

EXPECTED IMPLEMENTATION JULY 2017

965 GENERAL PROVISIONS FOR ALUMINUM ITEMS (INCLUDING WELDING). (REV 9-19-16) (FA 12-12-16) (7-17)

ARTICLE 965-3 is deleted and the following substituted:

965-3 Welding Aluminum Sign Structures.

Welding and weld details shall be in accordance with Section 14 of the AASHTO LRFD Specifications for Structural Supports for Highway Signs, Luminaries and Traffic Signals; ANSI and AWS D1.2 "Structural Welding Code - Aluminum", including the requirements for qualifications of procedures and welders, as specified therein.

1. Alloys: The aluminum alloys to welded under these specifications may be any of the following alloys:

Wrought Nonheat-treatable Alloys:

Alloy 3003
Alloy Alclad 3004
Alloy 5052
Alloy 5083
Alloy 5086
Alloy 5456

Wrought Heat-treatable Alloys:

Alloy 6061
Alloy 6063
Cast Heat-treated Alloy
Alloy SG-70A (ASTM Designation)

2. Filler Metals: The filler metals to be used with particular base metals shall be as shown in the table below except that other filler metals may be used if approved by the Engineer.

Base Metal	Filler Metal
3003 to 3003	ER1100
Alclad 3004 to Alclad 3004	ER4043
5052 to 5052	ER5356*
5083 to 5083	ER5183
5086 to 5086	ER5356*
5456 to 5456	ER5556
6061 to 6061	ER5356*
6063 to 6063	ER5356*
SG-70A to 6061	ER4043
SG-70A to 6063	ER4043

*ER5183, ER5356, and ER5556 may be used interchangeably for these base metals.