

SPECIAL NOTE FOR EDGE BLOCKS

In addition to the requirements of Special Provision No. 4 and Section 607.03.07 of the Department's Standard Specifications for Road and Bridge Construction, use edge blocks when radiographing butt welds greater than 1/2 inch thick.

Use edge blocks made of radiographically clean steel having a surface finish of ANSI 125 μ inch or smoother.

Provide edge blocks of sufficient length to extend beyond each side of the weld centerline for a minimum distance equal to the weld thickness, but no less than 2 inches, and have a thickness equal to or greater than the thickness of the weld. Ensure the minimum width of the edge blocks is equal to half the weld thickness, but not less than one inch.

Center the edge blocks on the weld with a snug fit against the plate being radiographed, allow no more than a 1/16 inch gap.

(Approved by AASHTO/AWS Joint Committee on Bridge Welding Code D 1.5.)

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