

EXPECTED IMPLEMENTATION JULY 2024 (FY 2024-25)

460 STRUCTURAL STEEL AND MISCELLANEOUS METALS. (REV 6-15-23) (FA 8-21-23) (FY 2024-25)

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 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 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.

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 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 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.

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SUBARTICLE 460-6.4.3 is deleted and the following substituted:

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 complete joint penetration 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.