

4600604 STRUCTURAL STEEL AND MISCELLANEOUS METALS
INTERNAL/INDUSTRY REVIEW COMMENTS

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Comments: (9-21-16, Internal)

I only have some editorial revisions to Section 460. The areas I have proposed for revision are highlighted in yellow.

herein.¶
→ → ~~460-6.4.1 Highway Sign Structures, Luminairesighting and Traffic Signals.~~
~~Support Structures:~~ For structural steel ~~supports for~~ sign structures, lighting poles, and traffic
signal poles, comply with the AWS D1.1 Structural Welding Code, as welland the weld
inspection as the additional requirements in Section 14.4.4.8 of the AASHTO Standard LRFD
Specifications for Structural Supports for Highway Signs, Luminaires and Traffic Signals,
Section 5.15, Welded Connections.¶

Response: Changes made.

John Westphal
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Comments: (9-27-16, Internal)

Upon consultation with Steve Duke of the SMO, I recommend pulling the proposed Specs 460-6.4.1 and 965-3 at this time. I do not object to the other proposed Specs though.

The rationale behind my recommendation is that Spec 460 as it is proposed references Section 14.4.4.8 of the AASHTO LRFD Specifications for Structural Supports for Highway Signs, Luminaires and Traffic Signals for weld inspection. This is problematic based on the following:

1. There is an option to perform destructive testing for weld testing at the Owner's discretion which is not desirable.
2. There is not clearly defined weld acceptance criteria within LRFD 14.4.4.8.

Similar ambiguities relating to weld acceptance criteria are present as well within Spec 965.

We would like to pull these Specs until such time as Steve and I can propose different language.

Response: Language added (highlighted) as proposed by Steve Duke to Section 460-6.4.1.

→ → ~~460-6.4.1 Highway Sign Structures, Luminairesighting and Traffic Signals.~~
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inspection as the additional requirements in Section 14.4.4.8 of the AASHTO Standard LRFD
Specifications for Structural Supports for Highway Signs, Luminaires and Traffic Signals,
Section 5.15, Welded Connections, amended by the following.¶
→ → → Unless otherwise shown in the Plans, perform ultrasonic testing (UT) or
radiographic testing (RT) on full penetration groove 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.¶
