

9650000 GENERAL PROVISIONS FOR ALUMINUM ITEMS (INCLUDING WELDING)  
COMMENTS FROM INTERNAL/INDUSTRY REVIEW

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Melissa Hollis  
(850) 414-4182  
[Melissa.Hollis@dot.state.fl.us](mailto:Melissa.Hollis@dot.state.fl.us)

Comments: (5-11-21, Internal)

Only a formatting request... Can the table be before/after the paragraph, not in the middle of a sentence?

Response: Missy brought up a good comment, it was ultimately a typo. Moved the language below the table and accept the change recommended by Missy. No language was added/changed.

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Ananth Prasad  
(850) 942-1405  
[aprasad@ftba.com](mailto:aprasad@ftba.com)

Comments: (5-12-21, Internal)

Valmont has the following concerns:

Concerns regarding the material certification requirements. It appears additional supplementary information may now be expected beyond what we and our suppliers currently provide. I suspect this is information we could obtain, but there may be a cost associated with it. In addition, Valmont and Akron Foundry both do substantial work with DOT's across the country who are also requiring certs and I am not aware of these additional requirements being requested by others entities.

Response: Many of the recent Aluminum ASTMs have lowered their standards of reporting, essentially moving the reporting of tensile to voluntary or at the request of the Owner.

The request in the specification change does not alter/change the testing requirements. All aluminum producers are required to perform a tensile test per Lot of material produced. The revision only asks for the certification to report the tensile test results. A distributor cannot certify material to an ASTM without knowing the tensile results. Because of that, there is no anticipated cost change. The reason for the reporting is outlined below.

The Department has seen multiple material failures, that were directly related to the distributors/suppliers not performing the tensile test as specified in the ASTM and thus the material never met the strength requirements specified in the ASTM. By the Owner specifying that they want the tensile test reported, it stays within the requirements of the ASTM, and addresses a need identified by the Department to prevent failing material from reaching the roadway. It also protects the producers from purchasing from distributors/suppliers that are certifying material to an ASTM standard without performing the appropriate testing.

Most active producers have already begun asking for the reporting of the tensile test to prevent them from receiving / incorporating bad material into an FDOT project. The only impact on the Contractor or producer has been / would be the request of the tensile results on the purchase order.

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Neil Monkman  
(239) 462-7371  
[neil.monkman@wcfgfl.com](mailto:neil.monkman@wcfgfl.com)

Comments: (5-21-21, Industry)

Perhaps I missed it, but section 965-1 is being eliminated and I did not see anything to replace requirements for shipping. In my opinion there must be something that requires protection of the items during shipping. If not, you are opening up a can of worms for a contractor to claim something unforeseen. Since other sections allow claim for items "beyond the reasonable control of the contractor", shipping methods would fall under that. There needs to be something so contractors can hold fabricators accountable. (IMO)

Response: 965-2 addresses this request "Protect against damage and marring during transit and delivery.". The language already existed within the Specification; it was just moved.

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Paul Hughes  
(813) 929-0841  
[paul.hughs@delamereindustries.com](mailto:paul.hughs@delamereindustries.com)

Comments: (5-24-21, Industry)

In Specification 9650000, Table 965-1. Railing Alloy Temper should include 6063-T6 for rolled or bent components such as end hoops or radius railing.

Response: The 6063-T6 material is a lower strength than the comparable 6061-T6 (B221). Since it is not in the design standard plans, it will be considered new business for the Department to consider lesser strength material for this application.

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No Name

Comments: (5-28-21, Industry)

Change "railing" to "railings" in 965-1. Add "in" after "Provide aluminum sheet, plate and structural shapes" in first sentence of 965-2.5.

Response: Adopted.

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