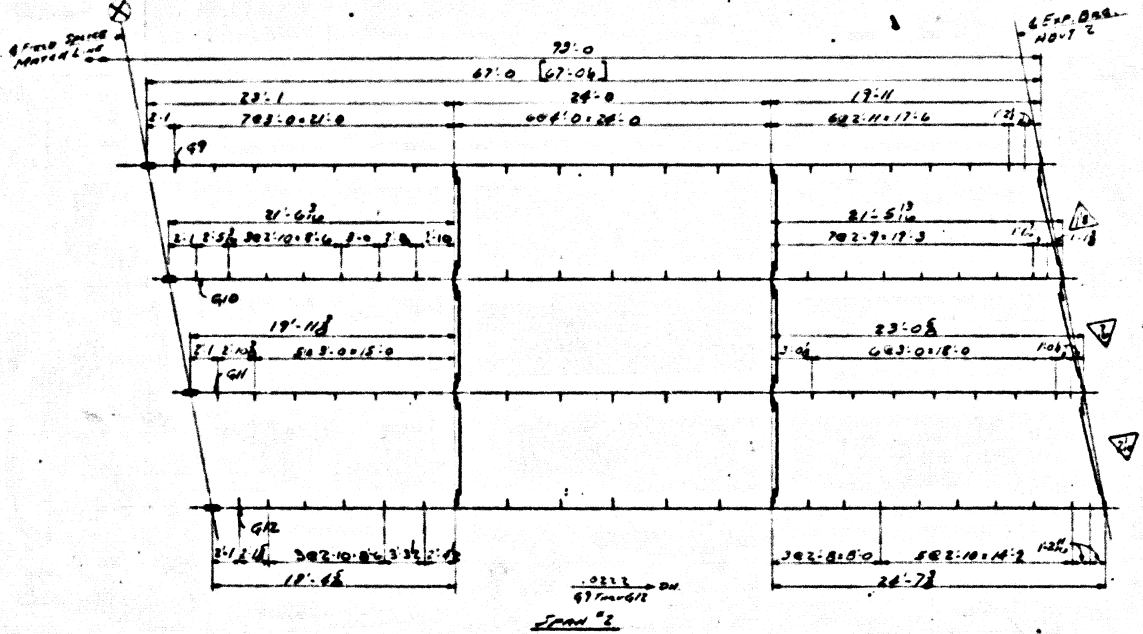


**NOTES:**  
 See Span #1 Note (Plan) - See 51 & 4  
 See Span #2 Note (Plan) - See 7 & 8  
 See Span #2 Note - R13, 14  
 See Span #2 - See 4 & 5  
 See R1 - 41 & 4

FIGURING PLAN



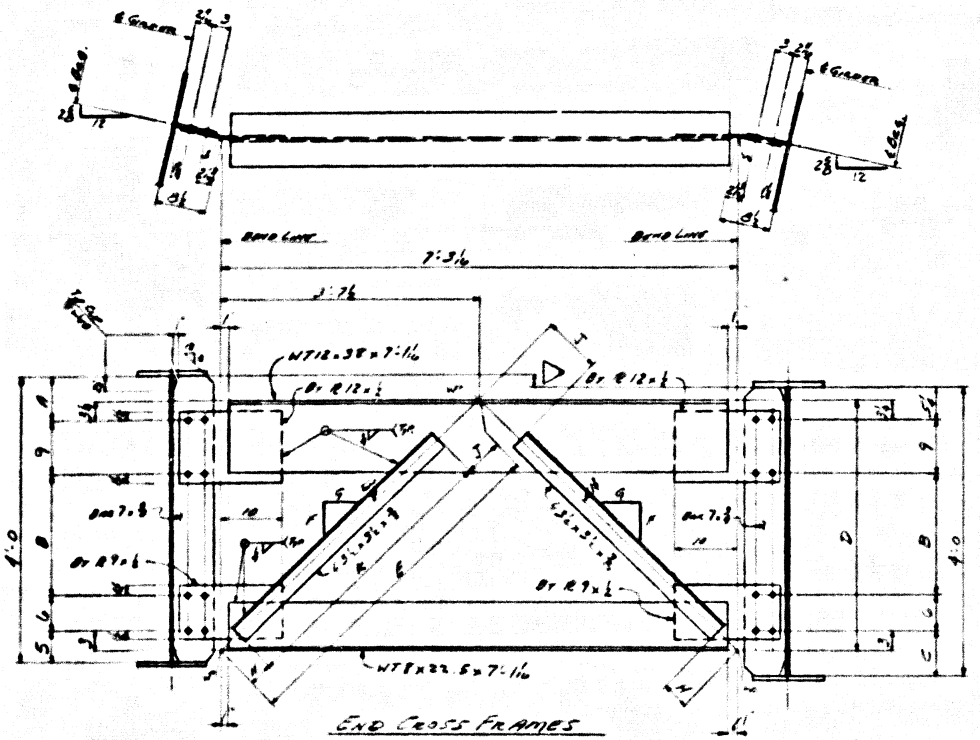
- NOTES:**
1. All Dimensions Are Given Horizontal Unless Other Than: [67'-0"] Which Includes Incurse Due To Grade.
  2. Dimensional Symbols:  $\nabla$  And  $\nabla$  And The Difference In Elevation Between The Top Of Web Or Flange Points To Top Of Grade.
  3. Dimensional Symbols:  $\nabla$  And  $\nabla$  And The Difference In Elevation Between The Top Of Web Or Flange Points To Top Of Grade.
  4. All Spacing Is Given To Top Of Stringer.
  5. All Intermediate Spacing And Intermediate Cross Points To Be Set To 5' On Planes.
  6. All Spacing To Be A.S.P.M. 136 (Unless Other).
  7. All Piers Shall Be Made With 1" U.S. Bolt (A.S.P.M. Section 100).
  8. All Cast Frame Layout Set Out, U.S.

18730 Sht 1 of 22

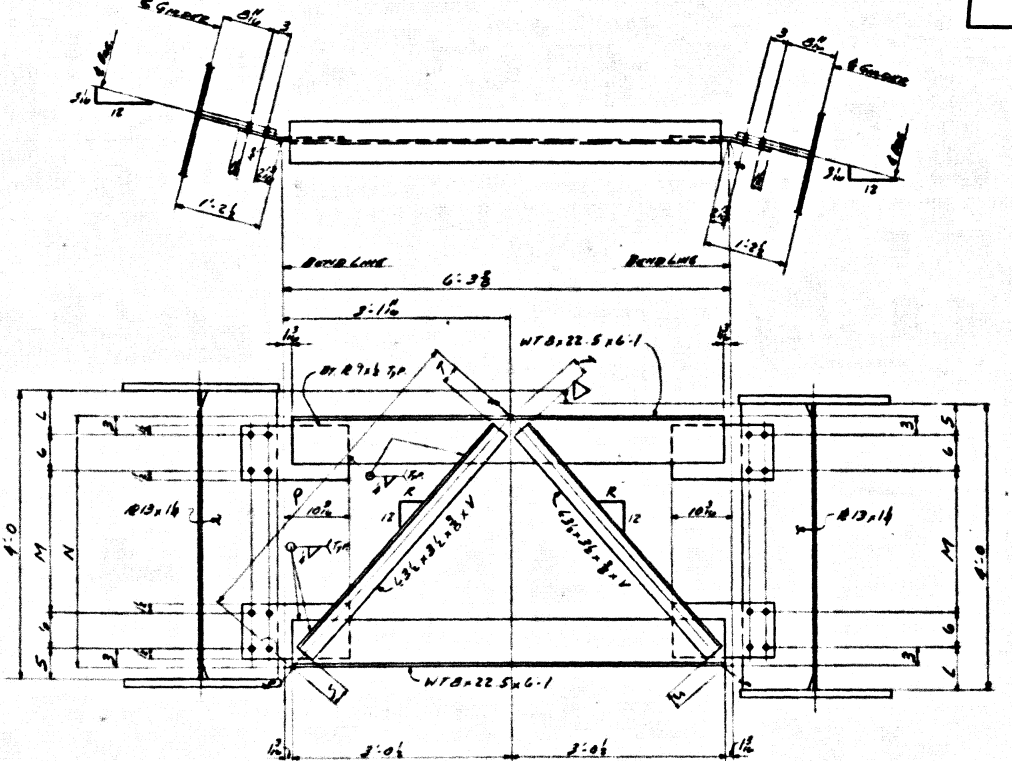
NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
DRAWING TITLE		
PROJECT NO. 18730 SHT 1 OF 22		
COUNTY OF YORK, PENNSYLVANIA		
APPROVED BY ARCHITECT		
DATE OF APPROVAL		
DRAWING NO. 18730		
CONTRACT NO. A-77065		
STATE COM. OR REG. NO. 2011-001		
DATE OF ISSUE 7/11/77		
DRAWN BY J.P. CHECKED BY R.K. DATE 7/11/77		
CONTRACT NO. A-77065 DRAWING NO. 18730		

LETTING DATE: APRIL 21, 1977  
 DRAWING No. 18730

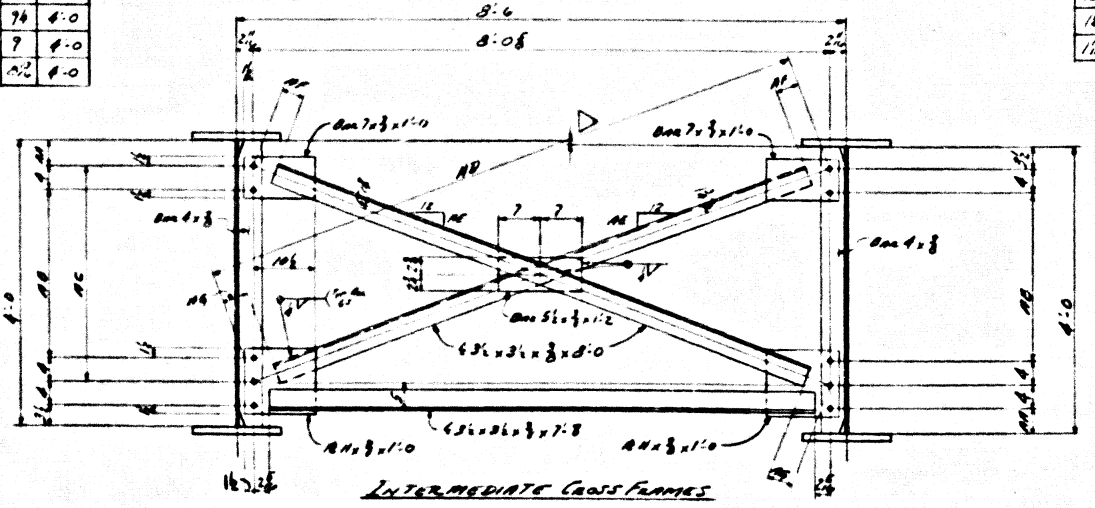
**BRIDGE**



D	A	B	C	D	E	F	G	H	J	K
16	5/16	1 1/16	5/16	3'-7 1/2	5'-1 1/2	12	11 1/2	3 1/2	14	4'-1
16	5/16	1 1/16	5/16	3'-7 1/2	5'-1 1/2	12	12	3 1/2	14	4'-1
16	5/16	1 1/16	5/16	3'-7 1/2	5'-1 1/2	12	12	3 1/2	14	4'-1
16	5/16	1 1/16	5/16	3'-7 1/2	5'-1 1/2	12	12	3 1/2	14	4'-1
16	5/16	1 1/16	5/16	3'-7 1/2	5'-1 1/2	12	12	3 1/2	14	4'-1



D	L	M	N	P	R	S	T	V
16	5/16	2 1/16	3'-7 1/2	4'-7 1/2	10	3 1/2	3	4'-2 1/2
16	5/16	2 1/16	3'-7 1/2	4'-7 1/2	10	3 1/2	3	4'-2 1/2
16	5/16	2 1/16	3'-7 1/2	4'-7 1/2	10	3 1/2	3	4'-2 1/2
16	5/16	2 1/16	3'-7 1/2	4'-7 1/2	10	3 1/2	3	4'-2 1/2
16	5/16	2 1/16	3'-7 1/2	4'-7 1/2	10	3 1/2	3	4'-2 1/2



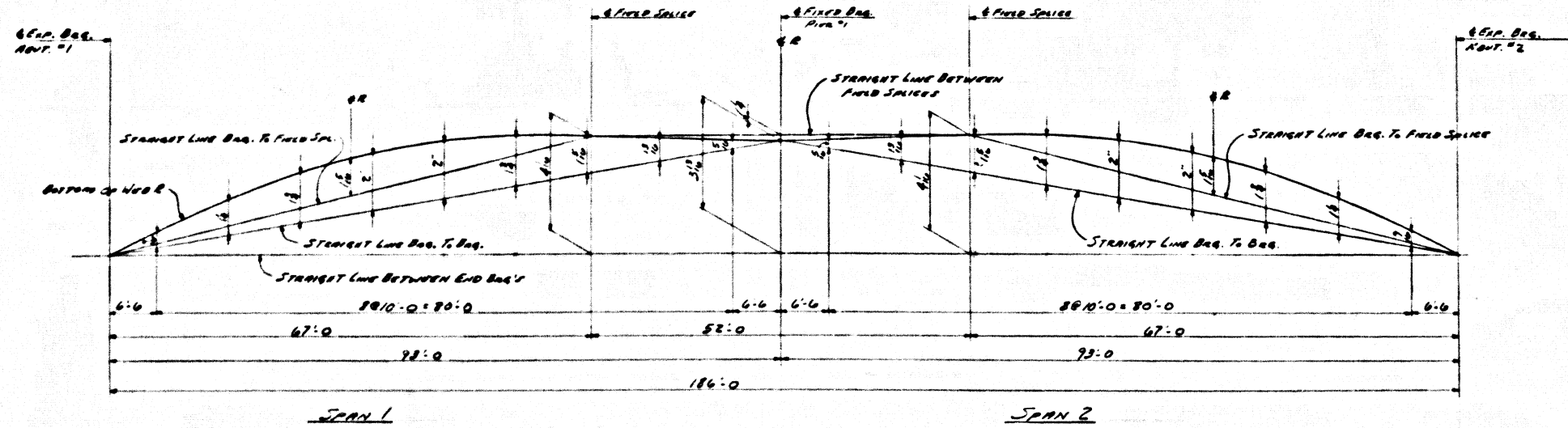
D	AA	AB	AC	AD	AE	AF	AG
0	3/4	2'-5	3'-1	0'-7 1/2	18	3 1/2	4
18	5/8	2'-3 1/2	2'-1 1/2	0'-0 1/2	18	3 1/2	4

2

NO.	REVISION	DATE
<b>HIGH STEEL STRUCTURES, INC.</b> 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
<i>Center Frame Layout</i> BY 128 - 1/24 - 34 - 4479 & 77 60 COUNTY OF TRUMBULL, PARSONS TRUSS, STATE HIGH 84 COMMISSIONER OF HIGHWAYS BRIDGE & HIGHWAYS TRANSPORT DEPARTMENT		
STATE COM. OR REP. NO.	SP. 111 404	CONTRACTOR
MADE BY	J.T.O.	CHECKED BY
DATE	7/12/77	DATE
CONTRACT NO.	K-77055	DRAWING NO.
		H-32

LETTING DATE: April 21, 1977  
 DRAWING No. 19730

BRIDGE



Scale: 1/4" = 10'-0" HORIZ., 1/8" = 1'-0" VERT.

CAMBER DIAGRAM

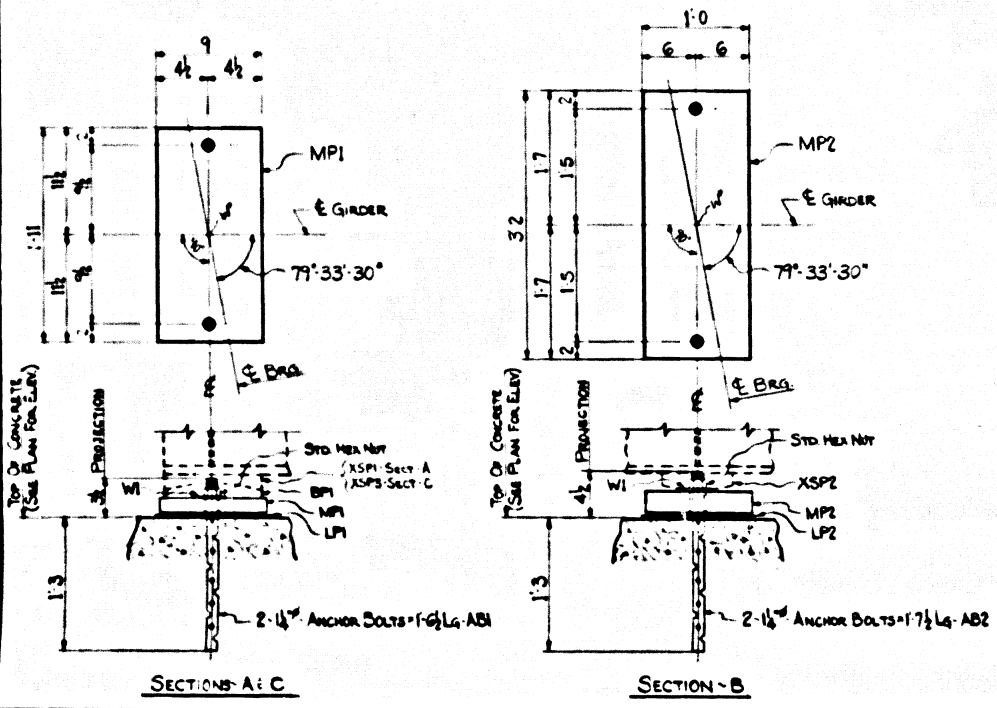
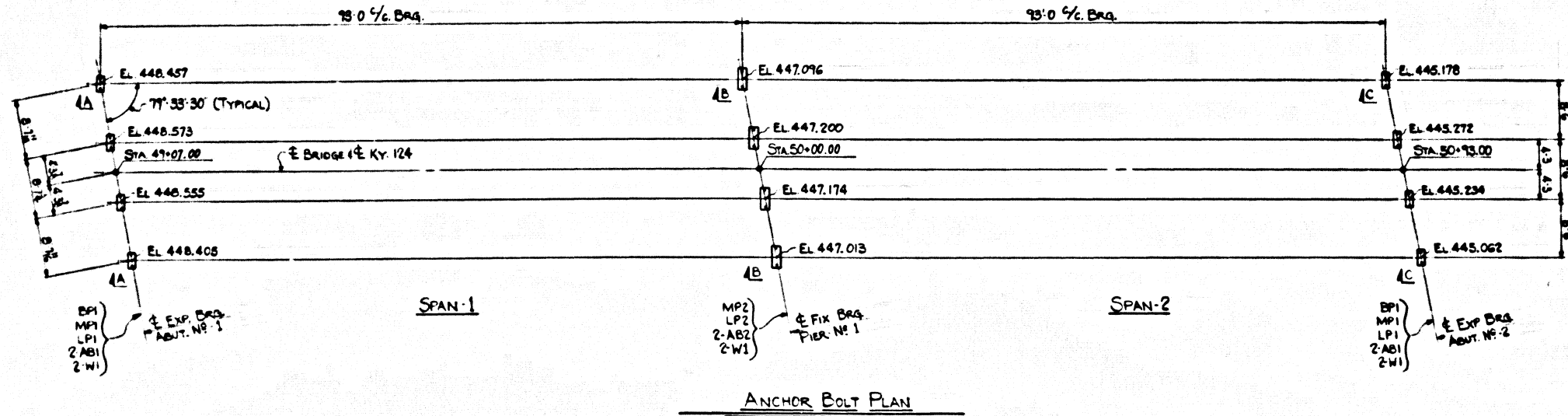
3

NO.	REVISION	DATE
<b>HIGH STEEL STRUCTURES, INC.</b> 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
<i>Camber Diagram</i> At 124 Feet & 24 Sta. 4470+51.46 COUNTY OF TALLEY, PENNSYLVANIA STATE LINE BRIDGE PENNSYLVANIA TALLEY COUNTY BUREAU OF HIGHWAYS PROJECT NO. 15-1000		
STATE COUNTY	CONTRACTOR	DATE
PA. TALLEY	McL. A. Han Inc.	7/11/77
DESIGNED BY	CHECKED BY	DATE
JLB	RK	7/11/77
CONTRACT NO.	BRIDGE NO.	
R-77055	CD1	

LETTING DATE: April 26, 1977  
 DRAWING NO. 18730

BRIDGE





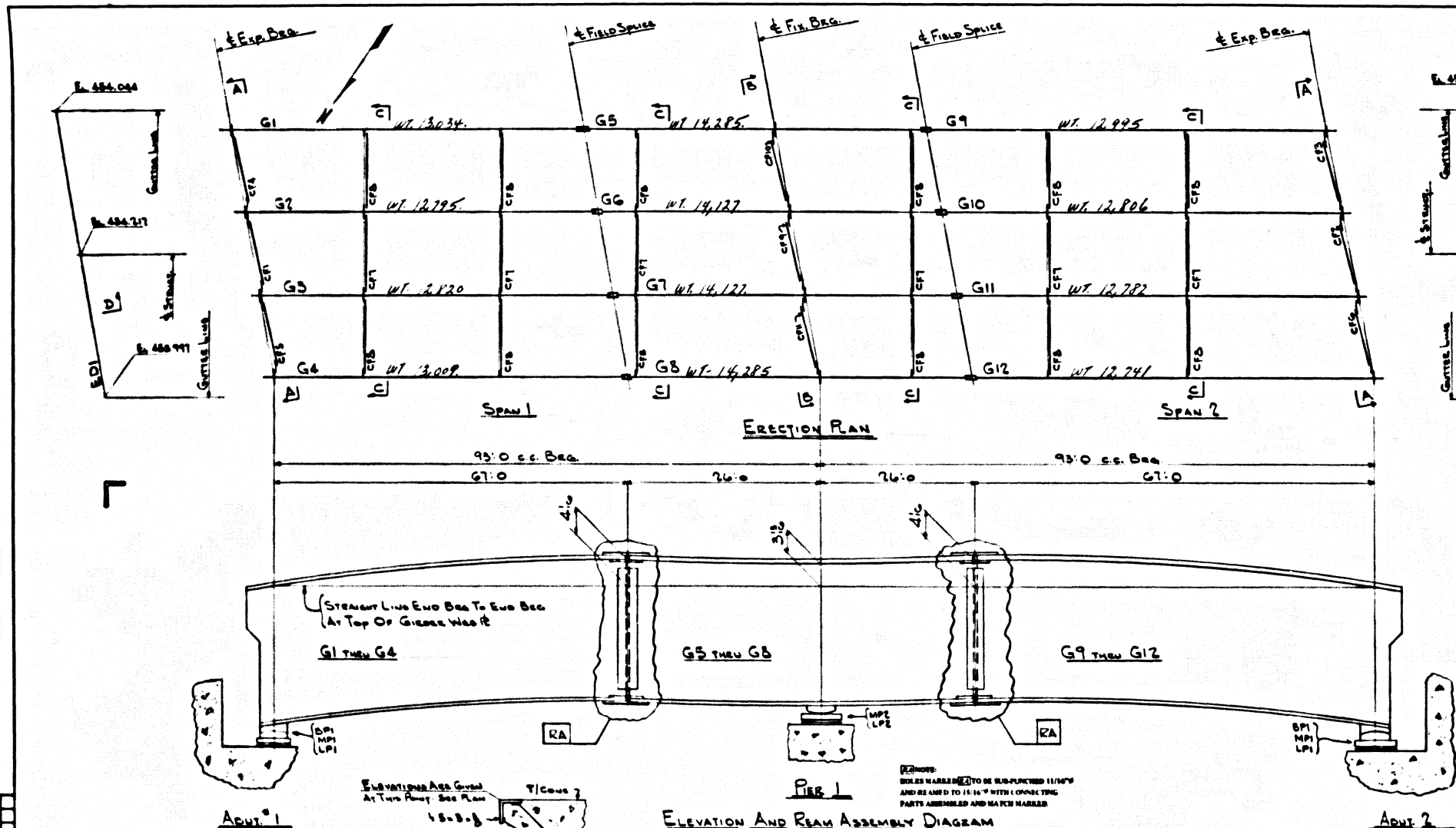
- NOTES:**
- 1 ANCHOR BOLTS FURNISHED BY HIGH STEEL STRUCTURES INC. AND SET BY OTHERS.
  - 2 ANCHOR BOLT SETTING MUST BE EXACT IN EVERY DETAIL IN ACCORDANCE WITH THIS DRAWING.
  - 3 ALL DIMENSIONS ARE GIVEN HORIZONTALLY.
  - 4 ELEVATIONS ARE GIVEN TO TOP OF CONCRETE PAD.

LETTING DATE: APRIL 21, 1977  
DRAWING NO.: 18730 4

NO.	REVISION	DATE
<b>HIGH STEEL STRUCTURES, INC.</b> 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
ANCHOR BOLT PLAN KY 199 COR. 24 STA 49+63.46 COUNTY OF TRING, FAYON TOWN OF LIME ROAD COMMONWEALTH OF KENTUCKY BUREAU OF HIGHWAYS FRANKFORT, KENTUCKY		
STATE COPY OR REF. NO.	SP111-404	CONTRACTOR: H. A. NAW, INC.
DATE BY D.G.B.	6-9-77	ISSUED BY: J.T.O. DATE: 6-23-77
CONTROL NO.	K-77055	REVISION NO.: E1

**BRIDGE**

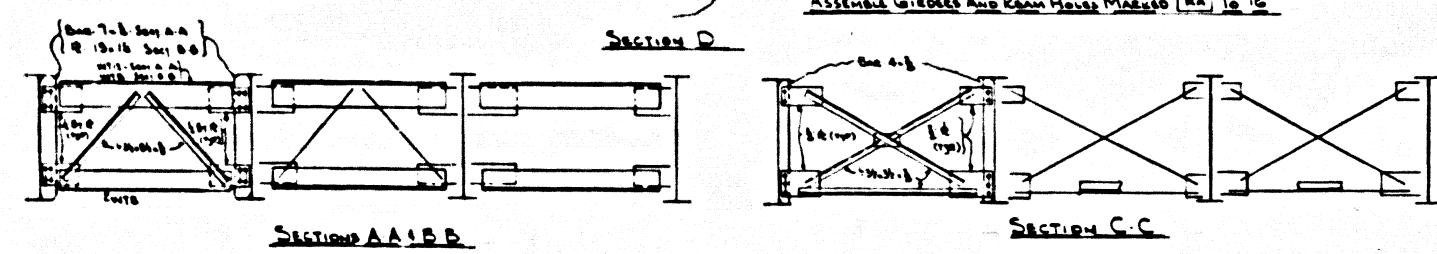




**SUMMARY OF ASTM A325 BOLTS (FRCTION TYPE)**

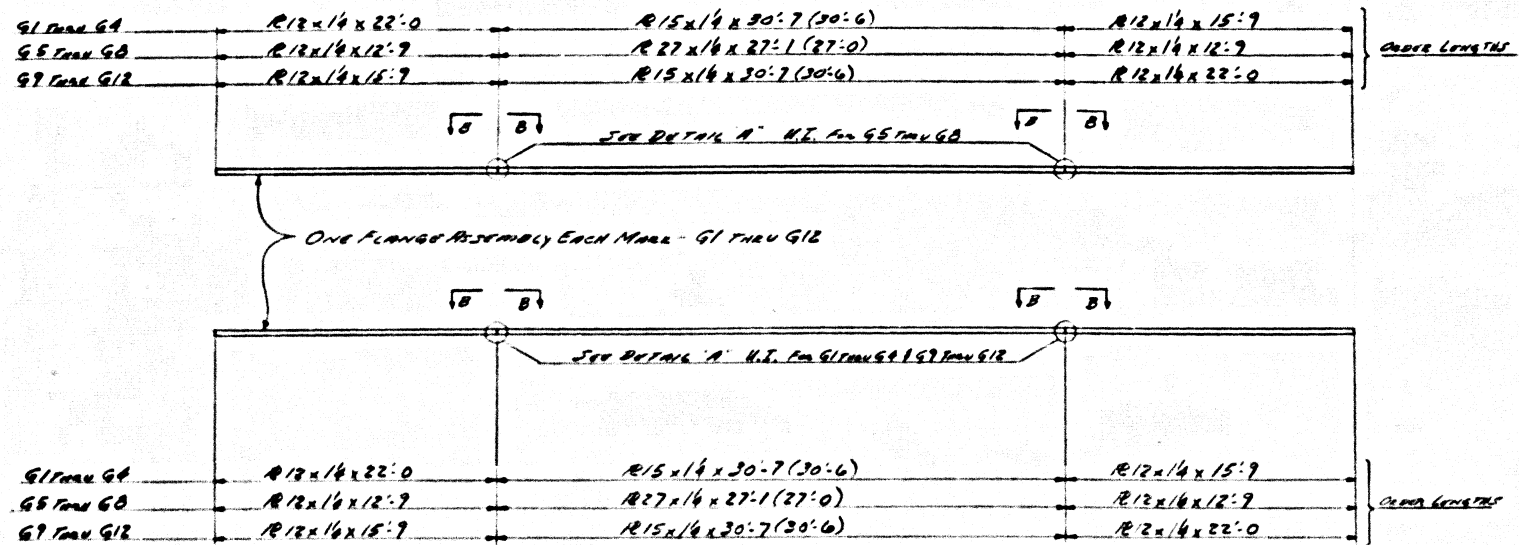
185	3/4" H.S. Bolts x 0'4" Lg.	Hex. Hex. Ho. & Nut
395	1" H.S. Bolts x 0'2 1/2" Lg.	Hex. Hex. Ho. & Nut
100	1" H.S. Bolts x 0'2 1/2" Lg.	Hex. Hex. Ho. & Nut
50	1" H.S. Bolts x 0'3" Lg.	Hex. Hex. Ho. & Nut
136	1" H.S. Bolts x 0'3 1/2" Lg.	Hex. Hex. Ho. & Nut
395	3/4" H.S. Bolts x 0'3 1/2" Lg.	Hex. Hex. Ho. & Nut
1260	Flat Head Washers For 3/4" H.S. Bolts	

- NOTES**
1. All Material ASTM-A36-75 (Unless Noted)
  2. All Field Connections To Be Made With ASTM-A325 H.S. Bolts (Friction Type)
  3. All Dimensions Are Given Horizontal Unless Noted
  4. For General Notes See Draw N1

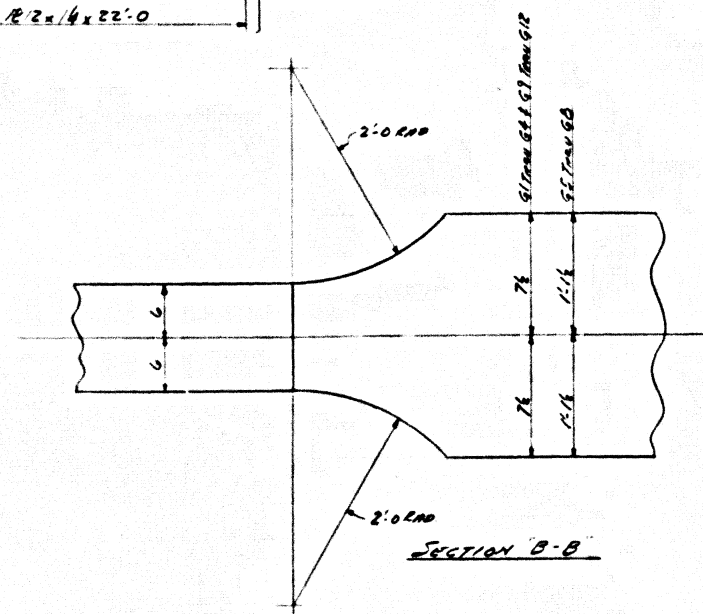
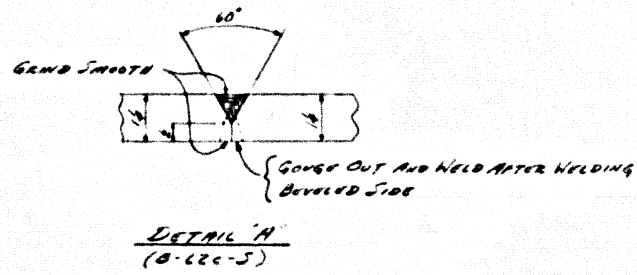


NO.	REVISION	DATE
<b>HIGH STEEL STRUCTURES, INC.</b> 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
ERECTOR PLAN		
KY 126 OVER I 24 STA 4499+89.46		
COMMITTEE OF TRAVEL - PROJECT TENN STATE HIGH ROAD		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
FRANKFORT, KENTUCKY		
STATE COUNTY OR REF. NO.	SP111-404	CONTRACTOR Hon. A. Nam Inc.
DESIGNED BY	RK	CHECKED BY RWL DATE 8-17-77
DRAWN BY	K-77055	REVISION NO. E2

**BRIDGE**



ONE FLANGE ASSEMBLY EACH MARK - G1 THRU G12



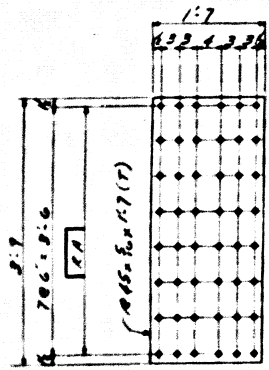
- NOTES:**
1. ALL WELDS MADE BY SUBMERGED ARC PROCESS.
  2. ALL STEEL TO BE A.S.T.M. A36-75.
  3. TESTING TO BE DONE BY LOW ENGINEERING TESTING.
  4. ALL STEEL TO MEET THE CHANDY V-NOTED TOUGHNESS TEST - SEE SPECS.
  5. ULTRASONIC INSPECTION OF FLANGE SPICES AS CALLED FOR BY KENTUCKY BUREAU OF HIGHWAYS SPECIAL PROVISION # (76). SPICES MARKED U.I. TEST 100%, ALL OTHERS TEST 25%.
  6. DIMENSIONS SHOWN THRU: (27'-0) ARE THE NETWORK DIMENSIONS THAT WILL APPEAR ON THE GIBBER DETAIL DRAWINGS.
  7. FOR GENERAL NOTES SEE DWG. N1.

**SHOP NOTE**  
 HOLES: None  
 BOLTS: None  
 PAINT: None

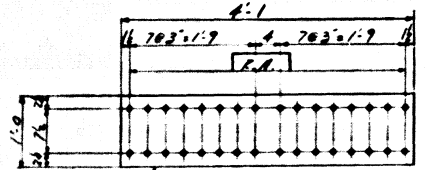
LETTING DATE: APRIL 21, 1977  
 DRAWING No. 18720

NO.	REVISION	DATE
<b>HIGH STEEL STRUCTURES, INC.</b> 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
SCALE: FULL SIZE DRAWING REVISED UNDER 28 - PA 44.17-27.40 COUNTY OF JEFFERSON, PROVISIONS FOR STATE USE ONLY KENTUCKY DEPARTMENT OF HIGHWAYS DIVISION OF HIGHWAYS TRANSPORTATION DISTRICT		
STATE CONTRACT OR REF. NO. 27111-408	CONTRACTOR: H&A - NEW INC.	
MADE BY: J.L.A.	CHECKED BY: R.K.	DATE: 7/26/77
DESIGNED BY: J.L.A.	CONTRACT NO. K-77055	DRAWING NO. FS1

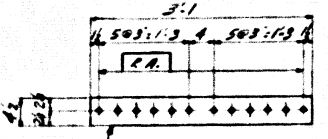
**BRIDGE**



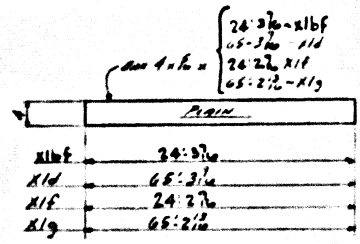
16 - Splice Rs - Ma. X1a



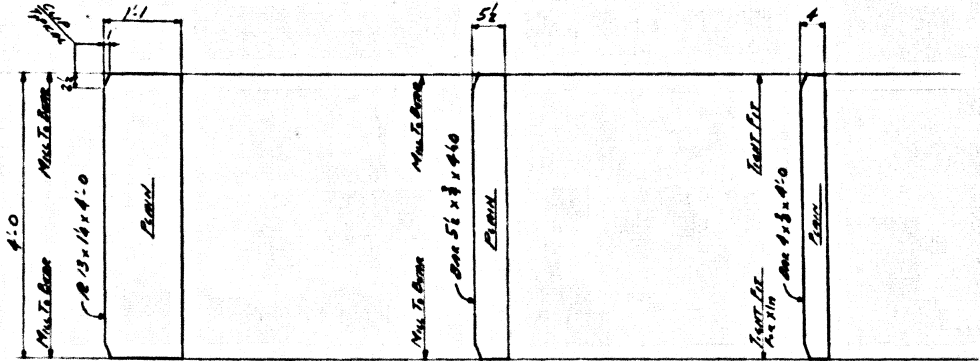
16 - Splice Rs - Ma. X1b



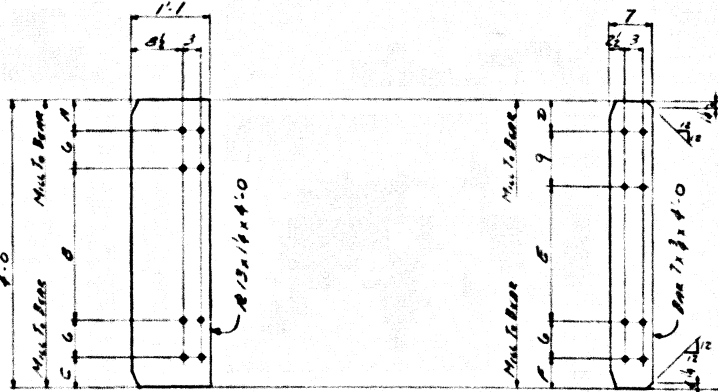
32 - Splice Rs - Ma. X1c



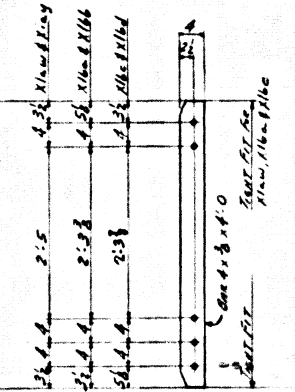
2 - Longitudinal Stiffs - Ma. X1d  
2 - " - Ma. X1f  
2 - " - Ma. X1g  
2 - Longitudinal Stiffs - Ma. X1bf



2 - Bag Stiffs - Ma. X1h  
4 - Bag Stiffs - Ma. X1k  
124 - Int. Stiffs - Ma. X1m  
30 - Int. Stiffs - Ma. X1n



One - Bag Stiff Each Ma. X1p & X1q  
One - Bag Stiff Each Ma. X1ab & X1ac



4 - Int. Conn. Rs - Ma. X1aw  
8 - " - Ma. X1ay  
4 - " - Ma. X1ba  
8 - " - Ma. X1bb  
4 - " - Ma. X1bc  
8 - " - Ma. X1bd

Mark	A	B	C
X1p	5/16	2-1/2	5
X1s	6/8	2-0/8	5
X1c	6/8	2-0/8	5
X1w	5	2-1/2	5 1/2
X1y	5	2-0/8	6 1/2
X1a	5	2-0/8	6 1/2

Mark	D	E	F
X1ab	5/16	1-1/2	5
X1ac	5/16	1-1/2	5
X1ad	6/8	1-7/8	5
X1af	6/8	1-7/8	5
X1ag	7/8	1-8/8	5
X1ah	7/8	1-8/8	5
X1ak	5/8	1-10/8	5 1/2
X1am	5/8	1-10/8	5 1/2
X1an	5/8	1-7/8	6 1/2
X1ap	5/8	1-7/8	6 1/2
X1as	5/8	1-8/8	6 1/2
X1at	5/8	1-8/8	7 1/2

NOTE: HOLES MARKED TO BE REINFORCED 1/4" DIA AND REAMED TO 1 1/4" WITH CONCRETE PARTS ASSEMBLED AND MATCH MARKED.

SHOP NOTE  
HOLES: 1/2" (Unless Noted)  
BOLTS: A490  
PAINT: MWP

ALL MEASUREMENTS TO BE AS SHOWN A30-75  
FOR SPECIFICATIONS SEE DRAWING N1  
LETTING DATE: APRIL 21 1977  
DRAWING NO. 18730

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
BY STATE CONT. OR REP. NO. 2011-608 CONTRACT NO. A-4401-608		
MADE BY: J.T.A. CHECKED BY: R.V. DATE: 7/22/77		
CONTRACT NO. K-77055 DRAWING NO. XI		

BRIDGE



GENERAL NOTES

MATERIALS

1. ALL STEEL TO BE A.S.T.M. A96-75 (UNLESS NOTED).
2. STEEL NOTED A108 TO BE A.S.T.M. A108-73 GRADE 1016 & 1030 MIN.
3. LEAD PLATES TO BE A.S.T.M. B29-55 (1971).
4. ALL WEB, FLANGE AND SPLICE PLATE MATERIAL TO BE A.S.T.M. A96-75 WITH CHARTER V-NOTCH TEST AS PER SPEC'S.

PAINTING

1. ALL STEEL TO BE BLAST CLEANED AS PER SSPC-SP10 FOR NEAR WHITE BLAST CLEANING PRIOR TO PAINTING.
2. ALL STEEL TO BE PAINTED WITH ONE SHOP COAT OF TTP-615J TYPE II-15 MILS. (DRY) MINIMUM (UNLESS NOTED).
3. NO PAINT WITHIN 3" OF OPEN HOLES (UNLESS NOTED).
4. NO PAINT STEEL IN CONTACT WITH OR EMBEDDED IN CONCRETE.
5. SURFACES INACCESSIBLE AFTER ASSEMBLY OR ERECTION SHALL BE PAINTED WITH THREE COATS OF THE SHOP PRIMER PAINT.

REFERENCE NOTES

1. FOR JOB STANDARD PIECES SEE DRAWING PREFIXED X.
2. FOR FLANGE SPLICE DETAILS SEE DRAWING PREFIXED F.

WELDING

1. ALL WELDS TO BE MADE BY SUBMERGED ARC PROCESS.
2. FLANGE AND WEB PLATE SPLICES ARE TO BE INSPECTED BY LAW ENGINEERING & TESTING CO. (SEE NOTE 5)
3. ALL FLANGE AND WEB PLATE SPLICES ARE TO BE MADE BEFORE FINAL FITTING AND WELDING INTO GIRDER.
4. WELDING OF WEBS TO FLANGES SHALL PROCEED FROM END OF SECTION TOWARD OPPOSITE END.
5. TESTING TO BE DONE BY ULTRASONIC METHOD AS FOLLOWS:
  - a. ALL TENSION FLANGE SPLICES.
  - b. 25% OF COMPRESSION FLANGE SPLICES.

REAMING

1. HOLES MARKED **RA** ON DETAIL DRAWINGS TO BE SUB-PUNCHED AND REAMED, AS NOTED BELOW, WITH CONNECTING PARTS ASSEMBLED AND MATCH MARKED. FOR REAM ASSEMBLY DIAGRAM SEE ERECTION DRAWINGS.

**RA** SUB-PUNCH  $\frac{1}{16}$ " AND REAM TO  $\frac{15}{16}$ "

GENERAL

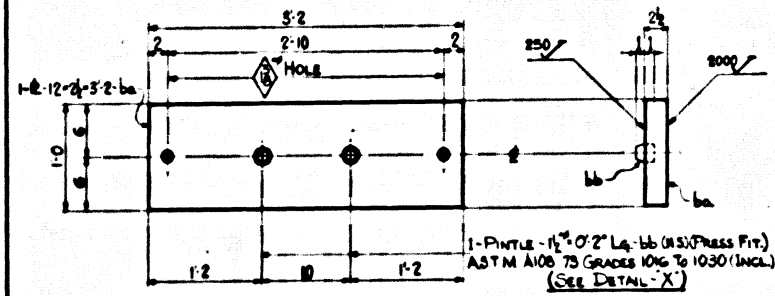
1. ALL RE-ENTRANT CUTS TO HAVE A  $\frac{3}{4}$ " RADIUS (MIN).
2. SHOP INSPECTION BY LAW ENGINEERING & TESTING CO.
3. SPEC'S: KY. STD. FOR RD. & BRIDGE CONST., CURRENT EDITION (1976) AND AWS DI. 1-72, 73 & 74 REV. INCLUDING AASHTO MODIFICATIONS, SPECIAL PROVISION 4 (16) CURRENT EDITION.

8

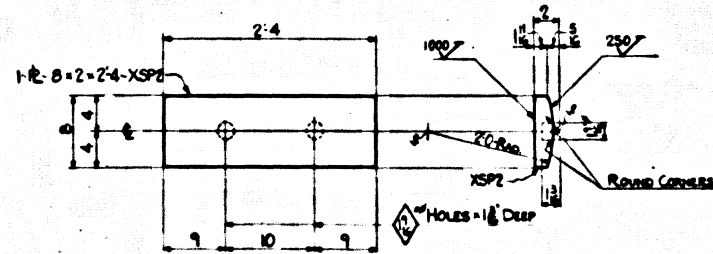
NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1811 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GENERAL NOTES		
K-77055		
COUNTY OF TRIGG, KY. BRIDGE		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
FRANKFORT, KENTUCKY		
STATE CONT.	SP-11-604	REV. A-D
DATE BY	J.A.	CHECKED BY C.N.
PROJECT	K-77055	REVISED BY NI
CONTRACT NO.		

LETTING DATE: April 21, 1977  
DRAWING No. 18730

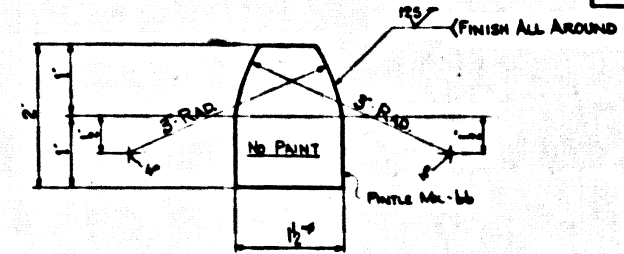
BRIDGE



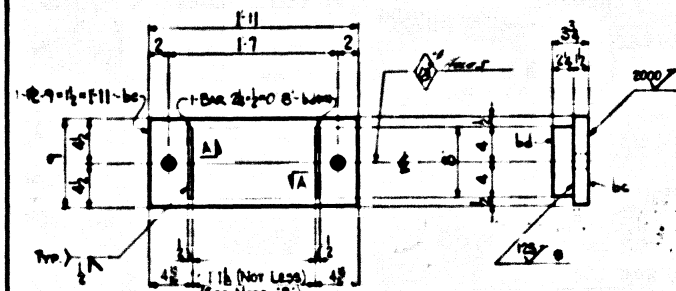
4 - MASONRY PLATES Mk - MP2  
 WT. EA. = 323.9



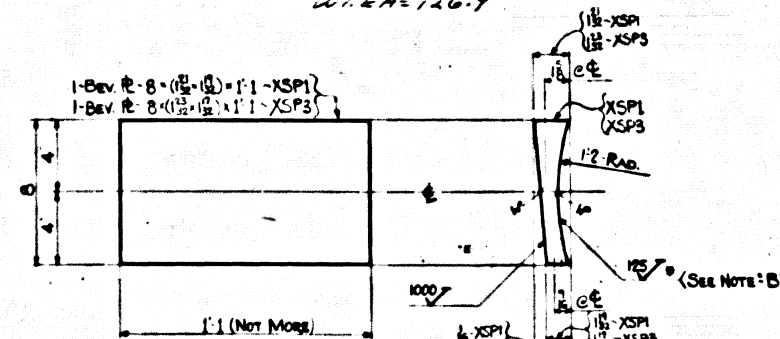
4 - SOLE PLATES Mk - XSP2  
 WT. EA. = 126.9



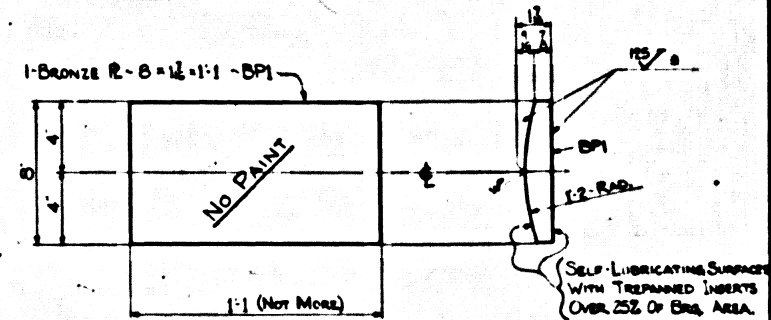
DETAIL - X



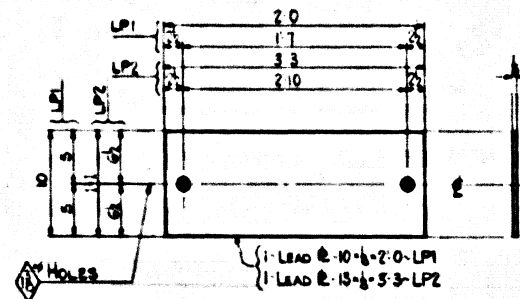
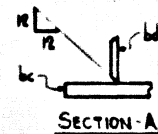
8 - MASONRY PLATES Mk - MPI  
 WT. EA. = 93.2



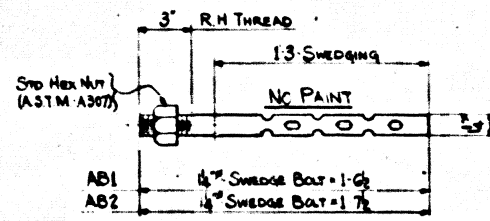
4 - SOLE PLATES Mk - XSP1 47.9 EA  
 4 - SOLE PLATES Mk - XSP3 47.9 EA



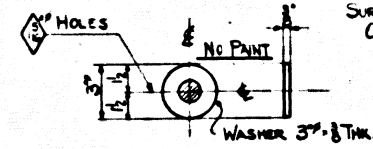
8 - BRONZE PLATES - Mk - BPI  
 (ASTM B22 AUGY 911)  
 WT. EA. = 44.1



8 - LEAD PLATES Mk - LP1 12.3  
 4 - LEAD PLATES Mk - LP2 25.9  
 ASTM B. 75 (H1)



16 - ANCHOR BOLTS Mk - AB1 6.9  
 8 - ANCHOR BOLTS Mk - AB2 7.3  
 WT. EA.



24 - WASHERS Mk - W1  
 WT. EA. = 609K

NOTES:

SOLE PLATES MARKED XSP1 & XSP3 ARE TO BE PAINTED (UN) AFTER BEING WELDED TO GIRDERS IN SHOP.

SHOP NOTES:

FINISHES MARK THUS: B ARE TO BE FINISHED IN THE DIRECTION OF MOVEMENT.

NOTE 'B'

SURFACES INDICATED ARE NOT TO BE PAINTED. APPLY ONE COAT OF HOT WHITE LEAD / TALLOW.

ALL MATERIAL - ASTM - A36 - 75 (UN)

SHOP NOTE

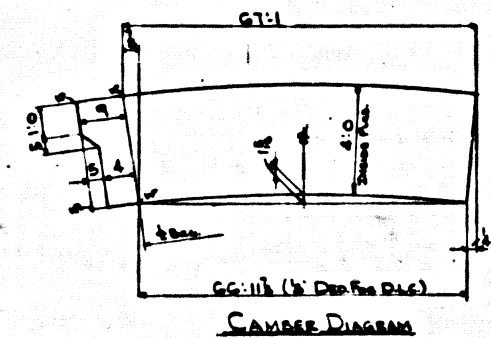
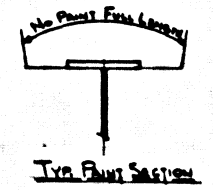
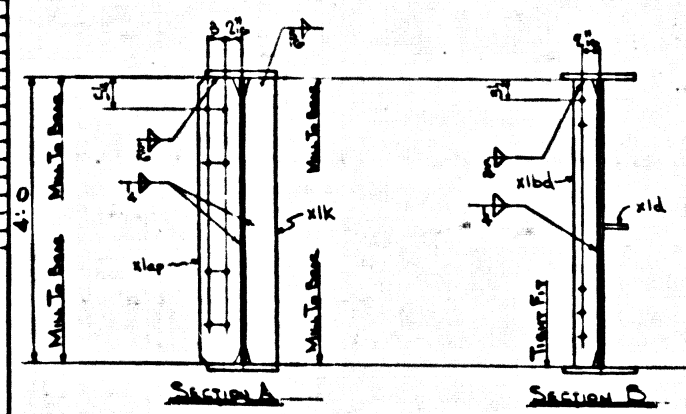
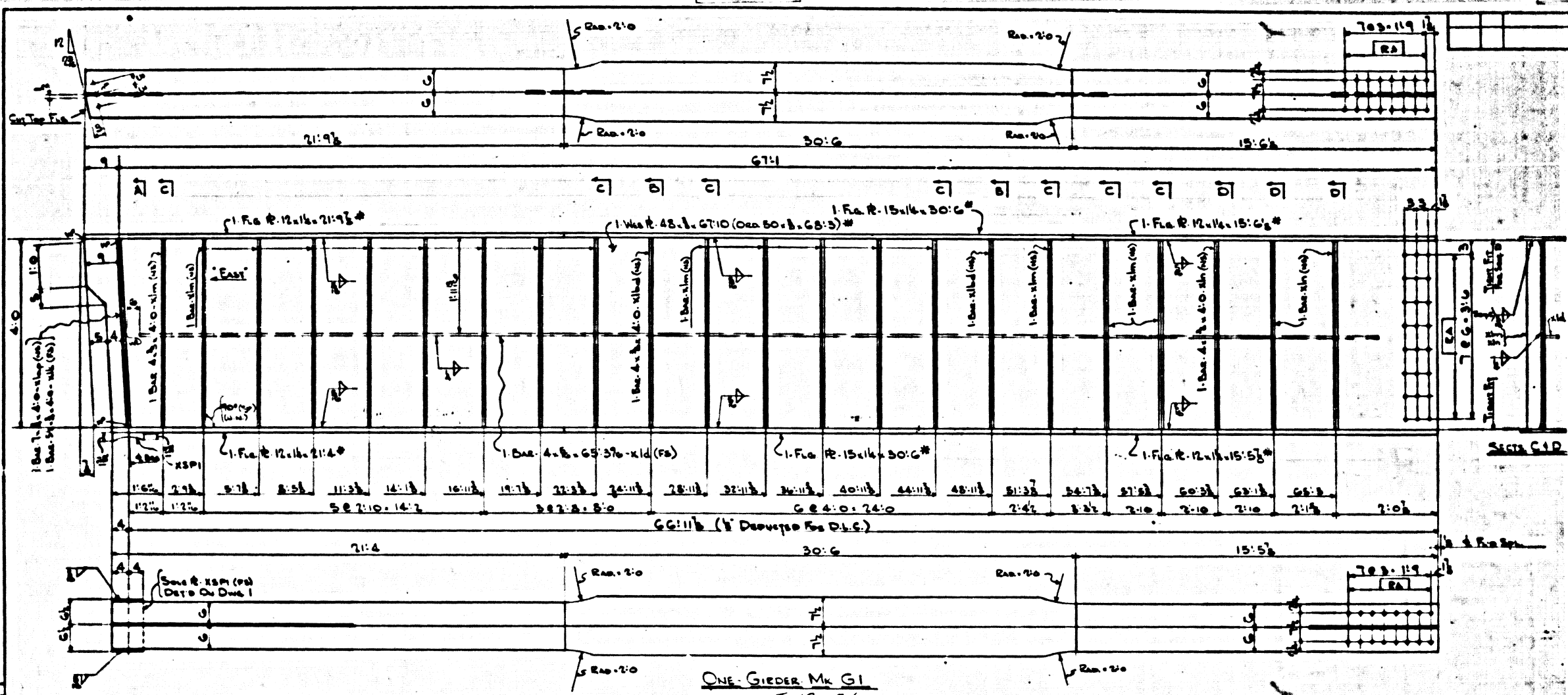
HOLES: AS NOTED  
 BOLTS: NONE  
 PAINT: ONE SHOP COAT OF TYP. G-52 TYPE II - 1.5 MILS (MINIMUM) DRY THICKNESS (UN)  
 CLEANING: SSPC-SP10 NEAR WHITE BLAST

LETTING DATE: APRIL 21, 1977  
 DRAWING NO: 18730

FOR GENERAL NOTES SEE Dwg. NO. 9

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
BEARING DETAILS KY 124 OVER 24 TO 2449 - 2442 COUNTY OF TRIGER, FARRAGAN - TENN. ST. LINE ROAD COMMONWEALTH OF KENTUCKY BUREAU OF HIGHWAYS FRANKFORT, KENTUCKY		
STATE COPY ON DEP. OF SP11 - 404 CONTRACTOR HO. - A - NEW INC.		
DESIGNED BY DGB 6-1-77 CHECKED BY JLD DRAWN BY K-77055 DATE 1 OF 14		

BRIDGE



NOTE: ALL PARTS TO BE REINFORCED STEEL AND BLENDED TO 14" WITH CONCRETE PARTS ANNEALED AND WATER MARKED.

MATERIALS: ASTM-A36-72  
FOR GRINDING NOTES SEE DWG. N1.

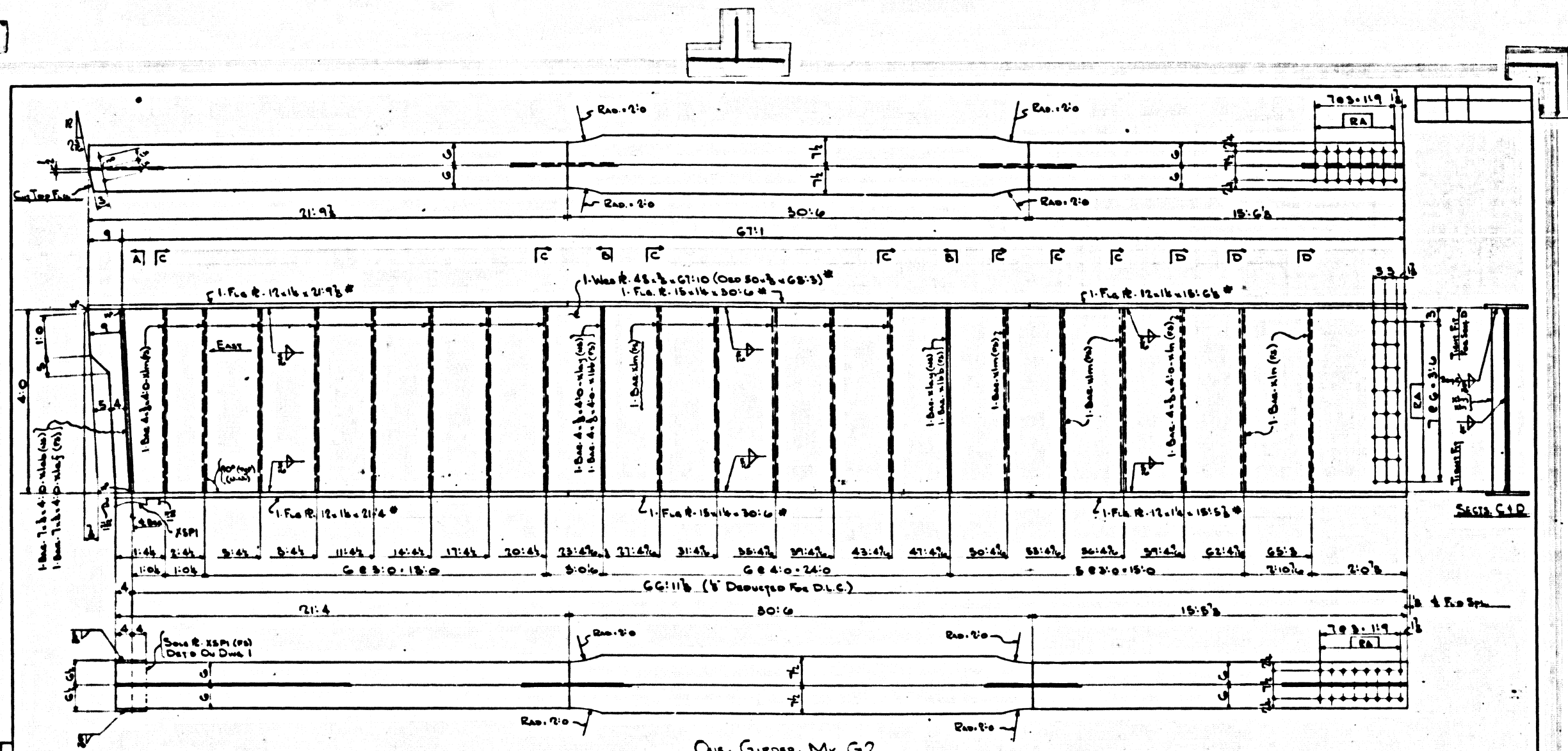
**SHOP NOTE**  
 HOLES: 1/8" (Unless Noted)  
 BOLTS: None  
 PAINT: One Coat of TPA 6100 Type X-1.5 Min. (Over Minimum 1/4")  
 CLEANING: SPC and Near White Blast No Paint Mould or Oil Holes

LETTING DATE: APRIL 11, 1977  
 DRAWING NO. 18189

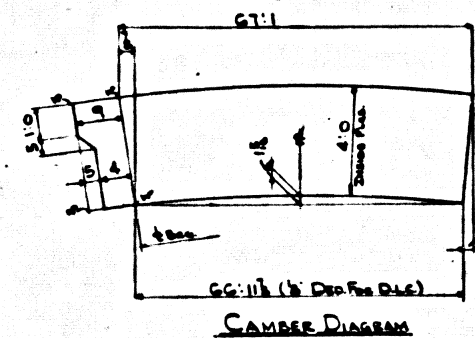
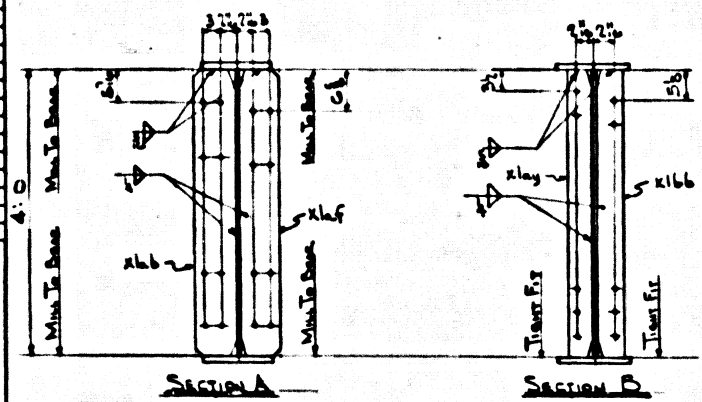
10	
<b>HIGH STEEL STRUCTURES, INC.</b>	
1911 OLD PHILADELPHIA PIKE LANCASTER, PA.	
GIRDER DETAIL	
KY. 124 over 2.26 STA. 4494+01.26	
COUNTY OF TRING PROJECT: KY. STATE HIGHWAY	
COMMONWEALTH OF KENTUCKY	
BUREAU OF HIGHWAYS	
FRANKFORT, KENTUCKY	
STATE CONTRACT NO. 3P11-404	DESIGNED BY: H. A. NAY, INC.
DRAWN BY: RWL	CHECKED BY: RWL
DATE: 2-15-77	DATE: 2-15-77
PROJECT: K-11055	SHEET: 2 OF 16

BRIDGE





ONE GIRDER MK G2  
WT. 12,795



NOTE: ALL WELDS TO BE EMPLOYED 1/4" MIN. AND BLANKED TO 1/4" MIN. WITH CORNER TING PILES ASSEMBLED AND MATCH MARKED.

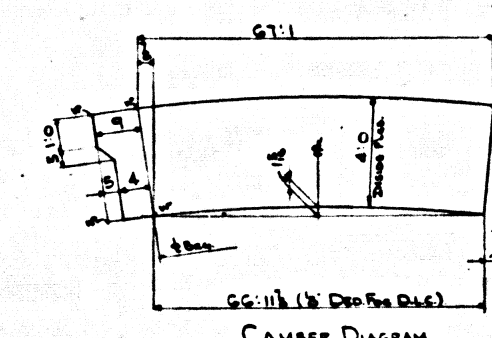
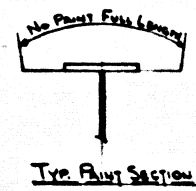
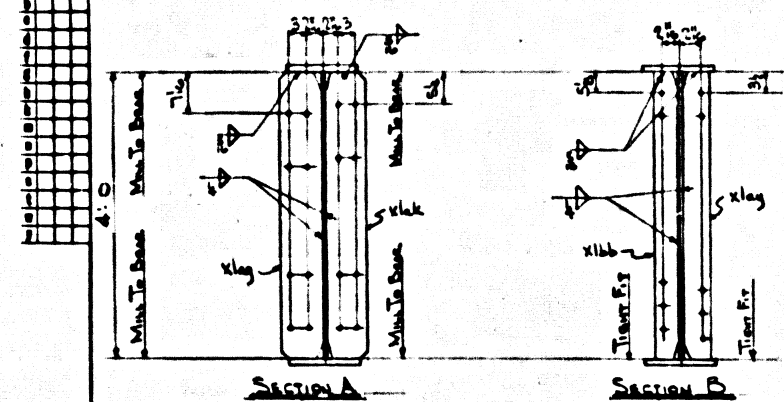
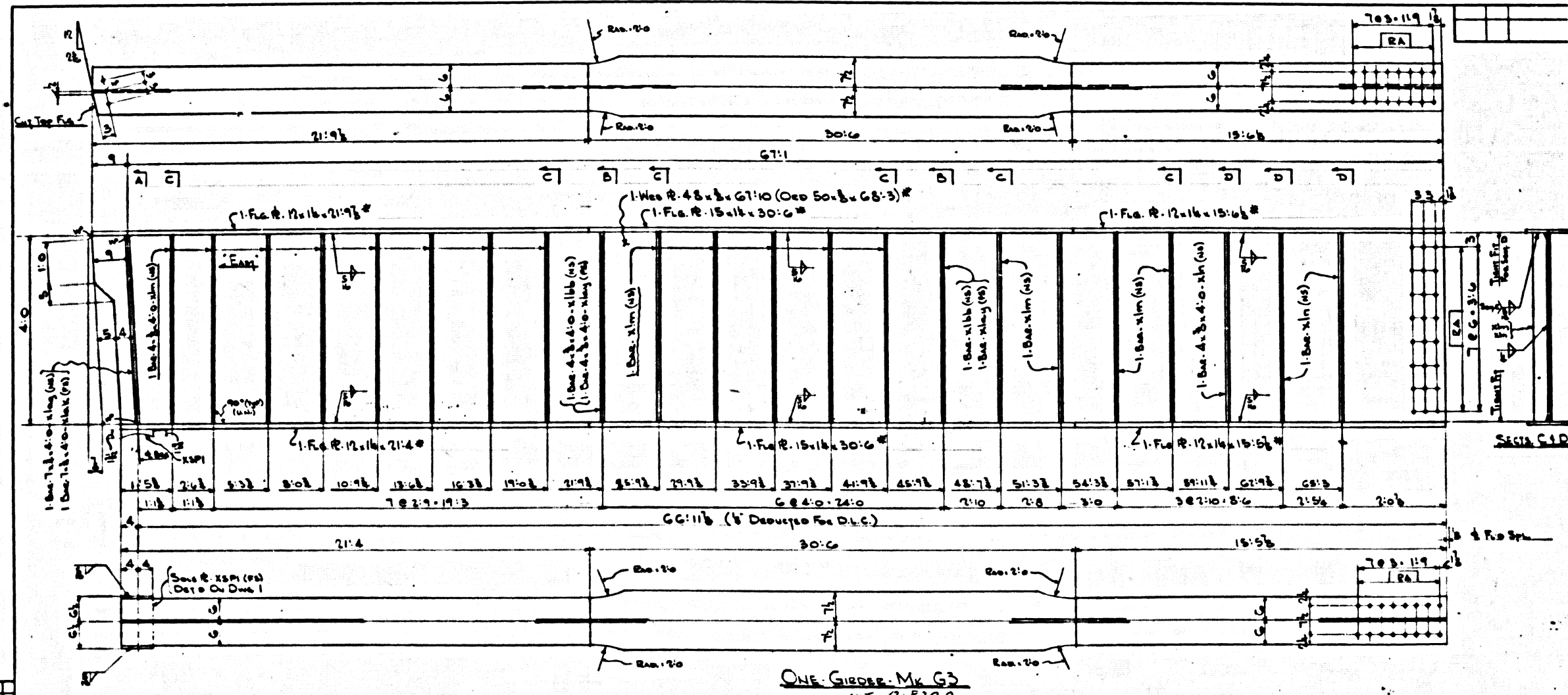
MATERIAL SPECIFICATION: In Home Chemistry Test  
MAX. A.S.T.M. A36-78  
FOR GENERAL NOTES SEE DRAW. N1

BHOP NOTE  
HOLES: 1/8" (Unless Noted)  
BOLTS: None  
PAINT: One Shop Coat Of T.P. Gild  
Type X-1.5 Min. (Dry) Minimum (Min)  
CLEANING: S.P.C. AND WASH WITH BRUSH  
NO PAINT WITHIN 3" OF OPEN HOLES

LETTING DATE: APRIL 11, 1977  
DRAWING NO. 18130

NO.	REVISED	DATE
HIGH STEEL STRUCTURES, INC. 1811 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDER DETAIL		
KY. 124 OVER 2.24 STA 4449.81 LAG		
COUNTY OF TRIGG PROUCA. KY. STATE HIGHWAY		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
FRANKFORT, KENTUCKY		
STATE COURT	NO. 3P111-404	CONTRACTOR: H.A. NAYLOR
BY: RK	CHECKED BY: R.W.C.	DATE: 8-15-77
PROJECT: K-11056	ISSUED BY: 307 14	

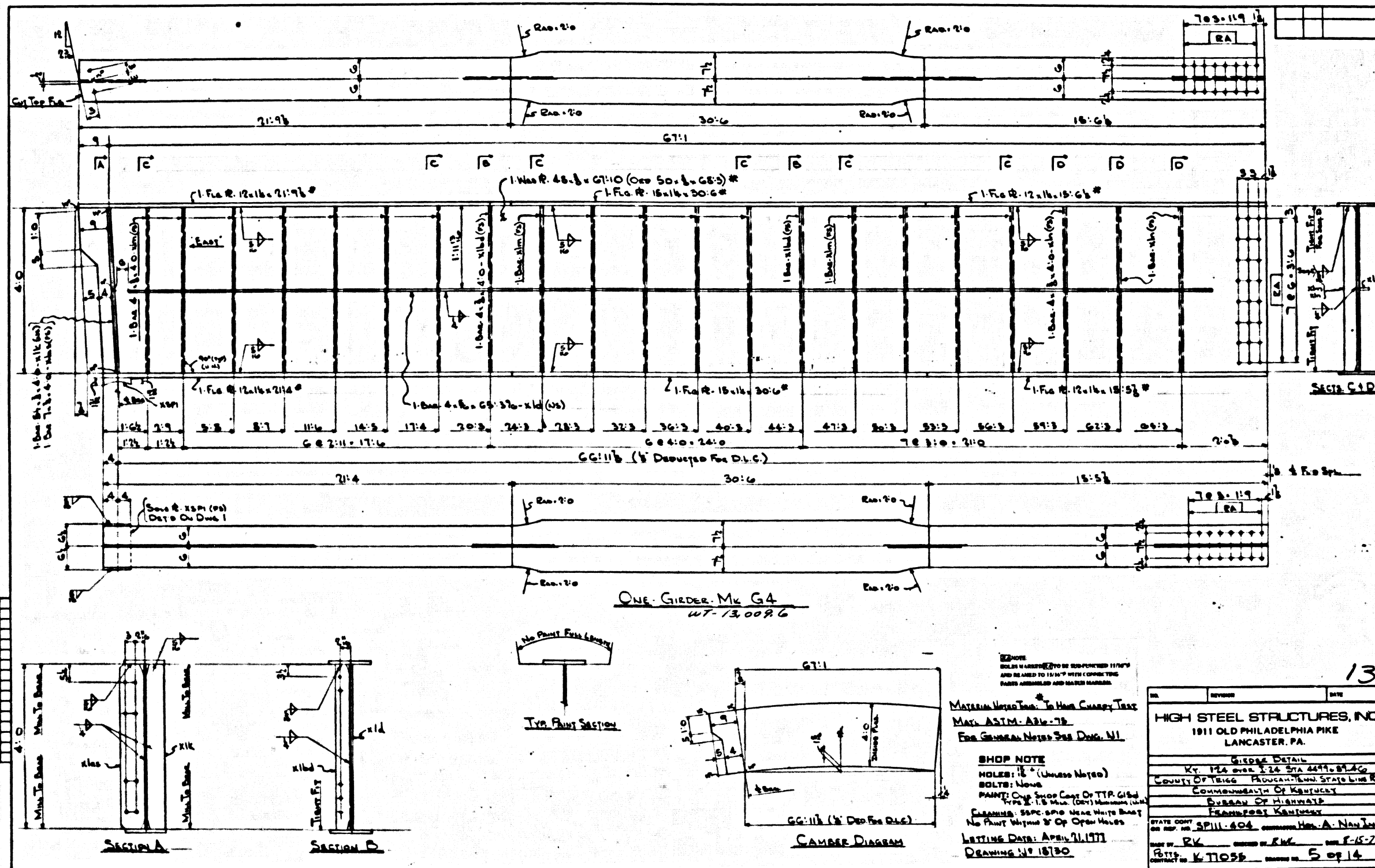
BRIDGE



SHOP NOTE  
HOLES: 1/2" (Unless Noted)  
BOLTS: None  
PAINT: One Side Coat Of T.P. G3  
CLEANING: SSPC-SP10 Near White Blast  
No Paint Within 8" Of Open Holes  
LETTING DATE: APRIL 11, 1977  
DRAWING NO: 18730

HIGH STEEL STRUCTURES, INC.	
1811 OLD PHILADELPHIA PIKE LANCASTER, PA.	
GIRDER DETAIL	
KY. 124 OVER I-24 STA 4499+81.46	
COUNTY OF TRIGG PROUCAH-KENN. STATE LINE BR.	
COMMONWEALTH OF KENTUCKY	
BUREAU OF HIGHWAYS	
FRANKFORT, KENTUCKY	
STATE CONT. OR REF. NO.	SP111-404
DATE BY	RK
DATE BY	RWL
DATE BY	8-15-77
CONTRACT NO.	K T1058
DRAWING NO.	4 of 14

BRIDGE



SHOW  
HOLD IN PLACE TO BE REINFORCED 11/17/77  
AND REAMED TO 1 1/4" WITH CORRECTING  
PINS ASSEMBLED AND MARKED HARD.

MATERIAL NOTED TO: TO HAVE CHEMIST TEST  
MAY: ASTM-A36-72  
FOR GENERAL NOTES SEE DWG. N1

SHOP NOTE  
HOLES: 1/8" (Unless Noted)  
BOLTS: None  
PAINT: One Shop Coat Of T.P. Gild  
Type 2, 1.5 Min. (Dry) Minimum (1/4")  
CRACKING: SSPC-SP10 WASH WHITE BRIST  
No PAINT Within 2" Of Open Holes

LETTING DATE: APRIL 21, 1977  
DRAWING NO: 18730

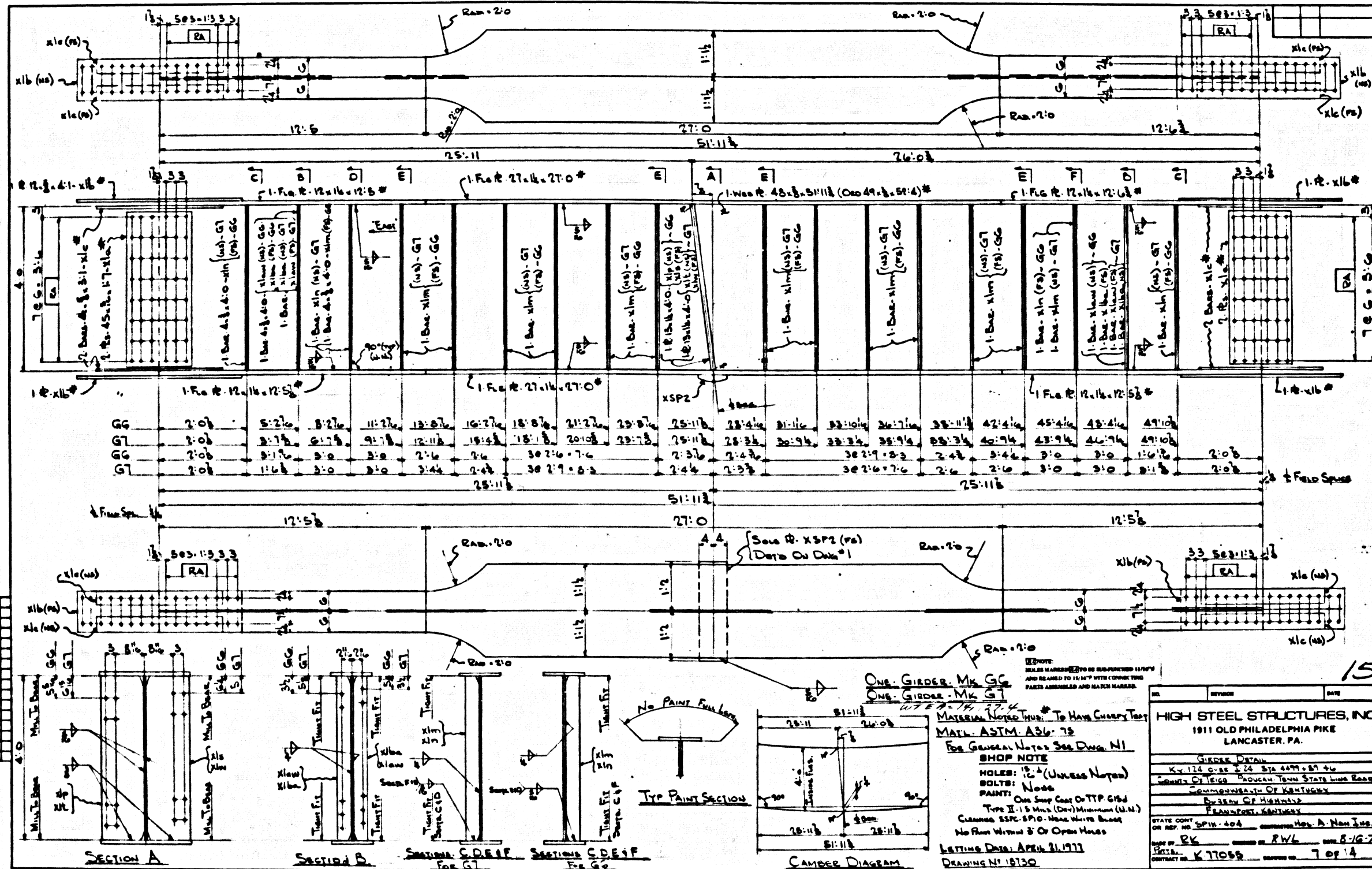
13

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDER DETAIL		
KY 124 over I-24 STA 449+87.40		
COUNTY OF TRIGG PRODUCTION STATE LINE R.O.		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
FRANKFORT, KENTUCKY		
STATE CONTRACT NO. SP111-404 CONTRACTOR: H.A. NATHAN		
DRAWN BY: RK CHECKED BY: R.W. DATE: 1-15-77		
DESIGNED BY: K.T.OSS CONTRACT NO. 5 of 14		

BRIDGE





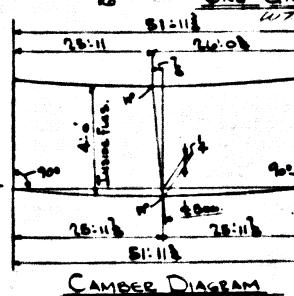


SECTION A

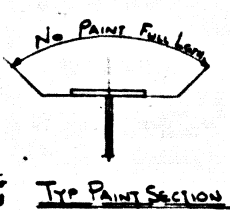
SECTION B

SECTIONS C, D, E, F For GT

SECTIONS C, D, E, F For GC



CAMBER DIAGRAM



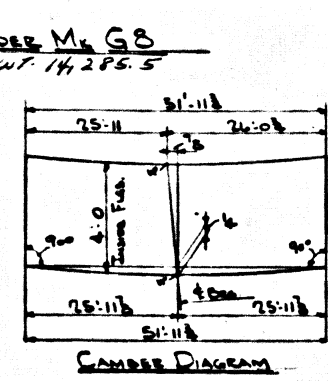
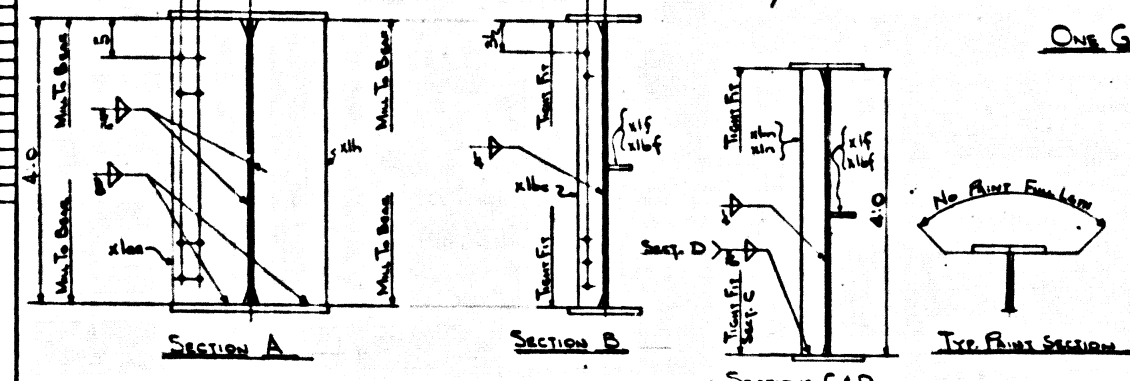
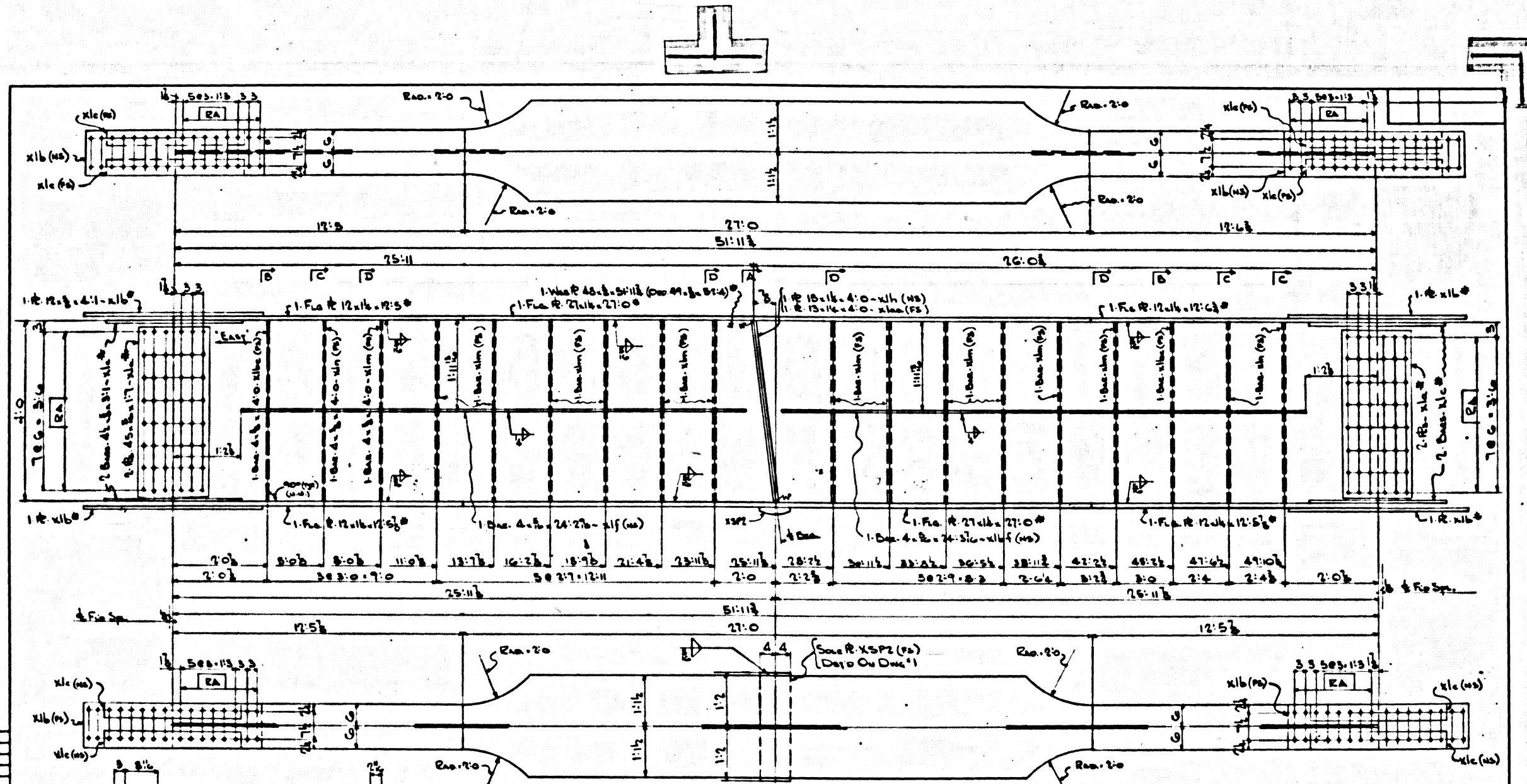
TYP. PAINT SECTION

ONE GIRDER - Mk GC  
ONE GIRDER - Mk GT

MATERIAL NOTES: HUBS - To Have Curved Top  
MATERIAL: ASTM A36 - 70  
For General Notes See Dwg. N1  
SHOP NOTE  
HOLES: 1/8" (Unless Noted)  
BOLTS: None  
PAINT: None  
One Shop Coat of TTP G15  
Type II - 1/8" Min. (Dev) Minimum (W.N.)  
Clearance SSPC-SP10 - Near Welds  
No Rein. Within 3" Of Open Holes  
LETTING DATE: APRIL 21, 1977  
DRAWING NO. 18130

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDER DETAIL		
KY 124 C-88 2-24 374 4499-87 46		
COUNTY OF LEBANON, TENN. STATE HIGHWAY ROAD		
COMMONWEALTH OF KENTUCKY		
DEPARTMENT OF HIGHWAYS		
FRANKFORT, KENTUCKY		
STATE COPY	OR. REF. NO. 30711-404	CONTRACT NO. A-Non Jus.
DATE OF PK.	DESIGNED BY R.W.L.	DATE 8-16-77
CHECKED BY	CONTRACT NO. K-77055	REVISION NO. 7 OF 14

BRIDGE



**ONE GIRDER M & GB**  
 WT. 14,285.5

MATERIAL NOTED TO BE TO HAVE GUARANTEED  
 MATH - ASTM A316 - 75  
 FOR GENERAL NOTES SEE DRAWING 111

**SHOP NOTE**  
 HOLES: 1/2" (Unless Noted)  
 BOLTS: None  
 PAINT: One Shop Coat of TTP-615d  
 Type II-15 Max. (Dry) Minimum (U.S.)  
 Coatings: 95% 570 Max. Whip Blast  
 No Paint Within 5' Of Open Holes

LETTING DATE: APRIL 21, 1977  
 DRAWING NO. 18730

16

REV.	REVISION	DATE

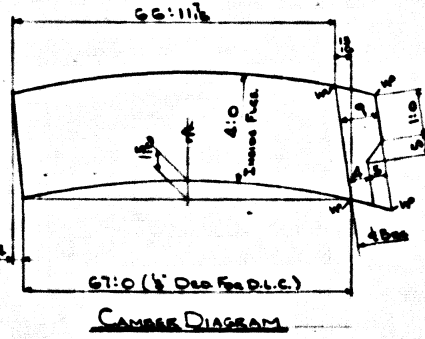
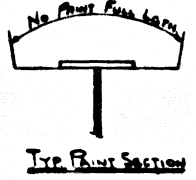
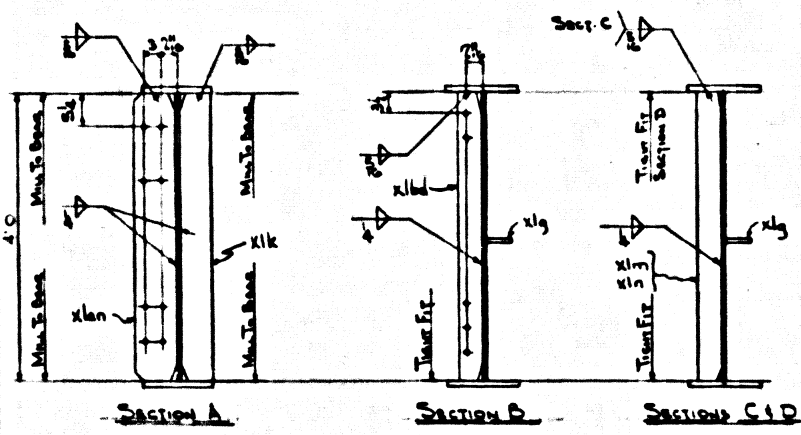
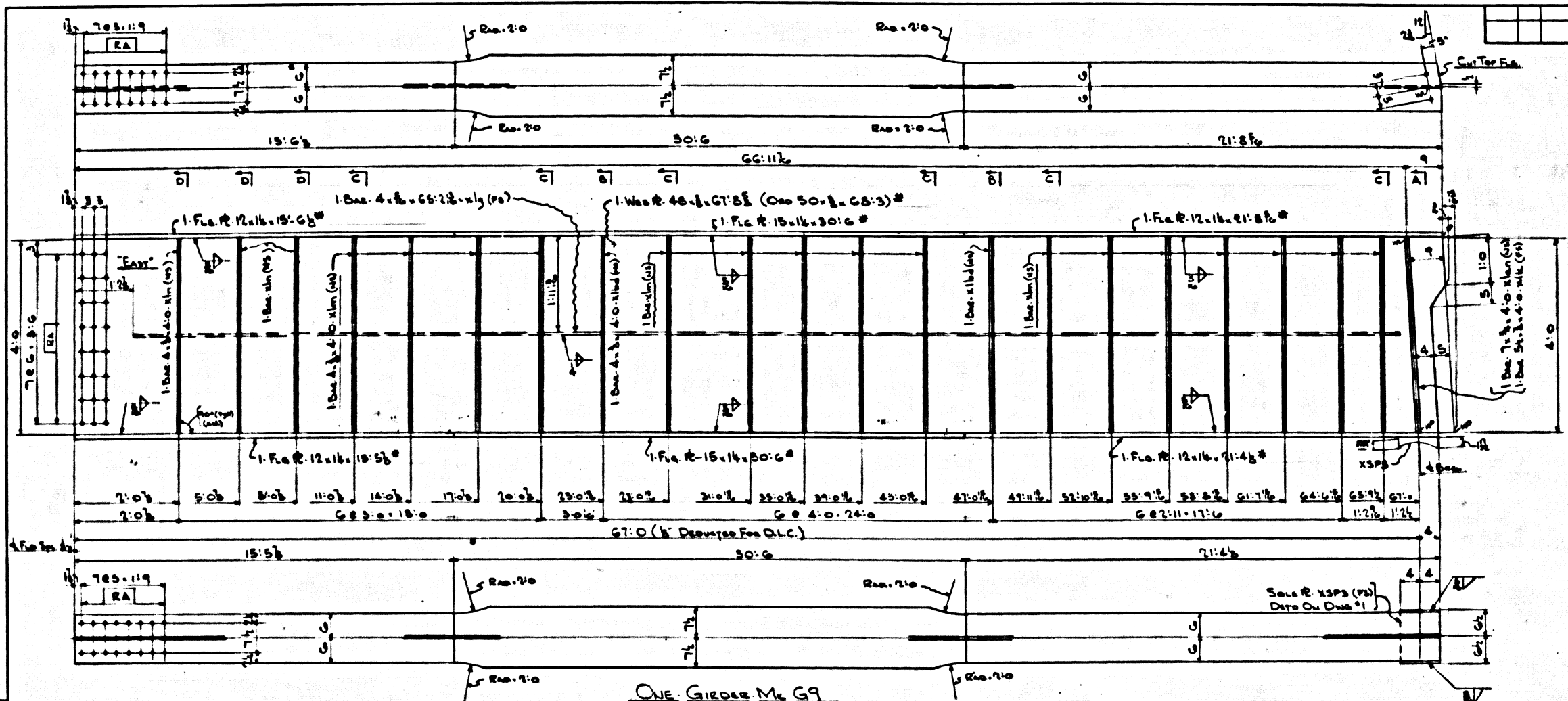
**HIGH STEEL STRUCTURES, INC.**  
 1911 OLD PHILADELPHIA PIKE  
 LANCASTER, PA.

GIRDER DESIGN  
 KY 124 SPEC. 3-14 510 449.89.46  
 COUNTY OF JEFFERSON, TRANSPORTATION DEPARTMENT  
 COMMONWEALTH OF KENTUCKY  
 BUREAU OF HIGHWAYS  
 FRANKFORT, KENTUCKY

STATE COPY  
 NO. 100 52111-404 HON. A. NORTON  
 BY: R.V. DATE: 8-16-77  
 CHECKED BY: K. TLOSS DATE: 8-16-77

**BRIDGE**

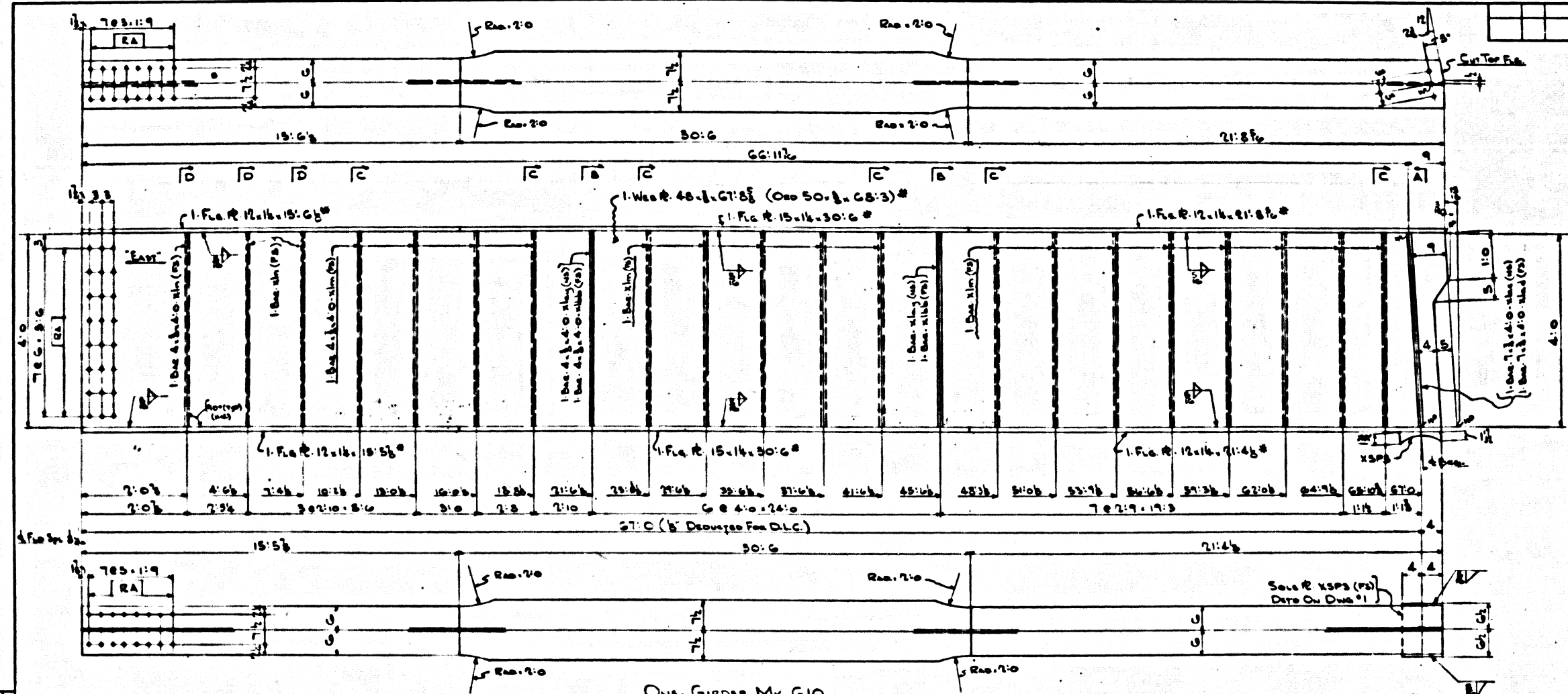




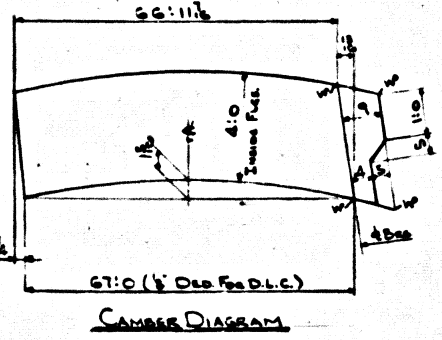
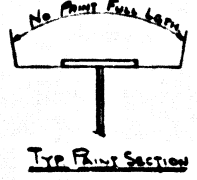
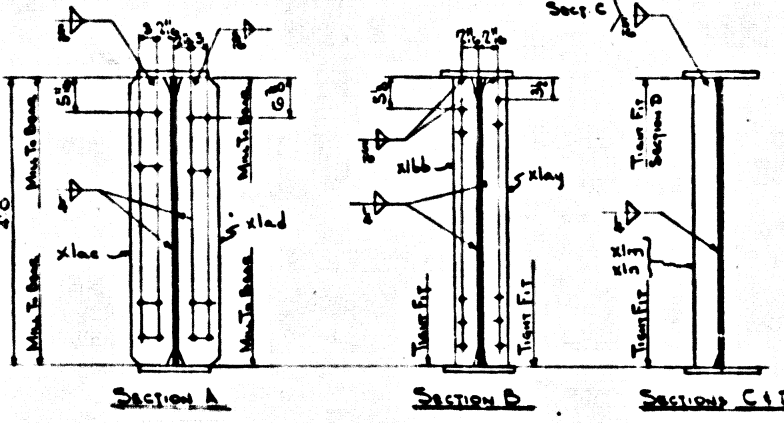
**SHOP NOTE**  
 HOLES: 1/2" (Unless Noted)  
 BOLTS: None  
 PAINT: One Shop Coat of TYP. G-15  
 Type II 1.8 Mil. (Min) Minimum (U.S.)  
 CLEANING: SSPC SP10 Near White Blast  
 No Paint Within 5' of Open Holes  
 LESTING DATE: APRIL 21, 1977  
 DRAWING NO. 18730

NO.	REVISION	DATE
		17
<b>HIGH STEEL STRUCTURES, INC.</b>		
1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDER DETAIL		
KY. 124 5th St. Sta. 4477+0 to 4480		
COUNTY OF TIGAY - PHOENIX TOWN STATE HIGH ROAD		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
FRANKFORD, KENTUCKY		
STATE CONTRACT NO.	PROJECT NO.	CONTRACTOR
7-111-404		W. A. MAN INC.
DATE OF ORDER	ORDERED BY	DATE
8-16-77	R.W.L.	8-16-77
CONTRACT NO.	SHEET NO.	TOTAL SHEETS
K-77055	9 of 14	

**BRIDGE**



ONE GIRDER Mx G10  
 WT. 12,806.5



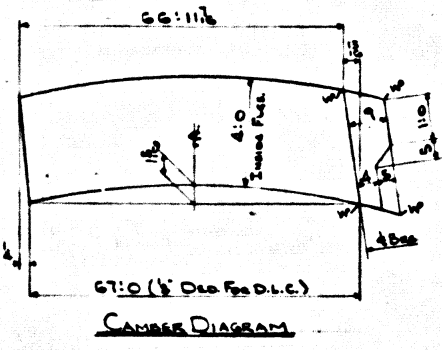
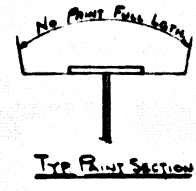
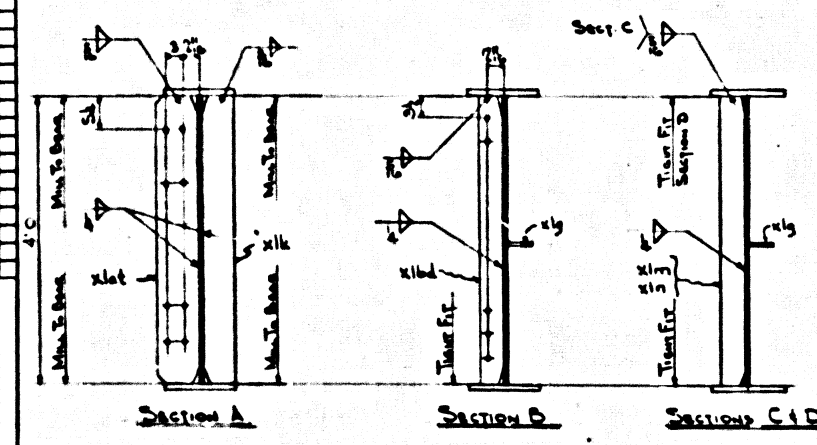
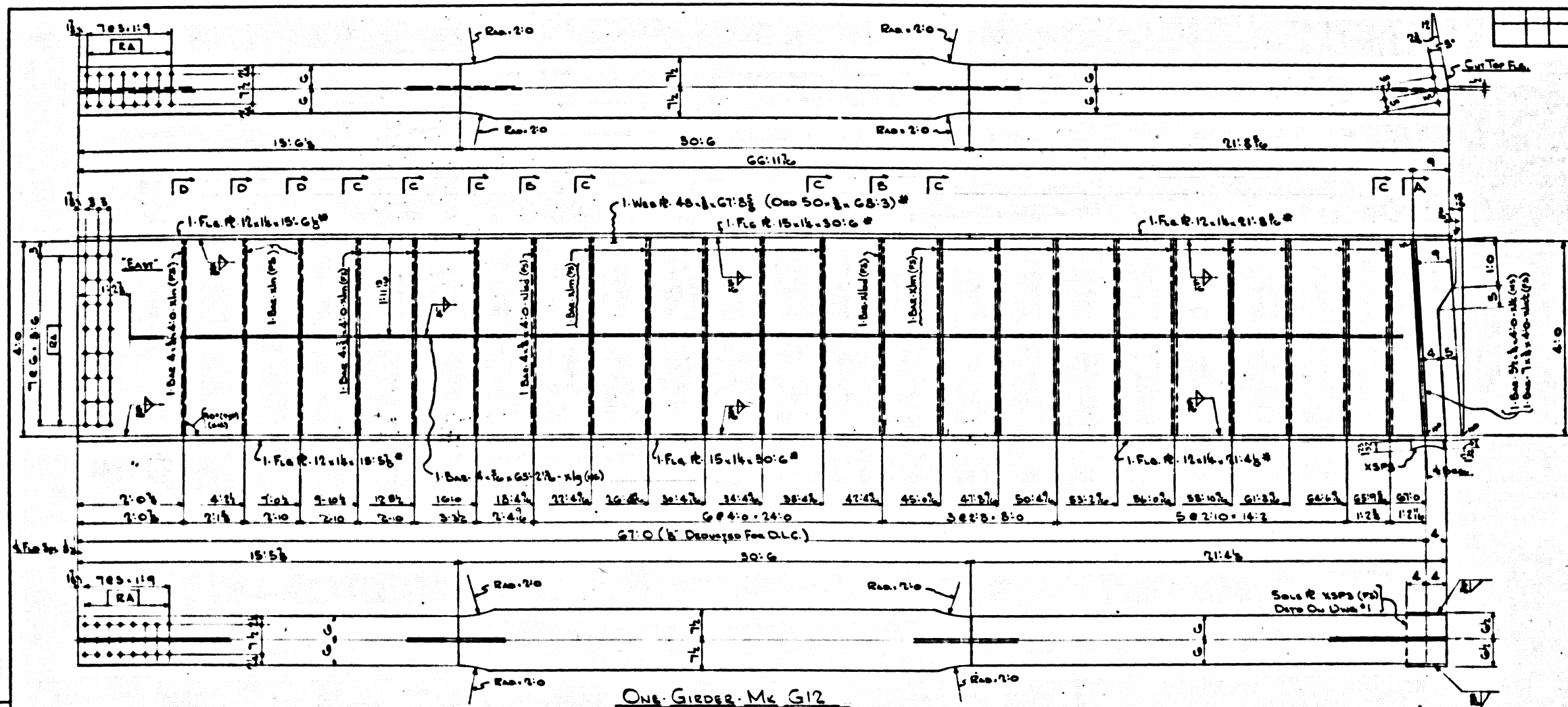
REPORT: AS BUILT TO BE RE-SPICED 11/7/77 AND BE USED TO 15 IN 79 WITH CORRECTING PARTS ASSEMBLED AND MARKED  
 MATERIAL NOTES: To Han Chung 1983  
 MAIL ASTM A36-75  
 FOR GENERAL NOTES SEE DRAWING NO. 11  
 SHOP NOTE  
 HOLES: 1/8" (Unless Noted)  
 BOLTS: None  
 PAINT: One Shop Coat Of TYP G10  
 TYPE II 1.8 MILS (DOL) Minimum On G10  
 CLEANING: SSPC SP10 Near White Blast  
 NO PAINT WITHIN 5' OF OPEN HOLES  
 LETTING DATE: APRIL 21, 1977  
 DRAWING NO. 18730

REV	DATE
18	
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.	
GIRDER DETAIL KY. 124 over 23A SpA 6497-0146 COUNTY OF TRIGO - PHOENIX TOWN STATE HIGH ROAD COMMONWEALTH OF KENTUCKY BUREAU OF HIGHWAYS FRANKFORT, KENTUCKY	
STATE COPY CON. NO. 3P11-604	DESIGNED BY: H. A. MAN INC.
DATE OF: RK	CHECKED BY: RWL
CONTRACT NO. K-77055	DATE: 8/6-77
	10 of 14

BRIDGE







REPORT FOR THE ENGINEER TO BE SUBMITTED WITH AND REFERRED TO IN THE CONTRACT AND MARKED THE PARTS AGREED AND MARK MARKED.

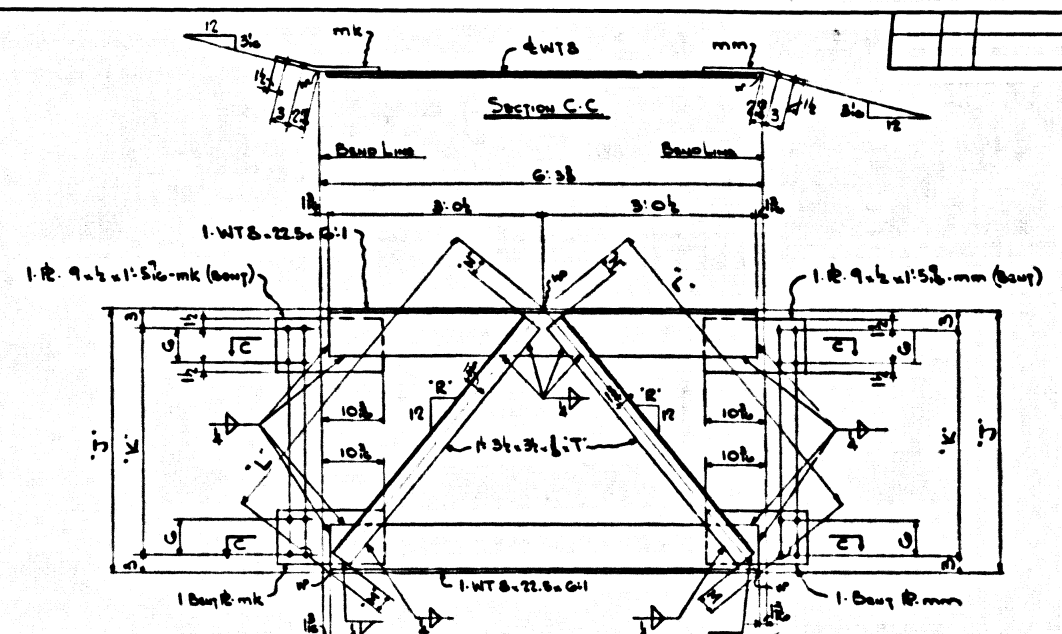
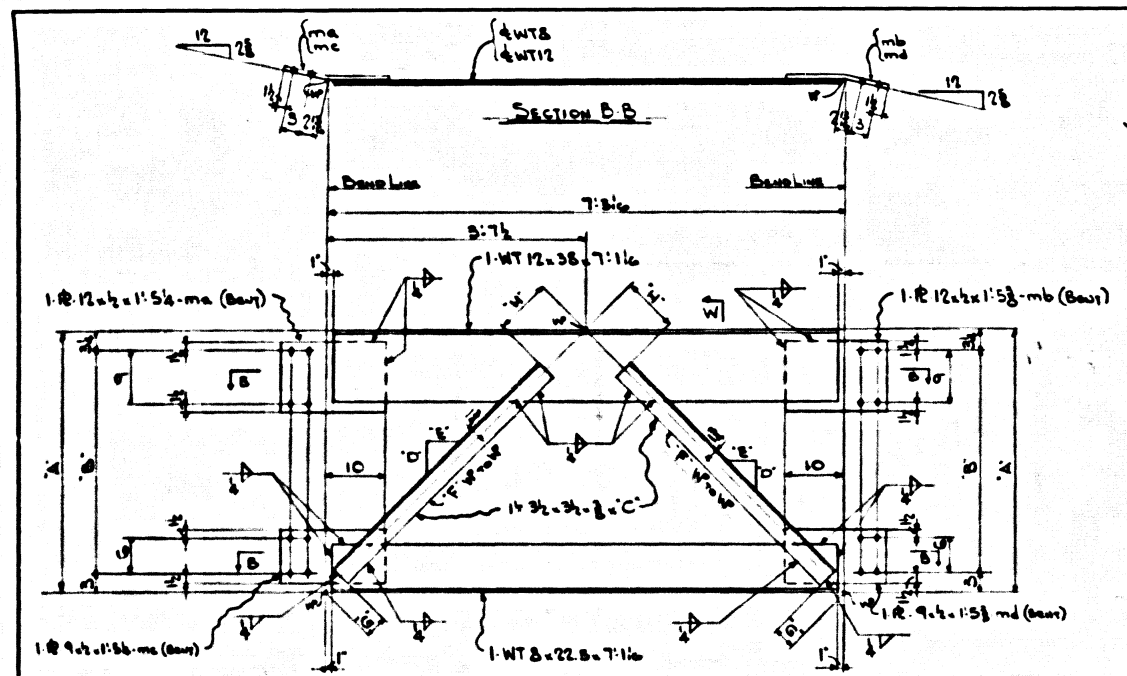
**MATERIAL NOTES:** To Have Charpy Test  
 MAIN: ASTM A36-75  
 FOR GENERAL NOTES SEE DRAWING NO. 11

**SHOP NOTE**  
 HOLES: 1/8" (Unless Noted)  
 BOLTS: None  
 PAINT: One Shop Coat of TYP G12  
 TYPE II 1/8 MILS (Per) Minimum  
 CLEANING: SSPC SP10 Near White Blast  
 No Rust Within 5' of Open Holes  
 LISTING DATE: APRIL 21, 1977  
 DRAWING NO: 18730

20

NO.	REVISION	DATE
<b>HIGH STEEL STRUCTURES, INC.</b> 1811 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDER DETAIL KY 124 OVER I-24 STA. 4049+01.40 COUNTY OF BOGGS - FARMAN - TENN. STATE HIGH ROAD COMMONWEALTH OF KENTUCKY BUREAU OF HIGHWAYS FRANKFORT, KENTUCKY		
STATE CONTRACT NO. 3P111-604	CONTRACTOR: H. A. NAW INC.	DATE: 8-16-77
DESIGNED BY: R.K.	CHECKED BY: R.W.L.	
PROJECT NO. K-71055		SHEET NO. 12 OF 14

**BRIDGE**

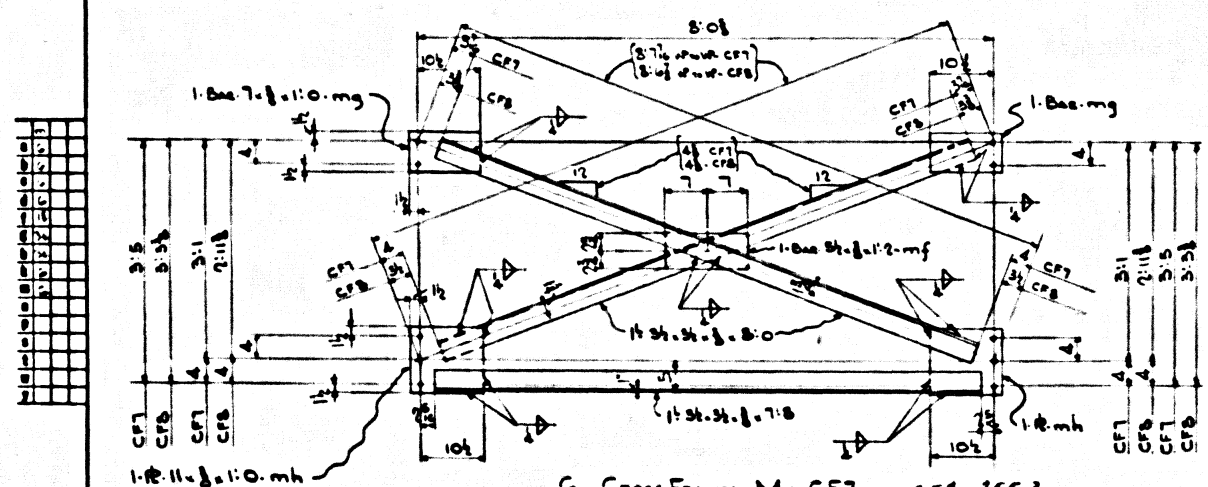


END CROSS FRAMES - CFI thru CFG

MARK	QTY	A	B	C	D	E	F	G	H	EA
CF1	ONE	3'-7 1/2"	3'-1 1/2"	4'-1"	12'	11 1/2"	5'-1 1/2"	3 1/2"	9 1/2"	601.3
CF2	ONE	3'-7 1/2"	3'-1 1/2"	4'-1"	12'	12"	5'-1 1/2"	3 1/2"	9 1/2"	601.3
CF3	ONE	3'-0 1/2"	3'-0 1/2"	4'-1"	11 1/2"	12"	5'-1 1/2"	3 1/2"	8 1/2"	601.3
CF4	ONE	3'-0 1/2"	3'-0 1/2"	4'-0"	11 1/2"	12"	5'-0 1/2"	3 1/2"	9 1/2"	599.9
CF5	ONE	3'-0 1/2"	2'-11 1/2"	4'-0"	11 1/2"	12"	5'-0 1/2"	3 1/2"	9 1/2"	599.9
CF6	ONE	3'-5 1/2"	2'-11 1/2"	4'-0"	11 1/2"	12"	5'-0 1/2"	3 1/2"	8 1/2"	599.9

- ONE CROSS FRAME - Mk CF9 435.0
- ONE - DO DO - Mk CF10 434.0
- ONE - DO DO - Mk CF11 433.2

Dim	J	K	L	M	N	R	T
CF9	3'-7 1/2"	3'-1 1/2"	4'-8 1/2"	3 1/2"	3"	10"	4'-2 1/2"
CF10	3'-0 1/2"	3'-0 1/2"	4'-8 1/2"	3 1/2"	3"	10 1/2"	4'-2 1/2"
CF11	3'-6 1/2"	3'-0 1/2"	4'-7 1/2"	3 1/2"	3 1/2"	10 1/2"	4'-1 1/2"



6. CROSS FRAMES - Mk CF7 W X EA - 255.2  
 12. DO DO - Mk CF8 W X EA - 255.2

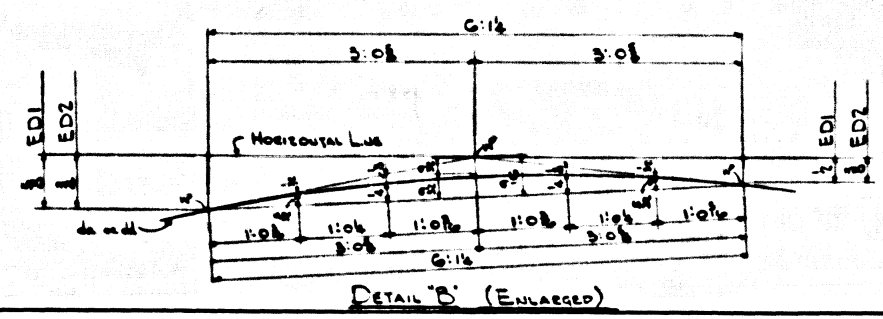
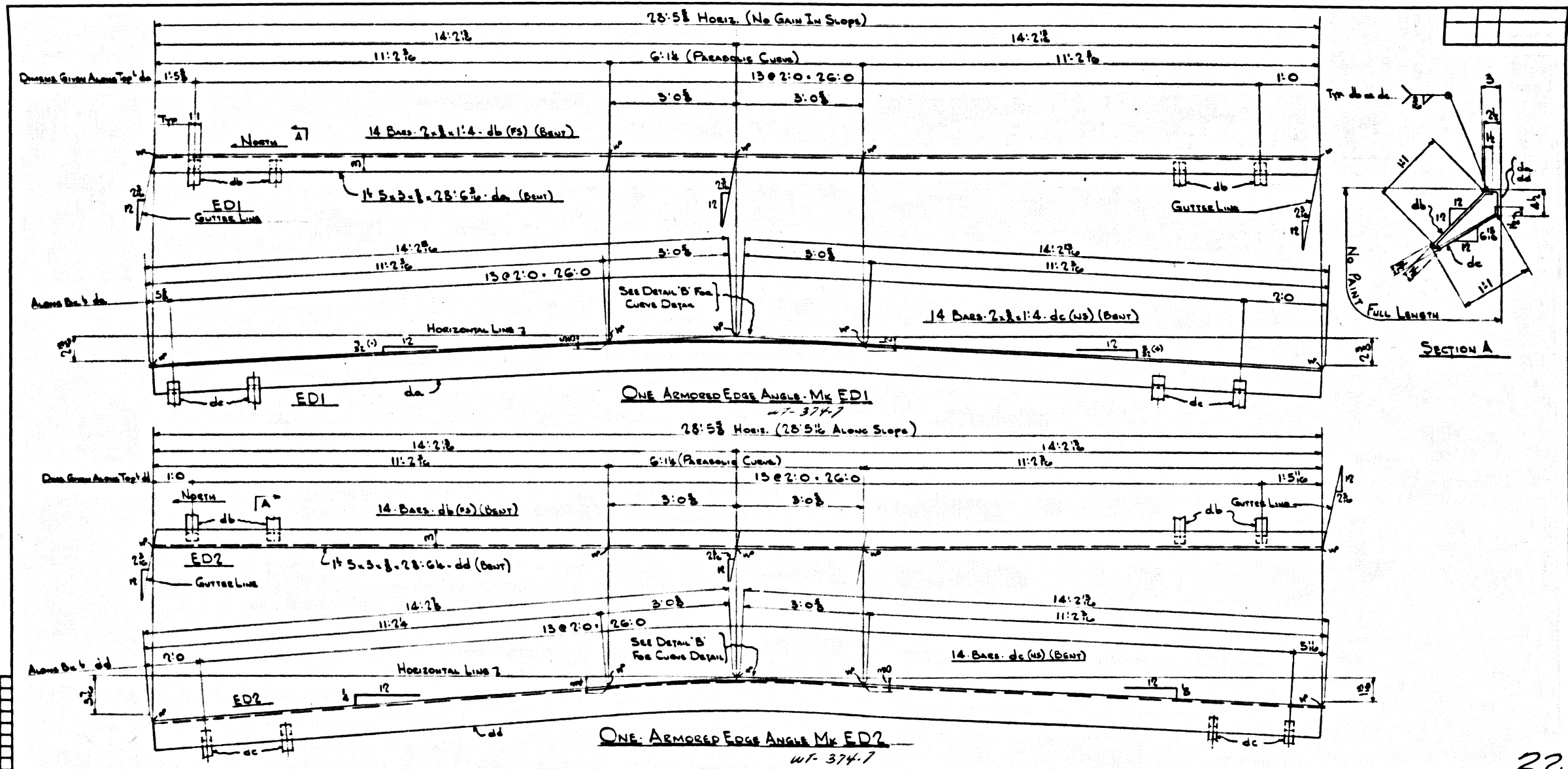
MAFL-ASTM-A56-75  
 For GENERAL NOTES See Dwg N1

**SHOP NOTE**  
 HOLES: 1/8"  
 BOLTS: None  
 PAINT: One Shop Coat of TTP with Type II, 1.5 Mil (Dry) Minimum (AIA)  
 CLEANING: SSPC SP10 Near White Blast  
 No Painting Within 5' Of Open Holes

LETTING DATE: APRIL 21, 1977  
 DRAWING NO. 18750

NO.	REVISION	DATE
21		
<b>HIGH STEEL STRUCTURES, INC.</b> 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
CROSS FRAME DETAILS		
Ky 174 over 2 24 Sta. 4+99.89 to 4+99.89		
COUNTY OF IRIGG PROVISION TOWN STATE HIGHWAY 80		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
FRANKFORT, KENTUCKY		
STATE CONTRACT OR REF. NO.	SP111-404	CONTRACTOR HOS A MAN INC.
DATE BY	RK	CHECKED BY
DATE	8-16-77	
FILE NO.	K-T1055	DRAWING NO.
CONTRACT NO.		13 of 14

BRIDGE



ONE ARMORED EDGE ANGLE - Mk ED1  
WT-374.7

ONE ARMORED EDGE ANGLE - Mk ED2  
WT-374.7

MAT'L - ASTM-A36-75  
For General Notes See Data N1

**SHOP NOTE**  
HOLES: None  
BOLTS: None  
PAINT: One Shop Coat of TTP-6184  
Type II - 1.5 Min (Min) Minimum  
(Unless Noted)

CLEANING: SSPC-SP10

LETTING DATE: APRIL 21, 1977  
DRAWING NO. 18720

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
ARMORED EDGE ANGLES		
KY 124 CURVE 224 STA 4199+00 TO 4200		
COUNTY OF BIRCH - FARMER - 19TH STATE HIGHWAY		
COMMONWEALTH OF KENTUCKY		
DIVISION OF HIGHWAYS		
FRANKFORT, KENTUCKY		
STATE CONTRACT NO.	SP111-404	CONTRACTOR
DESIGNED BY	RK	ENGINEER
DATE	8-17-77	
CONTRACT NO.	K-77055	DRAWING NO.
		14 of 14

22

BRIDGE





**HIGH STEEL STRUCTURES, INC.**

MEMPHIS, TENNESSEE 38102

**SHOP WELDING PROCEDURES**

Project: S-24-2(223)S  
By: 124 over S-24  
Trigg County, Kentucky  
Drawing No. 18730  
S.S.S. Shop No. S-77000

REVIEWED FOR  
DESIGN ONLY

MUG 8-1977

*C. Fisher, P. E.*

Issued Date: April 22, 1977

These procedures are to be used in conjunction with the  
prescribed specifications of the Kentucky Department of  
Highways Standard Specifications for Road and Bridge  
Construction. References used herein are to the American  
Welding Society Standard Specification for Welded Highway  
and Railway Bridges (A.W.S. B1.1-73).

Welding Procedure for A.W.S. Prequalified Joints

Checked



**I. DEFINITIONS**

The welding terms used in these specifications shall be interpreted according to the definitions given in the 1969 edition of A. W. S. "Standard Welding Terms and Their Definitions."

**II. PREPARATION OF MATERIAL FOR WELDING**

Details of welds and welded pieces shall be in accordance with approved shop detail drawings. Dimensional tolerances, straightness and flatness of structural shapes and plates shall be within the limits prescribed by the current A.S.T.M. A36 and A572 specifications.

Shop details shall indicate the proper joint preparation for the welding procedure proposed by the shop in instances where the shop prefers a process not detailed on the design drawings. If the joint configuration is not prequalified, High Steel Structures will submit to the engineer for approval the welding procedure specification of the joint with qualification test records.

The facing surfaces of the web and flange plates and the adjacent surfaces that are to be fillet welded shall be cleaned by grinding prior to assembly and welding of web to flange.

**III. ASSEMBLY**

Shutting parts to be joined by butt welds shall be cut square and true and aligned accurately. Butt welds shall be blocked up sufficiently to allow shrinkage to control distortion. The areas adjacent to the weld shall not be ground after grinding. The grinding shall produce a smooth machine-like finish which meets or exceeds 250 on the surface roughness scale. (A.S.T.M. B1.1-73)

Parts to be joined by fillet welds shall be brought into as close contact as practicable. If the separation is 1/16 inch or greater, the leg of the fillet weld shall be increased by the amount of the separation.

**IV. FILLER METAL**

Filler metal for submerged arc welding shall be dry and free of contamination from dirt, oil, scale, or other foreign material. Filler metal in welding shall not be reused. Filler metal that has not fused may be reused only after processing through the Invincible Vacuum Corporation flux cleaner or the Optom cleaner attached to the dart machine. Filler metal used shall be as specified on attached weld details.

**V. PROCEDURES FOR SUBMERGED ARC WELDING WITH A SINGLE ELECTRODE**

All submerged arc butt welds shall be made in the flat position. Fillet welds may be made in either the flat or horizontal position except that single-pass fillet welds made in the horizontal position shall not exceed 3/16 inch.

The thickness of weld layers, except root and surface layers, shall not exceed 1/4 inch. Where the root opening is 1/2 inch or greater, a multiple-pass, split-layer technique shall be used. The split-layer technique shall also be used in making multiple-pass welds when the width of the layer exceeds 3/8 inch.

Tack welds, in the way of fillet welds 3/8 inch or smaller in size, or in the root of joints requiring specific root penetration, shall be sufficiently small, generally 1/8 inch in appearance, that they do not produce objectionable changes in penetration; otherwise they shall be removed or reduced in size by any suitable means prior to welding.

Each weld pass shall have all slag removed before any additional weld is deposited on it.

Groove welds shall be terminated at the ends of a joint in a manner that will ensure sound welds. This shall be done by use of extension bars or run-off plates as detailed on the shop flange assembly drawings. When used, extensions shall be removed upon completion and sealing of the weld and the ends of the weld made smooth and flush with the ends of the shutting parts.

Roots of groove welds may be sealed with a root pass made by manual shielded metal arc welding with low-hydrogen electrodes when such sealing is necessary to prevent burn-through of the initial submerged arc welding pass.

**VI. FABRICATION REQUIREMENTS**

Butt welds in flange plates shall be made prior to assembling girders. Where plates are ordered in multiple widths the welds shall be made before flame cutting. If straightening is necessary after welding, it shall be done mechanically or by hammer. Flange plates up to 3/4 inch thickness may be curved before assembling the girder to or opposite for distortion caused by welding.

The web plates shall be trimmed along both edges to proper width, with allowance for shrinkage and to the corner shape. The best welding of the web plates shall be done in the flat position by the submerged arc welding process.

After the flange and web butt welds are complete they shall be assembled and tack welded, fitting the flange plate tight and square against the edges of the web. Flange to web fillet welds shall be made in the flat position (using face and toe end of the girder). The weld shall be made using the submerged arc semi-automatic machines (Lincoln Squir-obile).

The stiffeners will then be fit and tack welded in accordance with the detail drawings. Welding of the stiffeners will be by submerged arc process in horizontal position using the dart machine.

All auxiliary parts shall then be fit and welded to the girder after which it will be trimmed to detailed length.

All necessary corner adjustments will be made, as much as is possible, by proper blocking of the member when within the flange to web and the coverplate to flange.

Any minor corner and/or sweep adjustments will be made by application of heat, not exceeding 1100 Fahrenheit, by an experienced technician.

Corner adjustments will be made by heating an area at the center and quarter points of the member, the area being determined by the amount of corner needed, the thickness and width of the flange, and the length and weight of the member. Most corner adjustments are completed with the area heated not exceeding two inches by twelve inches at each point.

Sweep adjustments will be made by heating the convex edge of the flange or flanges. The heat shall be applied at the center and quarter points of greatest convexity.

Vertical stress will be relieved by application of heat to the toe edges of each flange the full length of the member. The amount of heat applied, as controlled by the travel speed of the torch, is dependent on the stress to be relieved; therefore, the heat input is variable.

In an instance may the metal temperature exceed 1100 degrees Fahrenheit regardless of the type of adjustment to be accomplished.

Procedure Specification table for Submerged Arc Welding. Columns include Material Specification (ASTM A-36, A-572, A-441), Welding Process (Sub-Arc), Manual or Automatic (Manual), Position of Welding (Flat/Horizontal), Filler Metal Specification (AWS A5.1-60), Filler Metal Classification (E7018), Flux (D.W.A.), Single or Multiple Arc (Single), Welding Current (400 Amps), Polarity (Electrode Negative), Heat Treatment (None), and Preheat and Interpass Temperature (See attached preheat chart).

Welding Procedure table for Submerged Arc Welding. Columns include No. of Steel Plates, Steel Size, Welding Speed (inches per minute), and Weld Type (V-Groove, Flat/Horizontal Fillet). Includes a diagram of a fillet weld joint.

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the "Limitations of Variables" given in the American Welding Society Welding Code, A.W.S. B1.1-73.

Procedure Specification table for Submerged Arc Welding. Columns include Material Specification (ASTM A-36, A-572, A-441), Welding Process (Sub-Arc), Manual or Automatic (Manual), Position of Welding (Horizontal), Filler Metal Specification (A.W.S. A5.17-60), Filler Metal Classification (E7018), Flux (Lincoln 701), Single or Multiple Arc (Lincoln 161 Single Electrode), Welding Current (400 Amps), Polarity (Electrode Negative), Heat Treatment (None), and Preheat and Interpass Temperature (See attached preheat chart).

Welding Procedure table for Submerged Arc Welding. Columns include No. of Steel Plates, Steel Size, Welding Speed (inches per minute), and Weld Type (5" Fillet, 3/16" Fillet, 3/8" Fillet, 1/2" Fillet). Includes a diagram of a fillet weld joint.

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the "Limitations of Variables" given in the American Welding Society Welding Code, A.W.S. B1.1-73.

Procedure Specification table for Submerged Arc Welding. Columns include Material Specification (ASTM A-36, A-572, A-441), Welding Process (Sub-Arc), Manual or Automatic (Manual), Position of Welding (Flat), Filler Metal Specification (AWS A5.17-60), Filler Metal Classification (E7018), Flux (Lincoln 600), Single or Multiple Arc (Lincoln 161 Single Electrode), Welding Current (400 Amps), Polarity (Electrode Positive), Heat Treatment (One Seal Bead as required), and Preheat and Interpass Temperature (See attached preheat chart).

Welding Procedure table for Submerged Arc Welding. Columns include No. of Steel Plates, Steel Size, Welding Speed (inches per minute), and Weld Type (3/4" Fillet, 1" Fillet, 1 1/2" Fillet, 2" Fillet). Includes a diagram of a fillet weld joint.

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the "Limitations of Variables" given in the American Welding Society Welding Code, A.W.S. B1.1-73.

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MAINTENANCE PROJECT NO.  
18730

UPDATE DATE  
LETTING DATE

Welding Procedure for A.S.S. Prequalified Joints

Procedure Specification

Material Specification ..... ASTM A-36, A-572, A-661  
 Welding Process ..... Sub-arc  
 Name of Machine ..... Lincoln ML-3 or LM-4  
 Position of Welding ..... Flat  
 Filler Metal Specification ..... AWS A5.17-60  
 Filler Metal Classification ..... E70-2012K  
 Flux ..... Lincoln 560  
 Single or Multiple Arc ..... Lincoln 561 Single Electrode  
 Welding Current ..... 400  
 Polarity ..... Electrode Positive  
 Root Treatment ..... One seal bead as required (see 1/8" Detail)  
 Preheat and Interpass Temperature ..... See attached preheat chart

Welding Procedure

No. of Steel Plates	Welding Current (Amps)	Speed (in/min)	Weld Thickness (in)	Weld Type	Joint Detail
2	400	34	1/8"	1/8"	
2	400	34	1/8"	3/8"	
2	400	34	1/8"	1/2"	
2	400	34	1/8"	3/4"	
2	400	34	1/8"	1"	

This procedure may vary due to fabrication sequence, fit-up, plate size, etc. within the "Limitation of Variability" given in the American Welding Society Welding Code, A.S.S. M.1-72.

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Welding Procedure for A.S.S. Prequalified Joints

Procedure Specification

Material Specification ..... ASTM A-36, A-572, A-661  
 Welding Process ..... Sub-arc  
 Name of Machine ..... Lincoln ML-3 or LM-4  
 Position of Welding ..... Flat  
 Filler Metal Specification ..... AWS A5.17-60  
 Filler Metal Classification ..... E70-2012K  
 Flux ..... Lincoln 561  
 Single or Multiple Arc ..... Lincoln 561 Single Electrode  
 Welding Current ..... 400  
 Polarity ..... Electrode Positive  
 Root Treatment ..... One seal bead as required (see 1/8" Detail)  
 Preheat and Interpass Temperature ..... See attached preheat chart

Welding Procedure

No. of Steel Plates	Welding Current (Amps)	Speed (in/min)	Weld Thickness (in)	Weld Type	Joint Detail
2	400	34	1/8"	1/8"	
2	400	34	1/8"	3/8"	
2	400	34	1/8"	1/2"	

This procedure may vary due to fabrication sequence, fit-up, plate size, etc. within the "Limitation of Variability" given in the American Welding Society Welding Code, A.S.S. M.1-72.

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Welding Procedure for A.S.S. Prequalified Joints

Procedure Specification

Material Specification ..... A-36, A-572, A-661  
 Welding Process ..... Sub-Arc  
 Name of Machine ..... Auto-Machine (Line-Equivalent)  
 Position of Welding ..... Flat  
 Filler Metal Specification ..... A.S.S. A5.17-60  
 Filler Metal Classification ..... E70-2012K  
 Flux ..... Lincoln 561  
 Single or Multiple Arc ..... Single 161  
 Welding Current ..... See Below  
 Polarity ..... Electrode Negative  
 Root Treatment ..... Remove Hill Scale  
 Preheat and Interpass Temperature ..... See Preheat Chart

Welding Procedure

Part No.	Steel Plate	Welding Current (Amps)	Speed (in/min)	Weld Thickness (in)	Joint Detail
1	A-36	400	34	1/8"	
2	A-36	400	34	3/8"	
3	A-36	400	34	1/2"	
4	A-36	400	34	3/4"	

This procedure may vary due to fabrication sequence, fit-up, plate size, etc. within the "Limitation of Variability" given in the American Welding Society Welding Code, A.S.S. M.1-72.

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STATION

QUALITY CONTROL AND INSPECTION REQUIREMENTS

Item	Inspection Method	Frequency	Acceptance Criteria
Welding Process	Visual	Continuous	Conforms to specification
Welding Current	Visual	Continuous	Conforms to specification
Welding Speed	Visual	Continuous	Conforms to specification
Welding Polarity	Visual	Continuous	Conforms to specification
Welding Flux	Visual	Continuous	Conforms to specification
Welding Electrode	Visual	Continuous	Conforms to specification
Welding Root Treatment	Visual	Continuous	Conforms to specification
Welding Preheat	Visual	Continuous	Conforms to specification
Welding Interpass Temperature	Visual	Continuous	Conforms to specification

This procedure may vary due to fabrication sequence, fit-up, plate size, etc. within the "Limitation of Variability" given in the American Welding Society Welding Code, A.S.S. M.1-72.

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STATION	P. E. PROJECT NO.	Drawing No.
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