

9620000 STRUCTURAL STEEL AND MISCELLANEOUS METAL ITEMS (OTHER THAN ALUMINUM)  
COMMENTS FROM INTERNAL/INDUSTRY REVIEW

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Larry Jones  
(850)-414-4305  
Larry.Jones@dot.state.fl.us

Comments: (7-22-22 Industry)

I cannot find where the CJP requirement is reinserted after 962-8.8 was deleted. All seams and welds in steel pipe piles, particularly spiral (helical) welded pipe, must be CJP to ensure quality dynamic testing data can be collected during construction. This requirement was put in place to eliminate issues observed with non CJP helical welded pipe.

Response:

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David A. Bancroft, P.E.  
[dbancroft@flbridge.com](mailto:dbancroft@flbridge.com)  
407-513-9709 (Ext. 244)

Comments: (8-10-22 Industry)

In the proposed Specification Section 962-9 “Overhead Signs” (which is incorrectly labeled as 962-8) there is no section for anchor bolts and nuts. This would revert the contractor back to section 962-8.2 in which grades 36, 55, and 105 are all allowed. However, this conflicts with Structures Manual Volume 3 Section 5.16.2, which limits the anchor bolt material only to ASTM F1554 Grade 55. I would recommend adding a section within Table 962-10 that covers the anchor bolt and nut material requirements specifically for overhead sign structures.

<b>5.16.2 Anchor Bolt Materials</b> <i>Add the following:</i> Only use ASTM F 1554 anchor bolts with 55 ksi yield strength.	<b>C 5.16.2</b> <i>Add the following:</i> ASTM F 1554 Grade 55 anchor bolts provide sufficient ductility after yield to engage all the anchor bolts on the tension side of the base plate.
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Response:

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Tim McCullough  
[Timothy.McCullough@dot.state.fl.us](mailto:Timothy.McCullough@dot.state.fl.us)  
(352) 955-6681

Comments: (8-9-22 Industry from the Originator)

These items should be corrected when the document comes back for review, per the request of the production facility, Arcosa Traffic Structures. Recommended revisions shown in red.

1. Identify the UT testing criteria for the upright material used in Sign Structures (Several Industry standards).

Table 962-10 – Requirements for Overhead Signs					
Product	Standard	Grade	Type/ Style	Reportable Properties	Supplementary Requirements
Upright Pipe	API 5L	X42R, X42N, X42M, X46N, X46M, X52N, X52M, X56N, X56M, X60N, X60M, X65M, X70M	PSL2	Killed, Fine Grain, Tensile, CVN Test	N/A
	A500	B, C	Round Structural	Composition, Yield, Tensile, Elongation	UT Seam Weld (per API 5L), CVN Test per 962-2

Response: