricator
Structural Highway Metal Components, Group II: bridge forgings, bridge castings, steel railing, aluminum railing, castings (manhole, grating, inlet, frame), guardrail, coated steel fence, elastomeric bearing pads, stay in-place forms	ISO 9001
Notes: An AISC fracture critical (FC) endorsement is required for all FC work. Other accreditations programs may be submitted to the FDOT State Materials Office for review and consideration in addition to the programs listed in the table above.	

SUBARTICLE 460-6.4.2 is deleted and the following substituted:

460-6.4.2 Tubular Bridge: Comply with the requirements of the AWS D1.1 Structural Welding Code as amended by the following:

Unless otherwise shown in the Plans, perform ultrasonic testing (UT) or radiographic testing (RT) on full penetration groove welds at the following frequency (use the AWS D1.1 Tubular Connections Class R Criteria for UT and Cyclically Loaded Criteria for RT).

EXPECTED IMPLEMENTATION (FY 2023-24)

One hundred percent of each joint subject to tension or reversal of stress.

Twenty-five percent of each joint subject to only compression or shear. If unacceptable discontinuities are found in the joint, the remainder of the joint shall be tested.

Perform Magnetic Particle Testing at the following frequencies:

A minimum of 25% of all fillet or partial penetration groove welds in main members (Use the AWS D1.1 Tubular Connections Criteria). If unacceptable discontinuities are found, the remainder of the welds on the members shall be tested.

SUBARTICLE 460-6.4.3 is expanded by the following:

460-6.4.3 Overhead Sign Structures and Toll Gantries: Comply with the requirements of the AWS D1.1 Structural Welding Code as amended by the following:

Unless otherwise shown in the Plans, perform 100 percent ultrasonic testing (UT) or radiographic testing (RT) on all full penetration groove welds.

Prior to galvanizing, perform Magnetic Particle Testing (MT) at the following frequencies:

One hundred percent of all fillet or partial penetration groove welds in the upright columns. A minimum of 25% of all other fillet or partial penetration groove welds in main members other than upright columns. If unacceptable discontinuities are found, the remainder of the welds on the member shall be tested.

After members are galvanized, perform one hundred percent MT of all fillet welds in the upright columns.

For acceptance, use AWS D1.1 Tubular Connection Criteria for MT, Tubular Connection Class R Criteria for UT, and Cyclically Loaded Criteria for RT.