

EXPECTED IMPLEMENTATION JULY 2023

965 GENERAL PROVISIONS FOR ALUMINUM ITEMS (INCLUDING WELDING).

(REV 6-21-22) (FA 8-25-22) (FY 2023-24)

ARTICLE 965-2 is deleted and the following substituted:

965-2 Fabrication.

Provide fabricated components in accordance with AASHTO LRFD Specifications for Structural Supports for Highway Signs, Luminaires and Traffic Signals, the Design Plans, and this section. Verify the strength of each Lot by tensile test. Alternate testing will not be accepted. Protect against damage and marring during transit and delivery. Provide an anodic coating (minimum 0.0002 inch) and chromate seal all hardware.

Table 965-1 Material Requirements for Aluminum Components			
Product	Test Method	Alloy/Temper	Reported Properties
Pole, Arm, Extrusions	ASTM B221	6061-T6	Alloy, Temper, Thickness, Tensile Strength
		6063-T6	
Pedestal, Posts	ASTM B429	6061-T6	
Bars, Plates, Stiffeners, Backing Ring, Shims, Shapes	ASTM B221	6063-T6 6061-T6	
	ASTM B209	6061-T6	
	ASTM B308		
Railing	ASTM B221	6351-T5	
	ASTM B241	6061-T6	
	ASTM B210		
	ASTM B429		
J-Arm Tube	ASTM B429	6061-T6	
	ASTM B221		
J-Arm Connection Plate	ASTM B209	6061-T6	
Sheet	ASTM B209	6061-T6	
		5154-H38	
		5052-H38	
Structural Shapes	ASTM B308	6061-T6	
	ASTM B221		
Single Column Ground Sign Sand Castings	ASTM B26	A356-T6	
	ASTM B108	A356-T61	
Washers	ASTM B221	7075-T6	
		2024-T4	
Button Head or Flat Head Bolts	ASTM F468	2024-T4 6061-T6	S2 Lot Testing, Alloy, Temper

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Hex Nuts	ASTM F467	6061-T6 6262-T9 2024-T4	S2 Lot Testing, Alloy, Temper
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965-2.1 Light Poles: Provide aluminum lighting poles in accordance with this section and Table 965-1. Weld arms and poles in the T4 condition, using the filler metal ER4043, ER4047, ER5183, ER5356, or ER5556 in accordance with AWS D1.2 Aluminum Structural welding Code. Weld to castings in accordance with 965-2.3. Heat treat the arm and pole, until aged to the T6 condition. Transverse welds are only allowed at the base. Equip poles with a vibration damper, when specified in the contract documents.

Provide exterior surface with a clean, uniform silvery appearance, free of dark streaks and discoloration. Finish the pole and arm with a satin rubbed finish.

965-2.2 Overhead Sign Components: Provide aluminum toll gantry J-arms in accordance with this section and Table 965-1. Weld tube to plate connections in the T4 or T6 condition, using the filler metal ER4043, ER4047, ER5183, ER5356, or ER5556 in accordance with AWS D1.2 Aluminum Structural welding Code. Heat treat tube and plate in the T4 condition until aged to the T6 condition.

Provide exterior surface with a clean, uniform silvery appearance, free of dark streaks and discoloration.

965-2.3 Castings: Provide aluminum castings in accordance with this section and Table 965-1. Weld aluminum castings to itself or aluminum tube to castings using the filler metal ER4043, in accordance with AWS D1.2 Aluminum Structural welding Code. Heat treat the castings, until aged to the T6 condition.

965-2.4 Railing: Provide aluminum railing in accordance with this section and Table 965-1. Weld aluminum railing using the filler metal ER4043, ER4047, ER5183, ER5356, or ER5556 in accordance with AWS D1.2 Aluminum Structural welding Code.

965-2.5 Static Sign Assemblies: Provide aluminum sheet, plate and structural shapes in accordance with this section and Table 965-1. Weld structural profiles to itself or aluminum components using ER4043, ER4047, ER5183, ER5356 or ER5556 in accordance with AWS D1.2 Aluminum Structural Welding Code. Heat treat the structural profiles, until aged to the T6 condition.

965-2.6 Transformer Bases (Excluding Lighting):

965-2.6.1 Product Acceptance: Manufacturers seeking evaluation of products for inclusion on the APL shall submit an application in accordance with Section 6 and include the following documentation, showing that the product meets the applicable requirements.

Table 965-2 Submittal Compliance Requirements	
Documentation	Requirements
Certified Test Report	Shows that product meets Moment Capacity
Installation Instructions	Include installation instructions
Product Identification Photo	Display's the manufacturer's name or logo and the model number.

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Product Photo	Displays the significant features of the product as required in this section.
Technical Data Sheet or Product Drawing	Uniquely identifies the product and includes product details, notes, material specifications, dimensions, and sizes meeting the specification

965-2.6.2 Physical Requirements: Meet the requirements of Table 965-3.

Table 965-3 Physical Requirements for Transformer Base		
Feature	Requirement	Documentation
Height	Base is 12 to 18 inches in height	Technical Data Sheet or Product Drawing
Base Material	ASTM B26, 356 T6 or 319	Technical Data Sheet or Product Drawing
Threaded Hub	Hub located at the top for mounting a nominal 4-inch Schedule 40 (4-1/2-inch outside diameter) aluminum pole. The threaded hub must be tapped to allow full pole engagement.	Technical Data Sheet or Product Drawing
Fastening	Provides for fastening to a foundation with four 3/4-inch anchor bolts located 90 degrees apart. The base design must allow for bolts that are placed off-center.	Technical Data Sheet or Product Drawing
Door Size	Provides a door opening of not less than 8 inches by 8 inches.	Technical Data Sheet or Product Drawing
Door Material	The door must be constructed of fiberglass or other non-combustible, non-aluminum material.	Technical Data Sheet or Product Drawing
Door Attachment	Attach the door to the base with cleats and one stainless steel socket button head screw or by other means suitable for NEMA 3 electrical enclosures.	Technical Data Sheet or Product Drawing
Moment Capacity	Supports an ultimate moment capacity of 10,000 foot-pounds, without breaking, cracking or rupturing in any manner.	Certified Test Report
Breakaway	Meets the requirements in the AASHTO LRFD Specifications for Structural Supports for Highway Signs, Luminaires, and Traffic Signals.	FHWA Eligibility Letter.

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965-3 Paint for Poles, Pedestals, and Posts.

Paint systems used on aluminum poles, pedestals, and posts shall meet the color requirements as specified in the Contract Documents. All paint systems shall possess physical properties and handling characteristics that are compatible with the application requirements of Section 646. Materials shall be specifically intended for use over aluminum. Paint systems shall exhibit no loss of adhesion or total color difference (ΔE^*_{ab}) greater than 8.0 units for five years after final acceptance as specified in 5-11. An aluminum pole, pedestal, post, or sign panel that exhibits a cumulative surface area of delamination in excess of 50 square inches will constitute an adhesion failure. Delamination shall be defined as any area of exposed metal surface subsequent to hand tool cleaning. A ΔE^*_{ab} value exceeding 8.0 units per the International Commission on Illumination L*a*b* 1976 (CIELAB) space and color difference formula, measured in accordance with ASTM D2244, will constitute a color retention failure.

The Department will measure and enter in the Department's database the CIELAB color chromaticity coordinates for the color of the top coat of sample coupons provided as required by 646-2.7 using a BYK-Gardner Handicolor colorimeter using D65 illuminant and 2-degree geometry settings. The Department-measured CIELAB chromaticity coordinates shall define the initial color and will be used for resolution of color retention failures and the resolution of color retention disputes.

965-4 Certification.

Produce a certificate of compliance for non-APL products, upon request of the Engineer. Certificates of compliance shall identify the reportable properties of Table 965-1.