

4600604 STRUCTURAL STEEL AND MISCELLANEOUS METALS

COMMENTS FROM INTERNAL/INDUSTRY REVIEW

Keith Krieger

Work Phone: 561-389-1075

E-Mail: [keith.krieger@dot.state.fl.us](mailto:keith.krieger@dot.state.fl.us)

Comments: (6-16-23 Industry)

The section now reads: Unless otherwise shown in the Plans, perform ultrasonic testing (UT) or radiographic testing (RT) on all complete joint penetration welds at the following frequency....this is confusing....first it says "all"....then it says "at the following frequency"....it can't be both.... May need to delete the word "all" (for both 460-6.4.1 and 460-6.4.2)

Response: (Specifications Office)

The inclusion of the word "all" was a typo.

Action(s): Typo corrected. Please see screenshot below for reference:

• SUBARTICLE 460-6.4.1 is deleted and the following substituted:¶  
→ → **460-6.4.1 Highway Sign, Lighting and Traffic Signal Support Structures:** For structural steel supports for signs, lighting, and traffic signals, comply with the AWS<sup>®</sup>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~~ **complete joint penetration** welds at the following frequency (use the AWS D1.1 Tubular Connections Class R Criteria for UT and Cyclically Loaded Criteria for RT).¶  
→ → → → 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 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 discontinuities are found, the remainder of the welds on the members shall be tested.¶  
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• SUBARTICLE 460-6.4.2 is deleted and the following substituted:¶  
→ → **460-6.4.2 Tubular Bridge:** Comply with the requirements of the AWS<sup>®</sup>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~~ **complete joint penetration** welds at the following frequency (use the AWS D1.1 Tubular Connections Class R Criteria for UT and Cyclically Loaded Criteria for RT).¶

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