



*Florida Department of Transportation*

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GOVERNOR

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JARED W. PERDUE, P.E.  
SECRETARY

November 6, 2023

Khoa Nguyen  
Director, Office of Technical Services  
Federal Highway Administration  
3500 Financial Plaza, Suite 400  
Tallahassee, Florida 32312

Re: State Specifications Office  
Section: 649  
Proposed Specification: **6490201 Galvanized Steel Poles, Mast Arms, And Monotube Assemblies.**

Dear Mr. Nguyen:

We are submitting, for your approval, two copies of the above referenced Supplemental Specification.

The changes are proposed by Timothy McCullough to remove the requirement to have oversight by the FDOT audit program.

Please review and transmit your comments, if any, within two weeks (10 business days). Comments should be sent via email [daniel.strickland@dot.state.fl.us](mailto:daniel.strickland@dot.state.fl.us).

If you have any questions relating to this specification change, please call me at (850) 414-4130.

Sincerely,

Signature on File

Daniel Strickland, P.E.  
State Specifications Engineer

DS/jb

Attachment

cc: Florida Transportation Builders' Assoc.  
State Construction Engineer

**GALVANIZED STEEL POLES, MAST ARMS, AND MONOTUBE ASSEMBLIES.  
(REV 4-28-23)**

SUBARTICLE 649-2.1 is deleted and the following substituted:

**649-2.1 Pole Assembly:** Use pole assemblies as shown in the Standard Plans when standard mast arm assemblies, standard strain pole assemblies, or standard steel CCTV pole assemblies are required by the Contract Documents.

Obtain ~~poles, mast arm, and~~ monotube assemblies from a fabrication facility that is listed on the Department's Production Facility Listing. Producers seeking inclusion on the list shall meet the requirements of Section 105.

Obtain poles and mast arms from a fabrication facility that is approved in one of the following fabrication categories:

1. American Institute of Steel Construction, Highway Component  
Manufacturer

2. American Welding Society, Certified Welding Fabricator

3. Canadian Welding Bureau, Fusion Welding of Aluminum (W47.2)

Use coating products meeting the requirements of Section 975.

Use grouts meeting the requirements of Section 934 and listed on the Department's Approved Product List (APL).

Use water meeting the requirements of Section 923.

Use membrane curing compounds meeting the requirements of Section 925.

ARTICLE 649-3 is deleted and the following substituted:

**649-3 Fabrication.**

Fabricate poles, mast arm, and monotube assemblies and miscellaneous hardware in accordance with the Contract Documents. Cut all materials to the final dimensions and complete all welding prior to galvanizing. Obtain all components for individual strain poles, mast arm and monotube assemblies from the same fabricator. Obtain the luminaire and bracket from other sources, when necessary.

All welds must be visually inspected for final approval by an actively certified welding inspector, qualified through the American Welding Society. A certifying statement from the welding inspector must be provided with the components. The document must identify the project information, date of inspection, welding inspector name, and inspector certification number.

Affix an aluminum identification tag which will be visible from the handhole or located inside the terminal box containing the information described in the Standard Plans.

Before shipping, assemble monotube assemblies to assure proper fit. Monotube assemblies may be separated for shipment.

For mast arms, use adequate manufacturing controls to assure proper fit, ensuring dimensional tolerances are met and that mast arm to pole connections can achieve a snug-tight condition as defined in 649-7.

Ensure all components are protected from damage during shipping and handling by wrapping or other effective methods. Replace any component, which the Engineer determines is

damaged beyond repair, at no additional cost to the Department. If components are wrapped for shipment, remove wrappings no later than five days after receipt of components or immediately if the wrappings become saturated. Post these instructions in brightly colored wording on the wrapper. Failure to comply with these instructions may lead to damage of the coating system and will be cause for the rejection of the component.

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Obtain monotube assemblies from a fabrication facility that is listed on the Department's Production Facility Listing. Producers seeking inclusion on the list shall meet the requirements of Section 105.

Obtain poles and mast arms from a fabrication facility that is approved in one of the following fabrication categories:

- Manufacturer
1. American Institute of Steel Construction, Highway Component
  2. American Welding Society, Certified Welding Fabricator
  3. Canadian Welding Bureau, Fusion Welding of Aluminum (W47.2)

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Use grouts meeting the requirements of Section 934 and listed on the Department's Approved Product List (APL).

Use water meeting the requirements of Section 923.

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