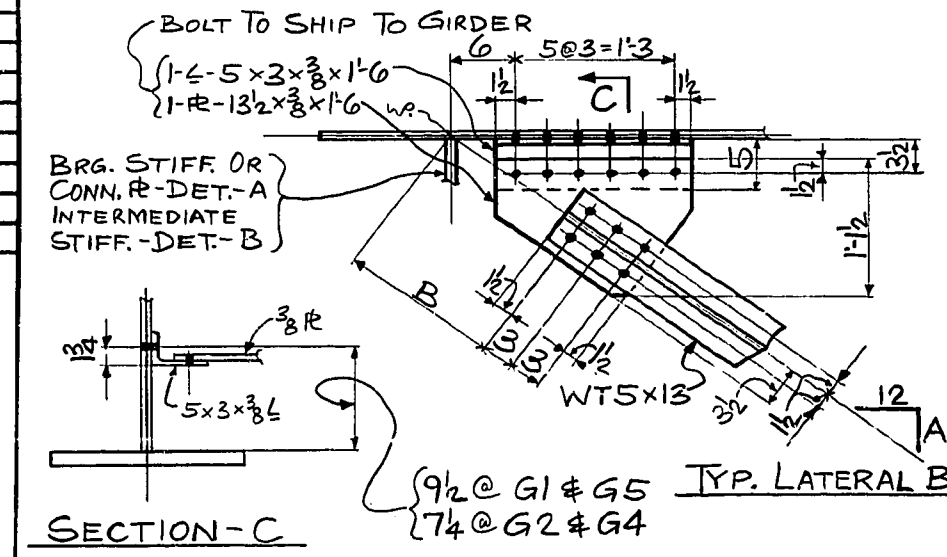


FIGURING PLAN



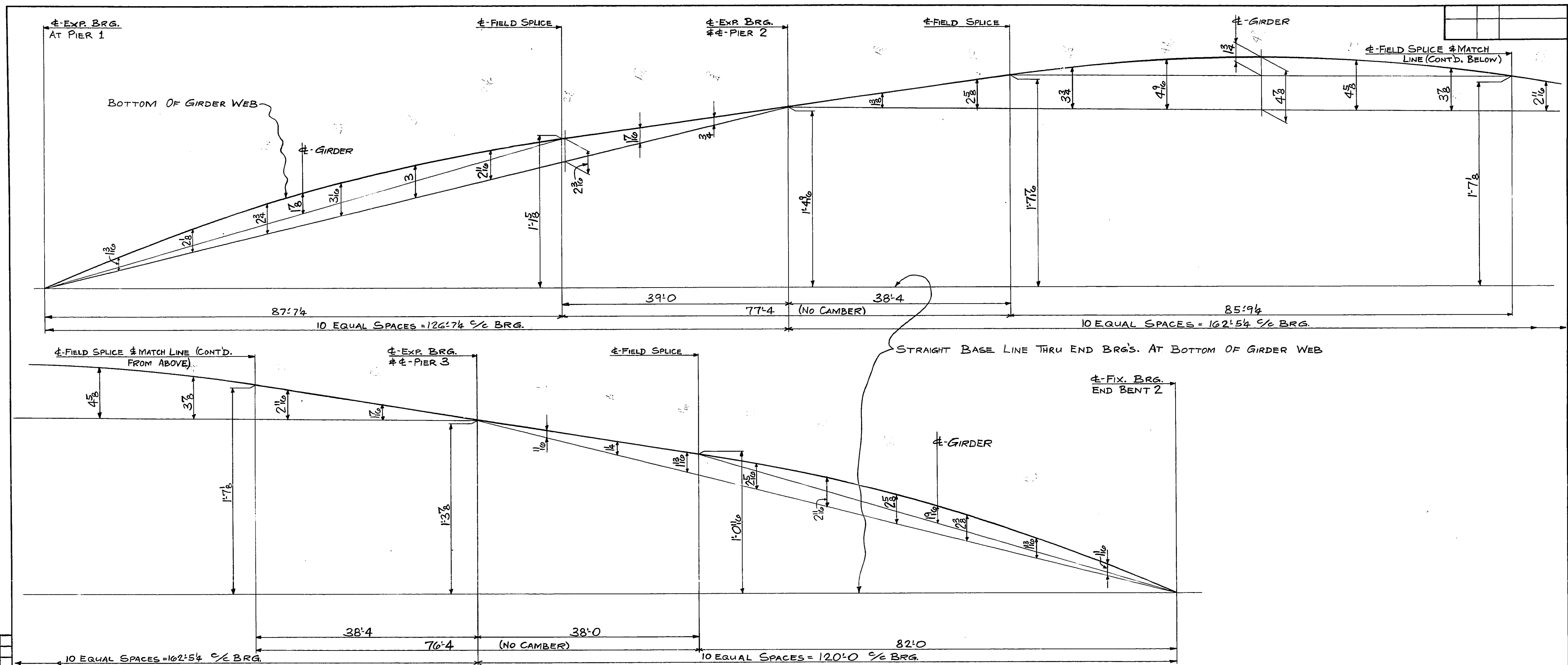
DETAIL	A	B
A # B	10 3/8	1'-1 1/8
A # B	9 3/8	1'-2 1/8
A # B	8 1/8	1'-3
A # B	10 3/8	1'-1 1/8

NOTES:

1. ALL DIMENSIONS ARE GIVEN HORIZONTALLY (U.N.).
2. DIMENSIONS GIVEN THUS: [75'-0"] ARE MEASURED PARALLEL TO THE GRADE.
3. FIGURES GIVEN THUS: .0215 ARE THE GRADES OF THE GIRDER CHORD LINES BETWEEN BEARINGS AND, OR FIELD SPLICES AFTER ALL DEAD LOAD HAS BEEN APPLIED; ARROW POINTS DOWNWARD.
4. FIGURES GIVEN THUS: V ARE THE DROPS BETWEEN GIRDERS; ARROW POINTS TOWARD LOW GIRDER.
5. ENDS OF GIRDERS & ALL BEARING STIFFENERS TO BE VERTICAL.
6. INTERMEDIATE CROSS FRAMES & STIFFENERS TO BE 90° TO FLANGES.
7. ALL STIFFENER & CROSS FRAME SPACING IS GIVEN TO C/O OF STIFFENER OR CONNECTION PLATE.
8. ALL STEEL TO BE A.S.T.M. - A36 (U.N.) ON DETAIL DRAWINGS.
9. ALL FIELD CONNECTIONS TO BE MADE WITH 3/8" H.S. (A-325 TYPE I) BOLTS; FRICTION TYPE.

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
FIGURING PLAN U.S. 60 OVER CLARKS RIVER (E.B.) U.S. 60 STA. 1284+54.55 COMMONWEALTH OF KENTUCKY BUREAU OF HIGHWAYS M ^C CRACKEN COUNTY, KY.		
STATE CONT. NO. SP-73-32-13L	CONTRACTOR CRAWFORD CONST. CO., INC.	
OR REF. NO. 12-11-79	IN CHARGE: SALTER	DATE: 12-11-79
MADE BY: B.D.S.	CHECKED BY: RF	
CONTRACT NO. K-79167	DRAWING NO. WS1	

DRAWING NO. 19909
LETTING DATE: 10-19-79



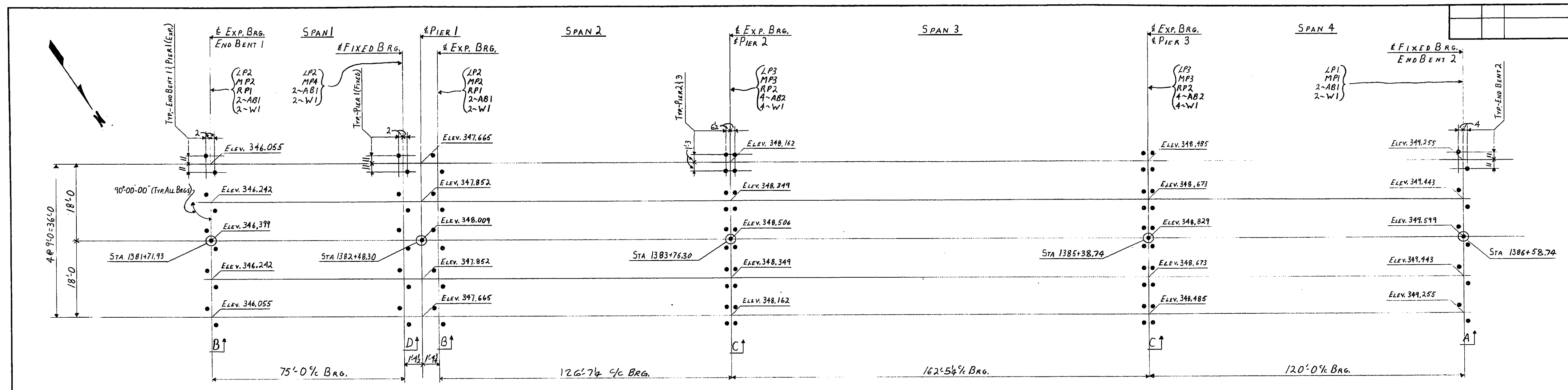
TYPICAL CAMBER DIAGRAM

NOTE:
LONGITUDINAL DIMENSIONS ARE GIVEN HORIZONTALLY AND
MUST BE ADJUSTED FOR GRADE SLOPE.

SCALE: HORIZONTAL - 1/8" = 1'-0"; VERTICAL - 3" = 1'-0."

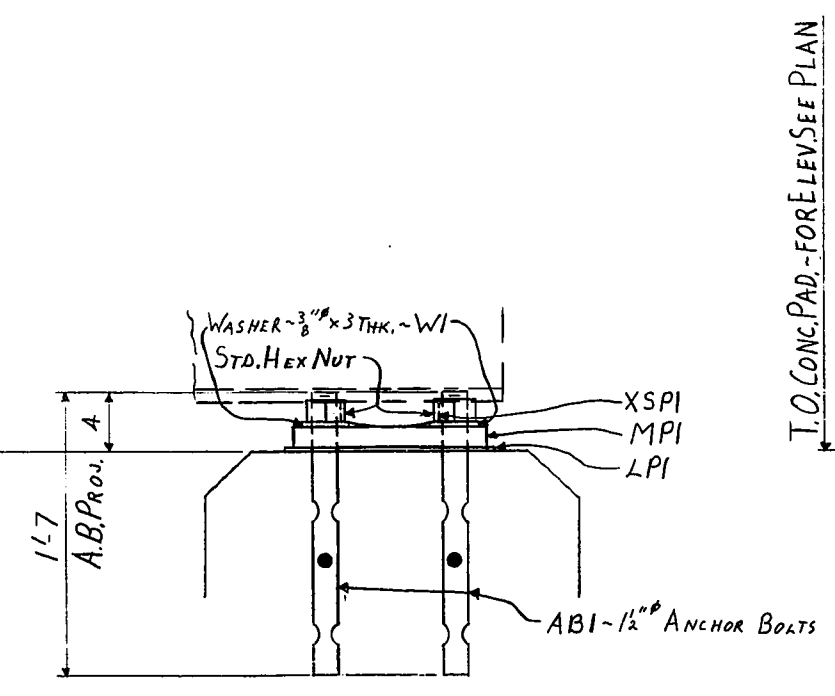
DRAWING NO.: 19909
LETTING DATE: 10-19-79

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
CAMBER DIAGRAM		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 1384+54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, K.Y.		
STATE CONT. OR REF. NO. SP-73-32-13L	CONTRACTOR CRAWFORD CONST. CO., INC.	
IN CHARGE: SALTZER		
MADE BY: R.D.G.	CHECKED BY: RF	DATE: 12-10-79
CONTRACT NO. K-79167	DRAWING NO. CD1	

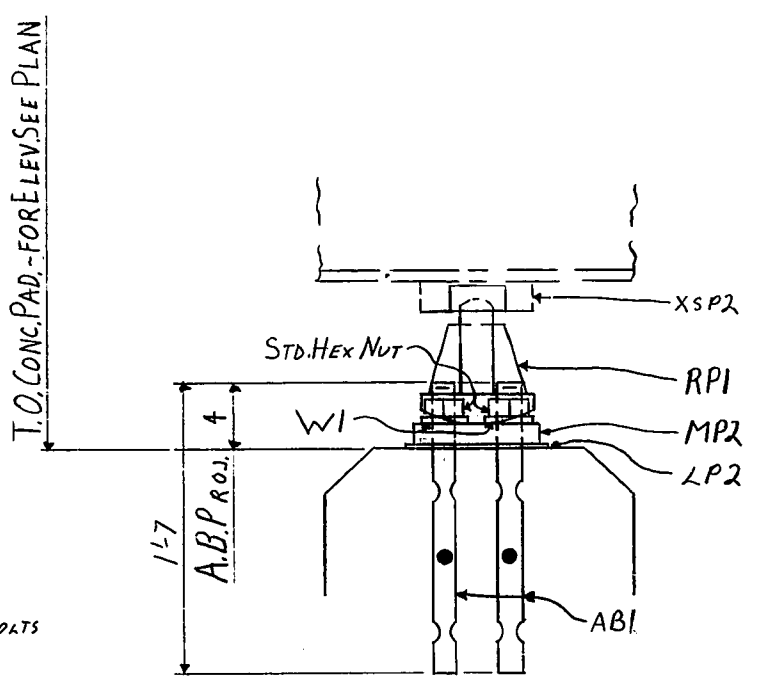


ANCHOR BOLT PLAN

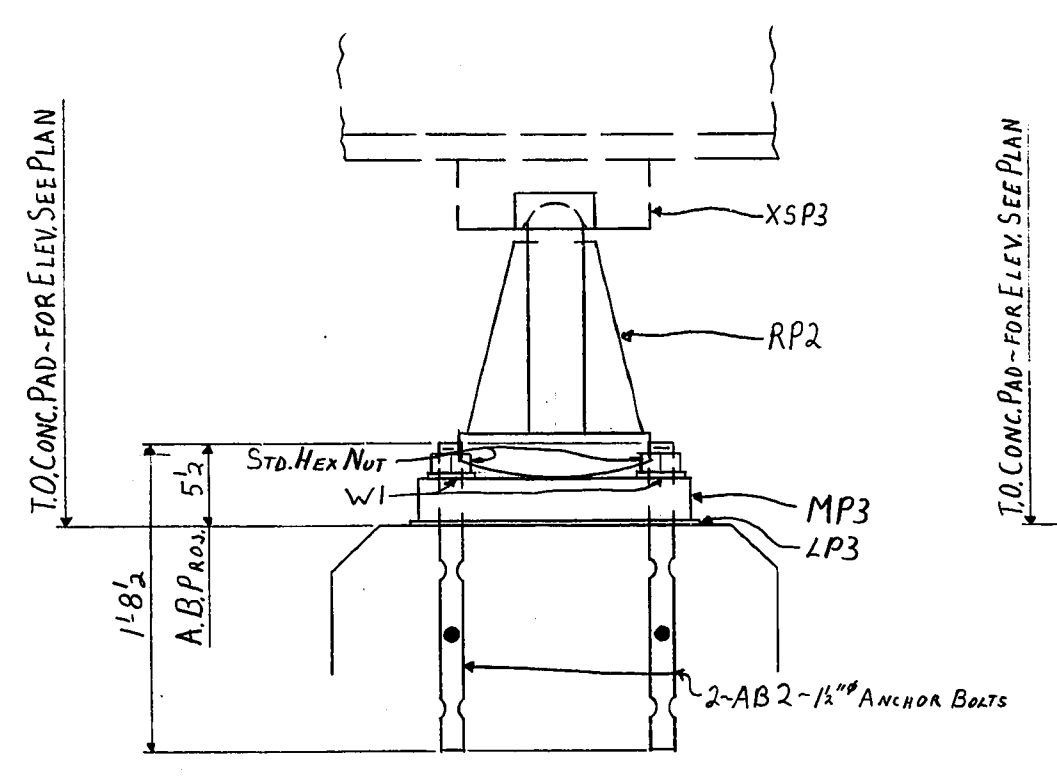
TOP OF CONCRETE PAD - FOR ELEVATIONS SEE PLAN



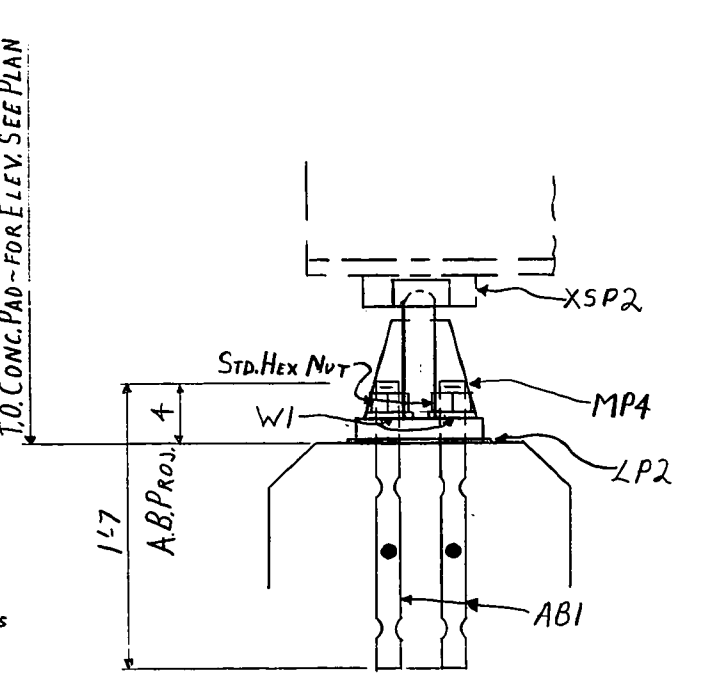
SECTION-A



SECTION-B



SECTION-C

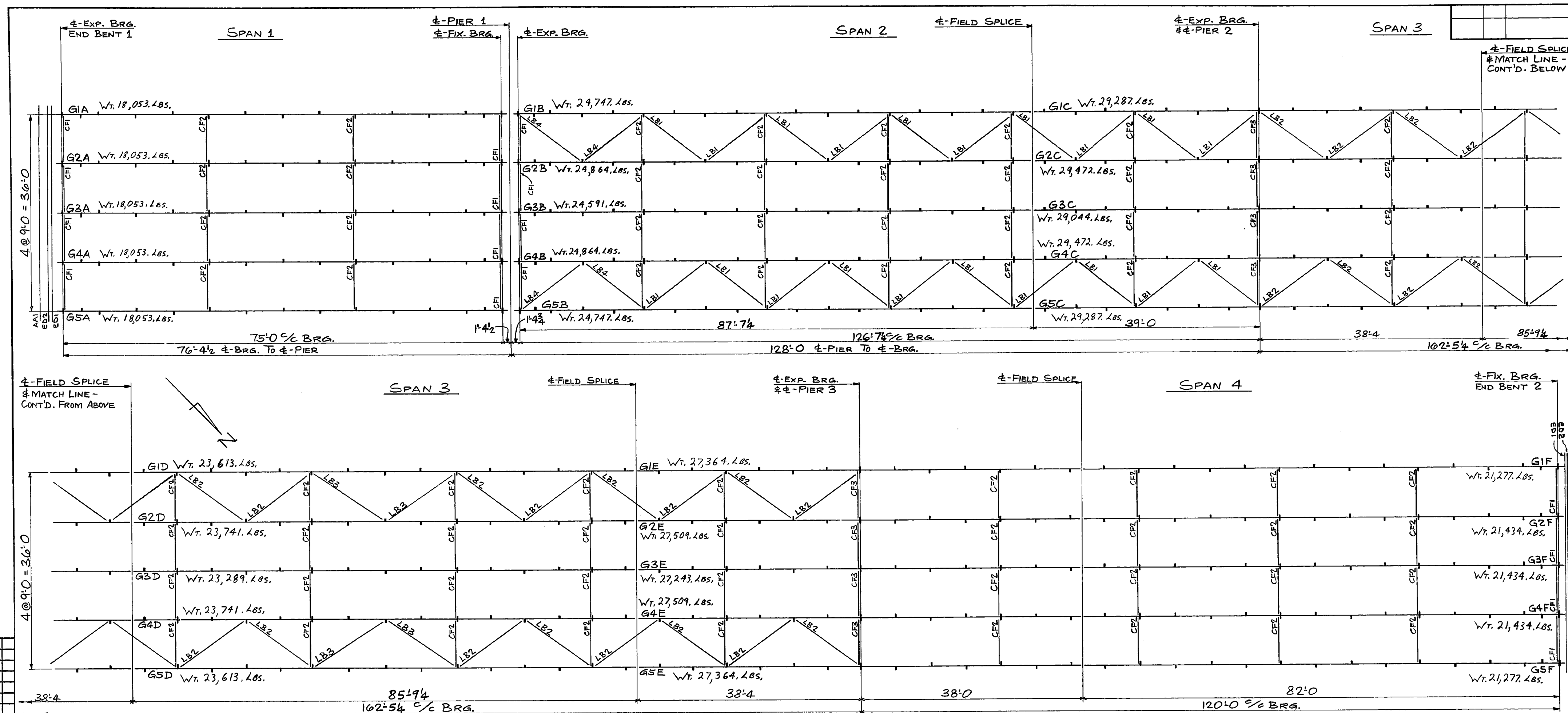


SECTION-D

NOTES
 ELEVATIONS ARE GIVEN TO TOP OF CONCRETE PAD
 ALL DIMENSIONS ARE GIVEN HORIZONTALLY
 ANCHOR BOLTS ARE FURNISHED BY HIGH STEEL STRUCTURES INC.
 AND SET BY OTHERS.
 ANCHOR BOLT SETTINGS MUST BE EXACT IN EVERY DETAIL IN
 ACCORDANCE WITH THIS DRAWING.

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC.		
1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
ANCHOR BOLT PLAN U.S. 60 OVER CANNON RIVER (E.B.) U.S. 60 STA 1384+54.55 COMMONWEALTH OF KENTUCKY BUREAU OF HIGHWAYS MCCREARY COUNTY, KY.		
STATE CONT. OR REF. NO. IN CHARGE'S SIGNATURE	CONTRACTOR CRAWFORD CONST. CO., INC.	
MADE BY L.D.B.	CHECKED BY RF	DATE 12-19-79
CONTRACT NO. K-79167	DRAWING NO. E1	

Drawing No. 19909
 Letting Date: 10-19-79



ERECTION PLAN

NOTES:

- ALL DIMENSIONS ARE GIVEN HORIZONTALLY.
- ALL FIELD CONNECTIONS TO BE MADE WITH 7/8" HIGH STRENGTH BOLTS (TYPE 1).
- ALL STEEL TO BE A.S.T.M. A36.
- WORK THIS DRAWING WITH DRAWING E3.
- SCUFFERS ARE NOT FURNISHED OR INSTALLED BY HIGH STEEL STRUCTURES, INC.

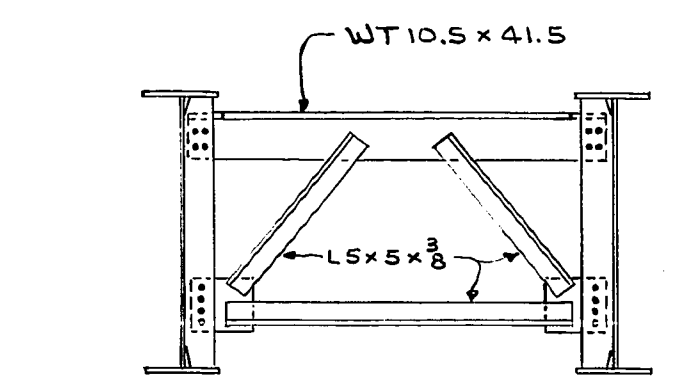
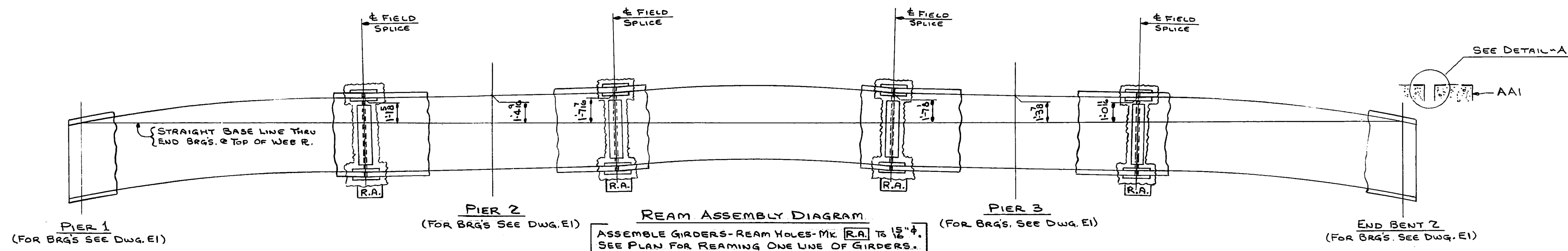
ERECTION NOTE:

No credit will be allowed for work performed by others in replacing or correcting materials or workmanship covered by this drawing unless expressly authorized by High Steel Structures, Inc.

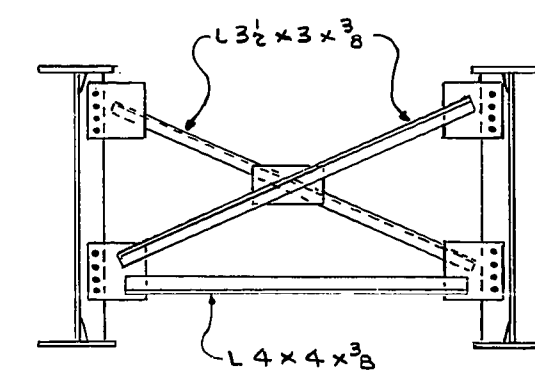
NOTE: HOLES MARKED TO BE SUB-PUNCHED 11/16" AND REAMED TO 15/16" WITH CONNECTING PARTS ASSEMBLED AND MATCH MARKED.

DRAWING No.: 19909
LETTING DATE: 10-19-79

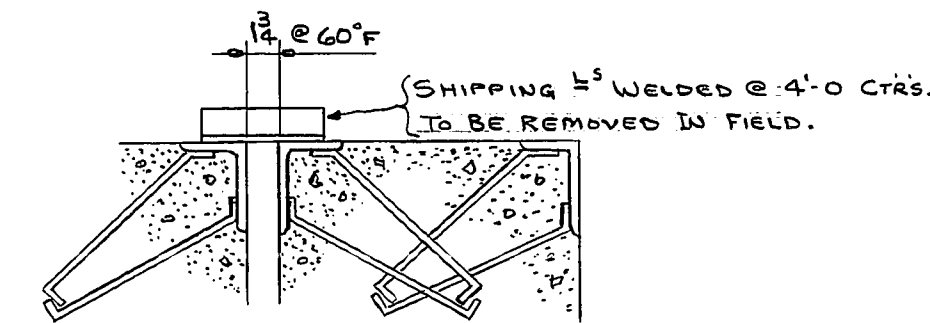
NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
ERECTION PLAN U.S. 60 OVER CLARKS RIVER (E.B.) U.S. 60 STA. 1384+54.55 COMMONWEALTH OF KENTUCKY BUREAU OF HIGHWAYS M ^C CRACKEN COUNTY, KY.		
STATE CONT. SP-73-27-12L CONTRACTOR CRAWFORD CONST. CO., INC. IN CHARGE: SALTZER MADE BY: G.F.Z. CHECKED BY: Kma DATE: 1-9-80		
CONTRACT NO. K-79167 DRAWING NO. E2		



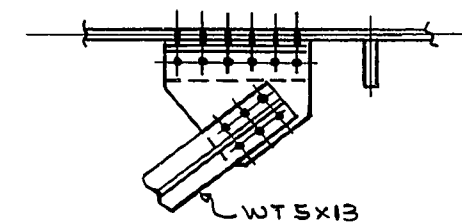
TYP. BAY @ END BENT 1, 2 & PIER 1
(LOOKING TOWARDS CENTER OF SPAN)



TYP. INT. CROSS FRM. @ PIERS 2 & 3
(LOOKING WEST)



DETAIL-A
AS SHOWN FOR END BENT 2
OPP. HAND FOR END BENT 1



TYP. LATERAL BRACING CONN.

SUMMARY OF FIELD BOLTS:

(A325, TYPE 1) HIGH STRENGTH BOLTS w/ HVY. HEX. HD. & A563 GR. C HEAVY HEX. NUT.

- 1,800 - 7/8" x 2 LG. - CONN. FOR INT. CROSS FRMS. & 3/8" L TO 3/8" R. @ LAT. BR. GUSSET PL.
- 1,580 - 7/8" x 2 1/2 LG. - CROSS FRM. CONN. FOR END BENT 1, 2 & PIER 1 & WTS TO 3/8" R. & 3/8" L TO 1/2 WEB. @ LAT. BR. GUSSET PL.
- 1,260 - 7/8" x 2 1/2 LG. - WEB SPLICE CONN.
- 135 - 7/8" x 2 3/4 LG. - CROSS FRM. CONN. PIER 2 & 3
- 295 - 7/8" x 3 1/4 LG. - FLG. SPLICE CONN. @ SPAN 4
- 1,010 - 7/8" x 3 1/2 LG. - FLG. SPLICE CONN. @ SPANS 2 & 3

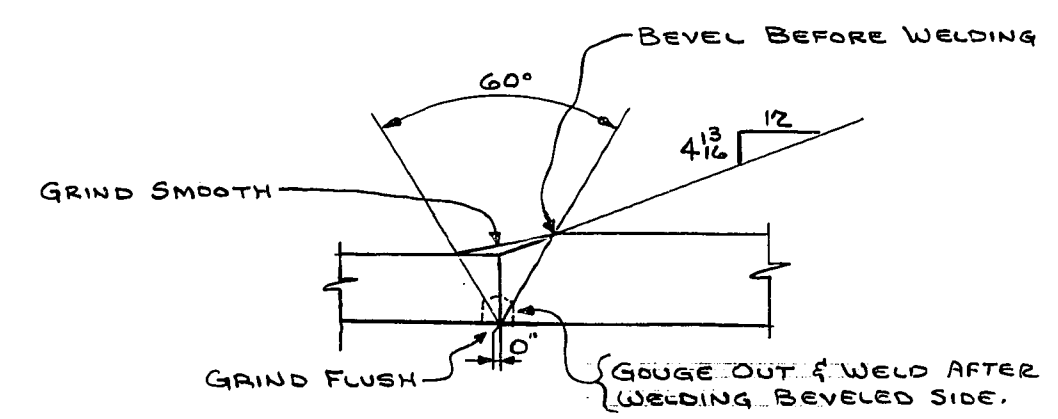
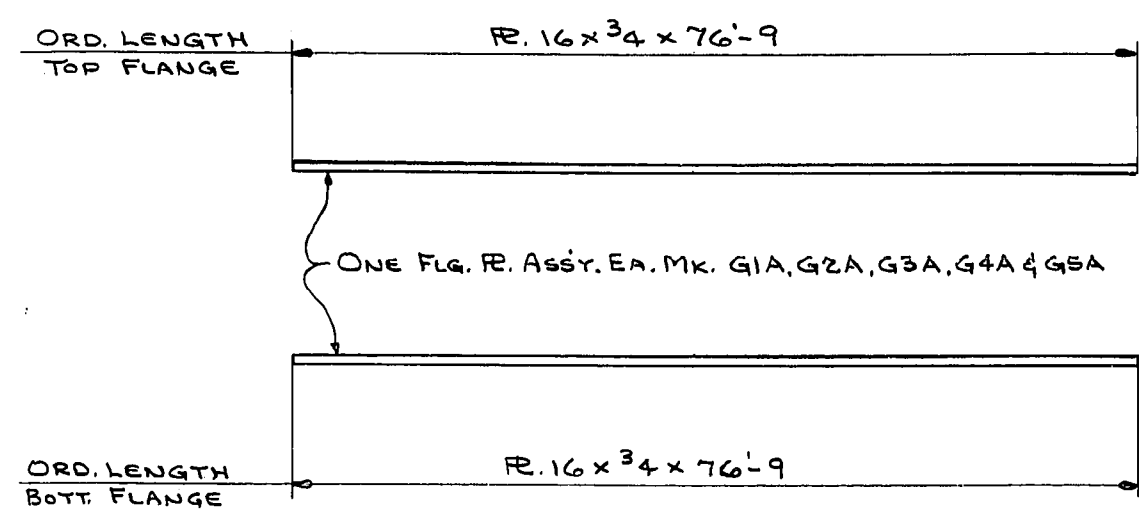
6,080 - HARD, FLAT, ROUND WASHERS (F-436) FOR 7/8" H.S. BOLTS.

NOTES:

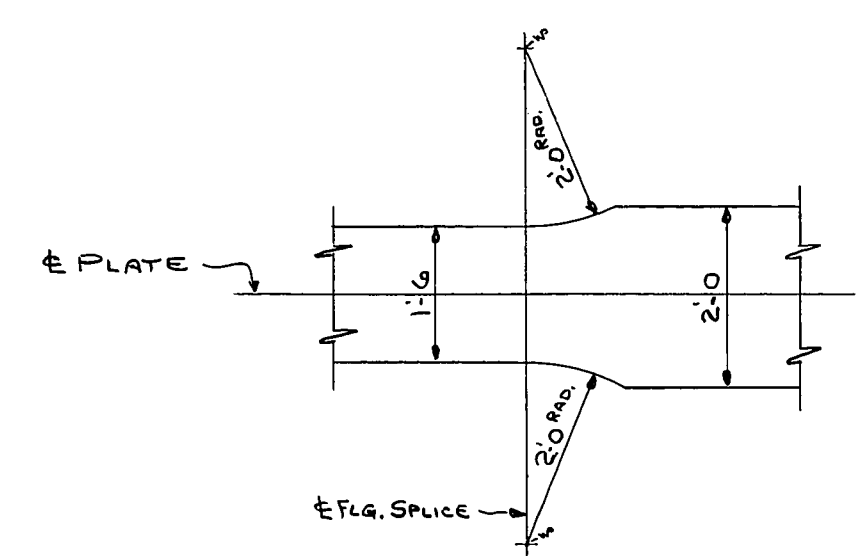
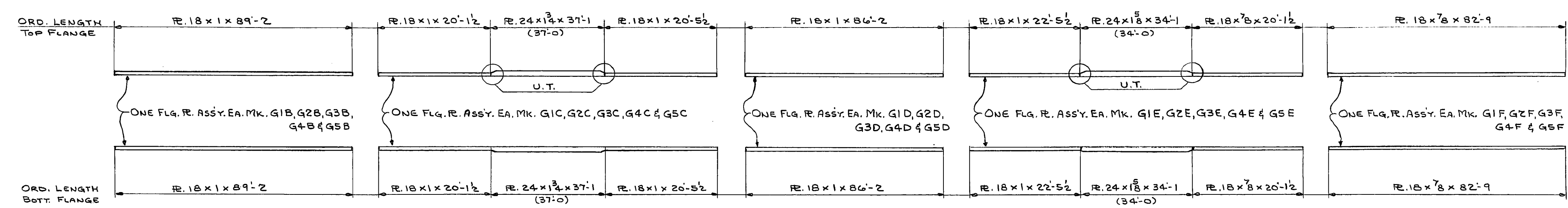
WORK THIS DRAWING WITH DRAWING E2.
FOR NOTES SEE DRAWING E2.
FOR BRGS. @ SPAN -1, SEE DWG. E1.

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
REAR ASSEMBLY DIAGRAM & SECTIONS		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 1384 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, KY.		
STATE CONT. OR REF. NO. <u>SP-73-32-131</u> CONTRACTOR <u>CRAWFORD CONST. CO., INC.</u>		
IN CHARGE: <u>SALTZER</u>		
MADE BY: <u>G.F.Z.</u> CHECKED BY: <u>Kma</u> DATE <u>1-8-80</u>		
CONTRACT NO. <u>K-79167</u> DRAWING NO. <u>E3</u>		

DRAWING No. 19909
LETTING DATE: 10-19-79



TYPICAL FLANGE SPLICE
(B-U2-S MOD.)



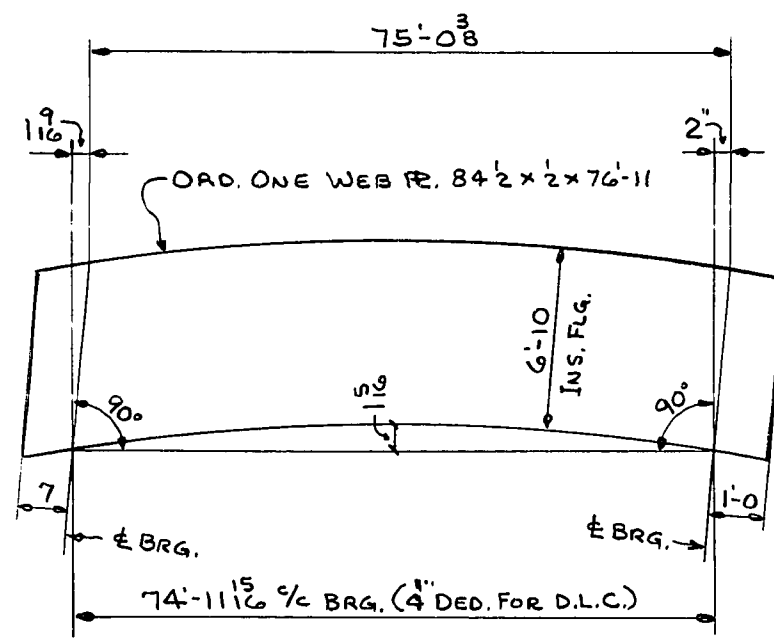
TYPICAL FLANGE PLATE TRANSITION

NOTES:

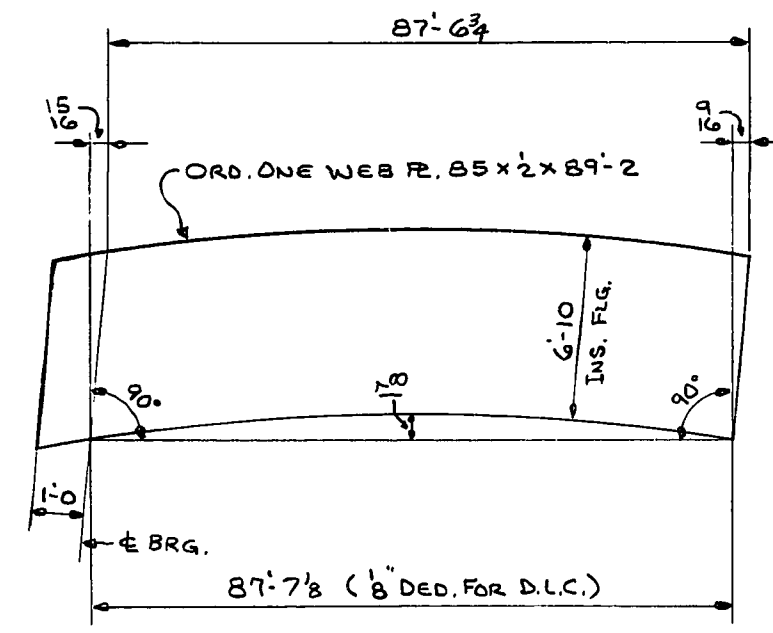
DIMENSIONS SHOWN THUS: (37'-0) ARE THE ACTUAL DIMENSIONS THAT WILL APPEAR ON THE GIRDER DETAIL DRAWINGS.
 ALL MATERIAL TO BE A.S.T.M.-A36 WITH CHARPY V-NOTCH TEST.
 ALL WELDS TO BE MADE BY SUBMERGED ARC PROCESS.
 ULTRASONIC INSPECTION OF FLANGE SPLICES AS NOTED: SPLICES MARKED (U.T.)=100%, ALL OTHERS TEST 25% EA.
 TESTING TO BE DONE BY LAW ENGINEERING TESTING CO. FOR GENERAL NOTES, SEE DRAWING N1.

DRAWING NO.: 19909
 LETTING DATE: 10-19-79
 CODE: 4000

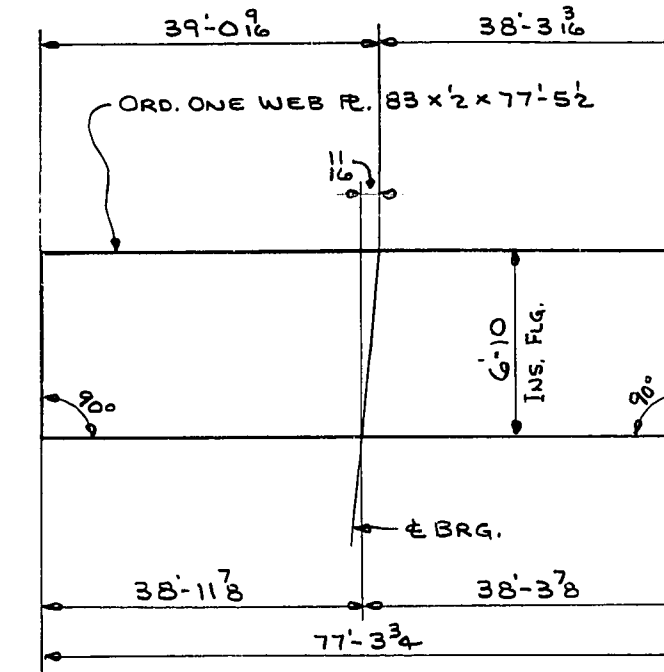
NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
FLANGE SPLICES		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 13R4 +54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MCCracken COUNTY, KY.		
STATE CONT. OR REF. NO. SP73-32-13L	CONTRACTOR CRAWFORD GUST. G. INC.	
IN CHARGE: SALTZER		
MADE BY: G.F.Z.	CHECKED BY: Kua	DATE: 1-8-80
CONTRACT NO. K-79167	DRAWING NO.	FS1



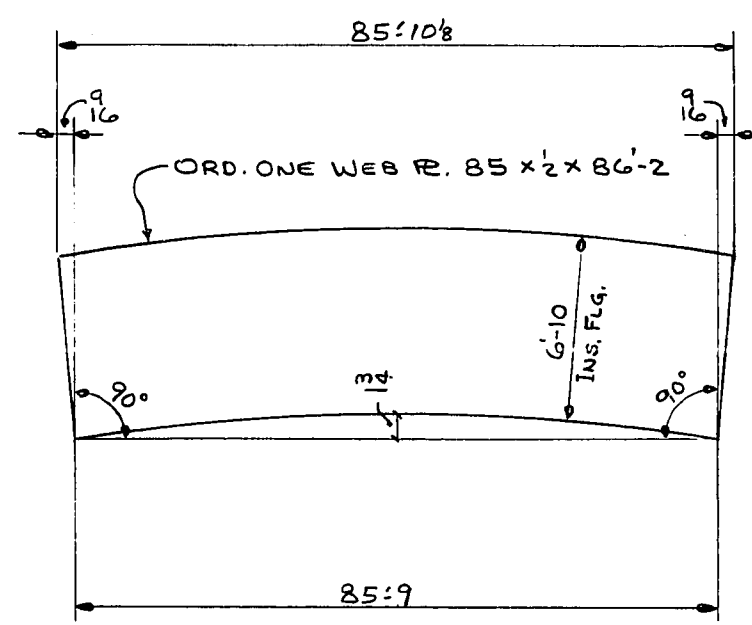
ONE WEB R. EA. MK. G1A, G2A, G3A, G4A & G5A



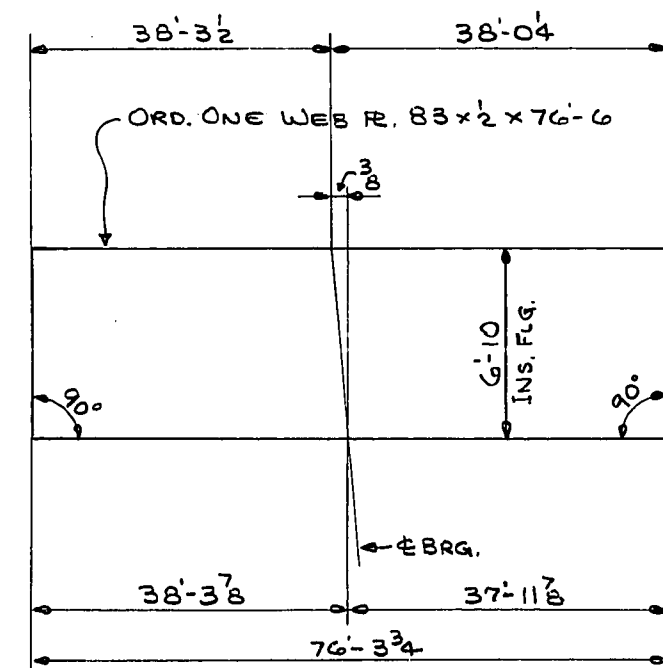
ONE WEB R. EA. MK. G1B, G2B, G3B, G4B & G5B



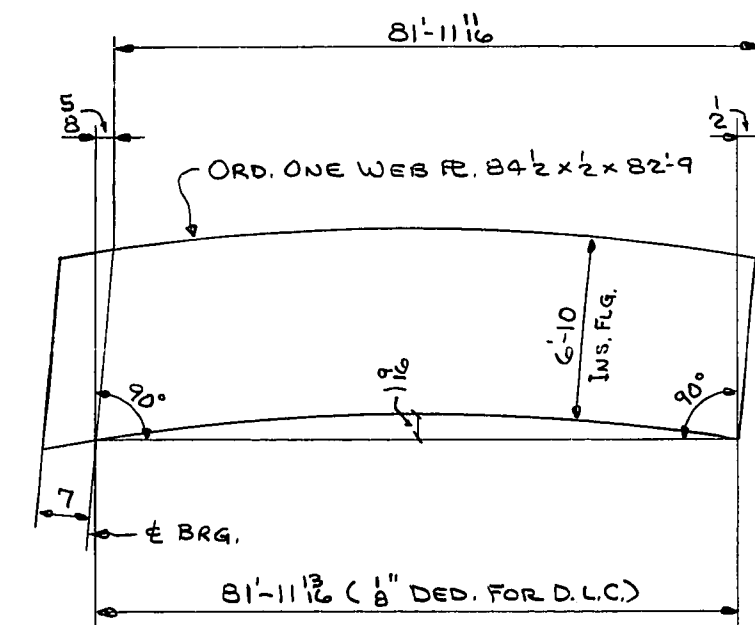
ONE WEB R. EA. MK. G1C, G2C, G3C, G4C & G5C



ONE WEB R. EA. MK. G1D, G2D, G3D, G4D & G5D



ONE WEB R. EA. MK. G1E, G2E, G3E, G4E & G5E



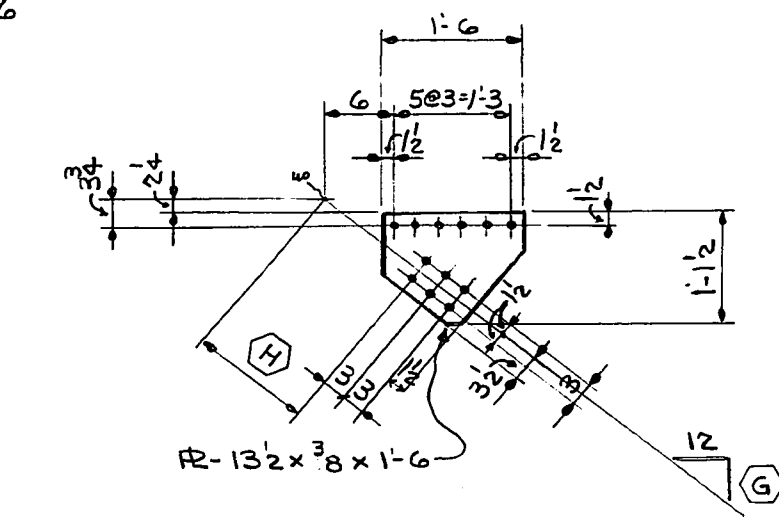
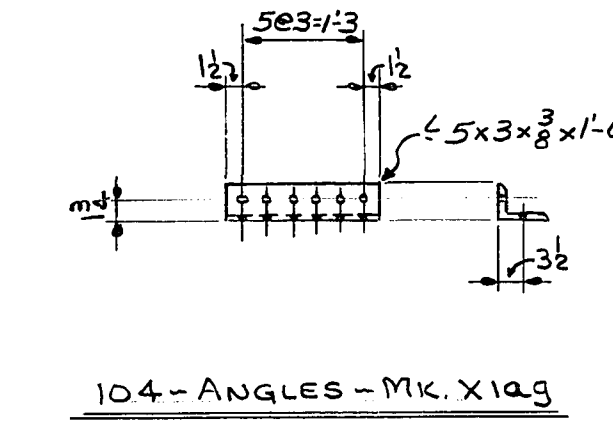
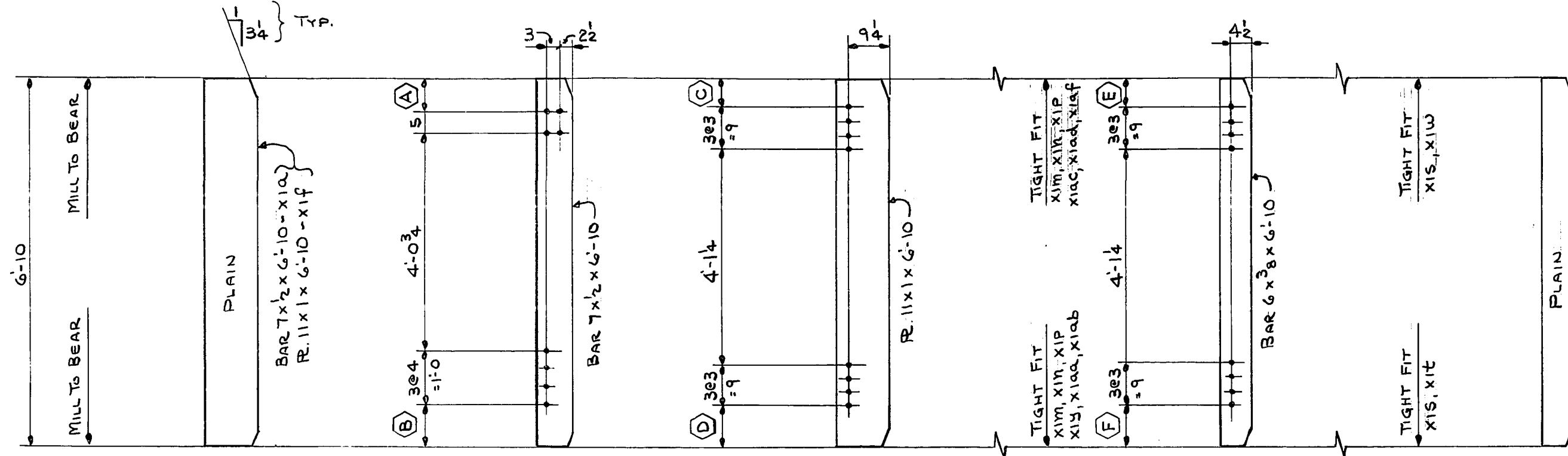
ONE WEB R. EA. MK. G1F, G2F, G3F, G4F & G5F

NOTES:

- MAKE ONE WEB R. ASSEMBLY FOR EACH MARK.
- ALL STEEL TO BE A.S.T.M. A36 WITH CHARPY IMPACT TEST.
- FOR GENERAL NOTES SEE DRAWING N1.

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
CAMBER DIAGRAMS		
U.S. 60 OVER CLARKS RIVER (E.B.)		
U.S. 60 STA. 1384+54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MCCRACKEN COUNTY, KY.		
STATE CONT. OR REF. NO. SP-73-32-13L CONTRACTOR CRAWFORD CONST. CO. INC.		
IN CHARGE: SALTZER		
MADE BY: G.E.Z. CHECKED BY: Kua DATE 1-8-80		
CONTRACT NO. K-79167 DRAWING NO. WCI		

CODE: 4000
DRAWING NO.: 19909
LETTING DATE: 10-19-79



8 - STIFF. RS. - MK. XIA
4 - STIFF. RS. - MK. XIF

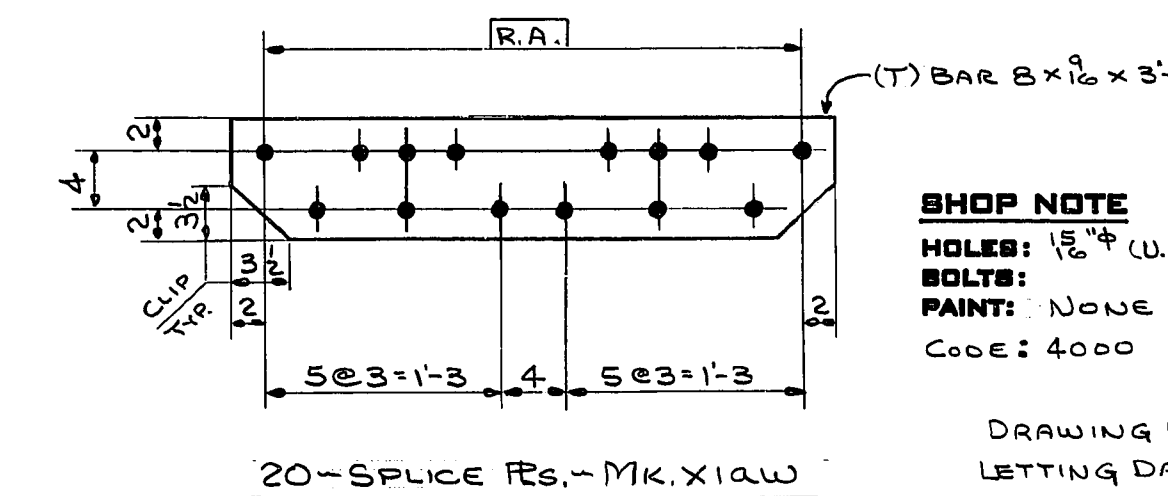
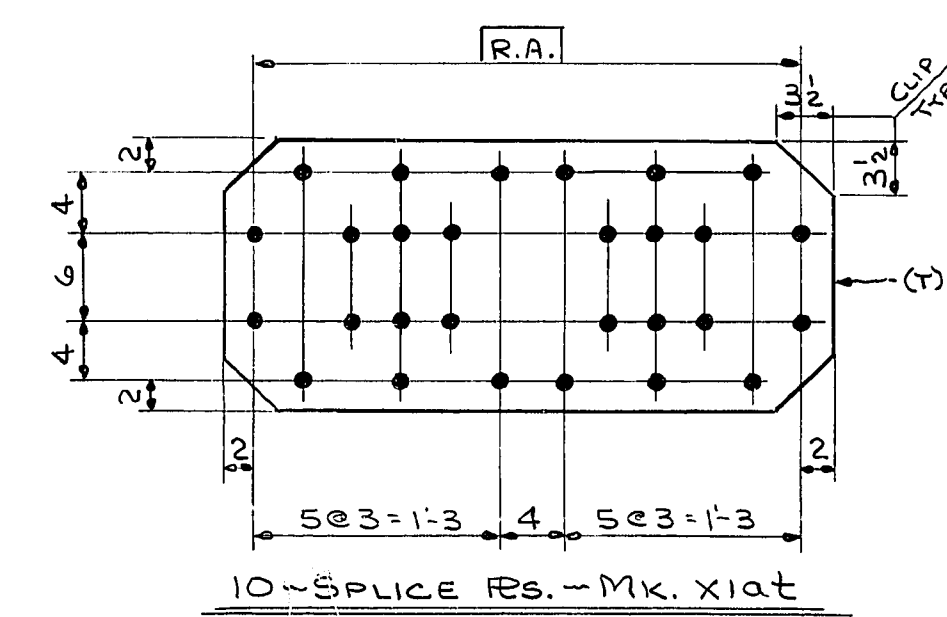
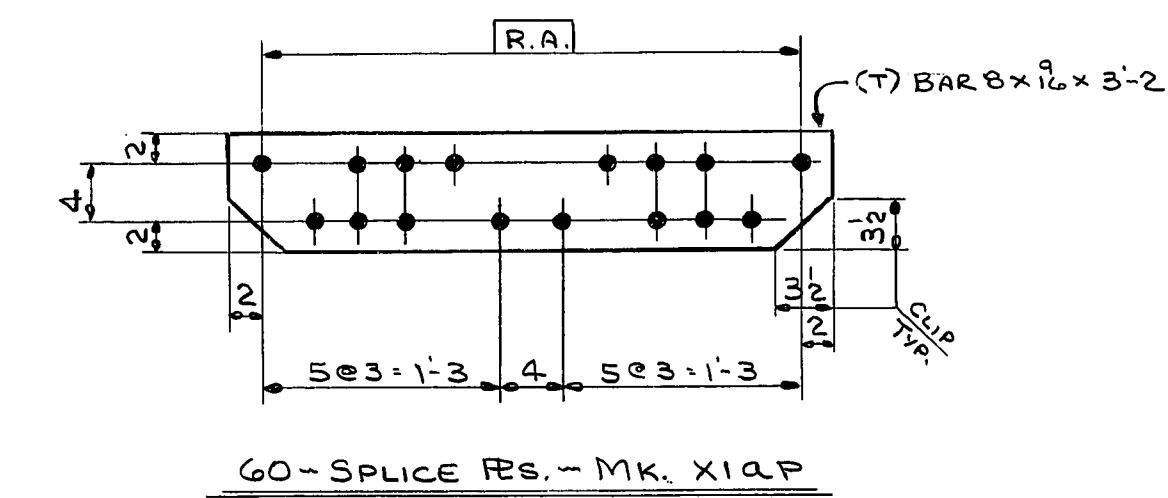
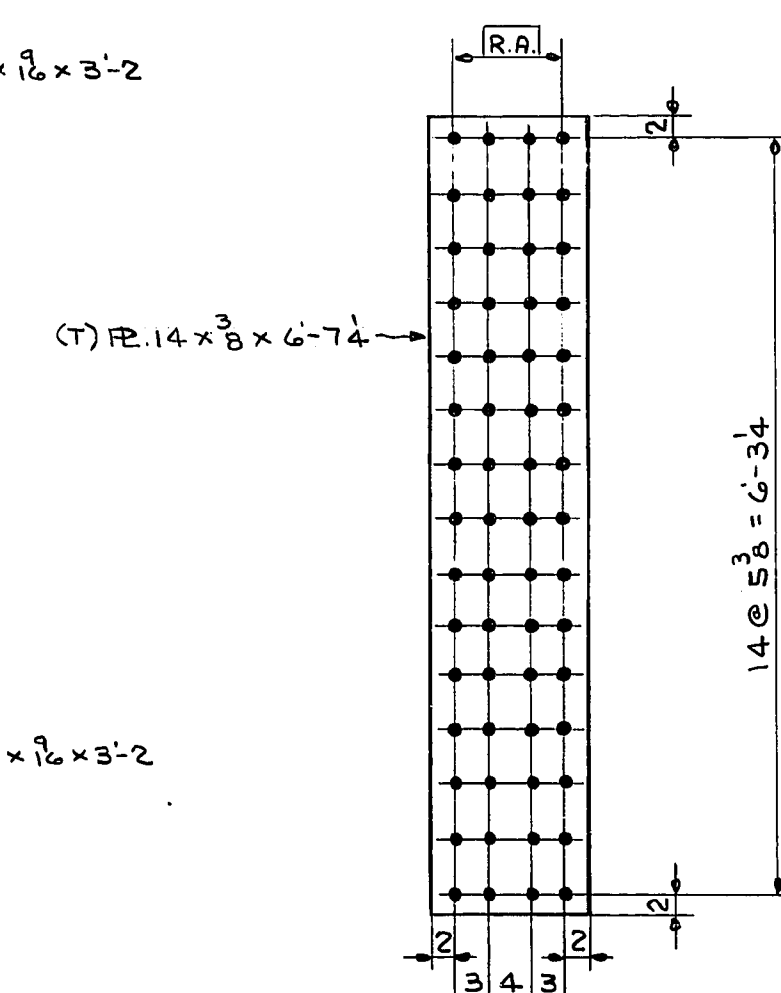
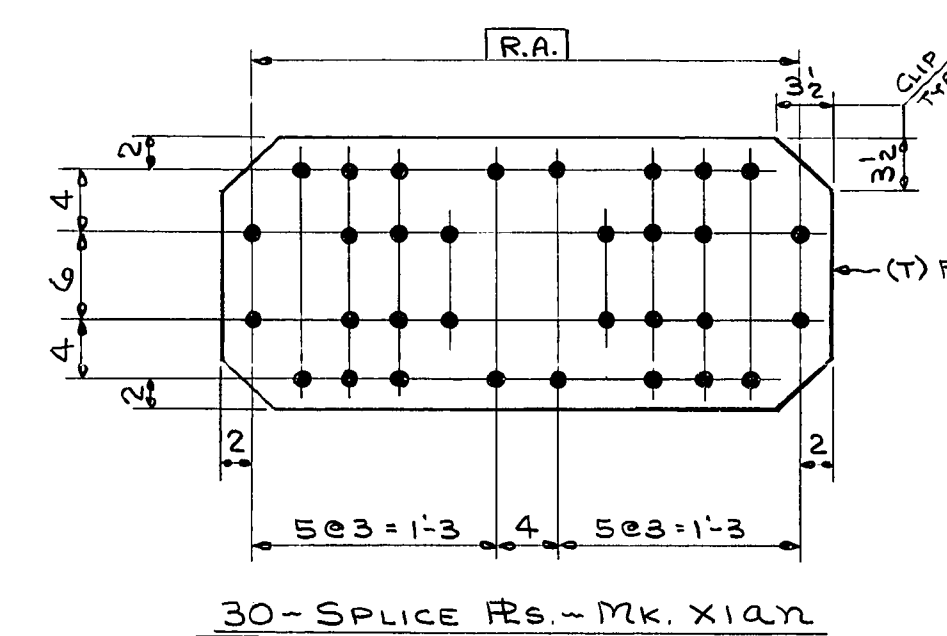
REQ'D.	MK.	(A)	(B)
16	XIB	5	11 1/4
8	XIC	7 1/4	9
8	XID	6 7/8	9 3/8

REQ'D.	MK.	(C)	(D)
8	XI9	3 1/2	11 1/4
4	XIH	5 3/4	9
4	XIK	5 3/8	9 3/8

REQ'D.	MK.	(E)	(F)
16	XIM	3 1/2	11 1/4
8	XIN	5 3/4	9
8	XIP	5 3/8	9 3/8
40	XI3	3 1/2	11 1/4
20	XI22	5 3/4	9
20	XI2B	5 3/8	9 3/8
12	XI2C	3 1/2	11 1/4
6	XI2D	5 3/4	9
6	XI2E	5 3/8	9 3/8

60 - STIFF. RS. - MK. XI5
210 - STIFF. RS. - MK. XI7
65 - STIFF. RS. - MK. XIW

REQ'D.	MK.	(G)	(H)
40	XIAH	10 1/8	1-1 5/8
48	XIAK	9 3/8	1-2 3/8
8	XIAM	8 1/2	1-3
8	XIAY	10 3/8	1-1 1/2



NOTES:

ALL STEEL TO BE A.S.T.M. A36
(T) INDICATES CHARTY IMPACT TEST.
FOR GENERAL NOTES SEE DWG. N1.

NOTE:
HOLES MARKED (H) TO BE SUB-PUNCHED 11/16" AND REAMED TO 15/16" WITH CONNECTING PARTS ASSEMBLED AND MATCH MARKED.

SHOP NOTE
HOLES: 1/8" (U.N.)
BOLTS:
PAINT: NONE
CODE: 4000

DRAWING NO.: 19907
LETTING DATE: 10-19-79

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
JOB STANDARDS U.S. 60 OVER CLARKS RIVER (E.B.) U.S. 60 STA. 1384 + 54.55 COMMONWEALTH OF KENTUCKY BUREAU OF HIGHWAYS MC CRACKEN COUNTY, KY.		
STATE CONT. OR REF. NO. SP-73-32-13L CONTRACTOR CRAWFORD CONST. CO. INC.		IN CHARGE SAUTZER
MADE BY G.F.Z.		CHECKED BY Kuma DATE 1-8-80
CONTRACT NO. K-79167		DRAWING NO. X1

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I. DEFINITIONS
The welding terms used in these procedures are to be interpreted according to the definitions given in Appendix I of A.S.T.M. Structural Welding Code D1.1.

II. PREPARATION OF MEMBERS 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. A-1 specifications.

The attached welding procedures and shop detail drawings shall indicate the proper joint preparation for a welding procedure prepared by the fabricator when he performs a joint. Specific attention not detailed on the design drawings: If the joint configuration is not prequalified, the fabricator will submit to the engineer for approval the welding procedure specification of the joint with qualification test records.

The flange surfaces of the web and flange plates and the adjacent surfaces that are to be fillet welded shall have all mill scale removed prior to assembly and welding of the web to flange joint.

III. ASSEMBLY
Abutting parts to be joined by butt welds shall be cut square and true and aligned accurately within the A.S.T.M. D1.1 tolerances. The cross section of the weld shall not be reduced after grinding. The grinding shall produce a smooth machine-like finish which meets or exceeds a 250 mu on the surface roughness scale (i.e. 125/63/32).

Parts to be joined by fillet welds shall be brought into as close contact as practicable. If the separation is 1/16" or greater, the use of the fillet weld shall be increased by the amount of separation. The maximum separation shall not exceed 3/16".

IV. FIXTURES FOR SUBMERGED ARC WELDING SHALL BE DRY AND FREE OF CONTAMINATION FROM DIRT, MILL SCALE, OR OTHER FOREIGN MATERIAL. FIXTURES IN WELDING SHALL NOT BE REUSED. FLAME WHICH HAS NOT BEEN USED ONLY AFTER PROCESSING THROUGH THE INVERTIBLE VACUUM CORPORATION FLUX CLEANER OR THE OPEN CLEANER ATTACHED TO THE DART MACHINE. FILLER METALS USED SHALL BE AS SPECIFIED ON THE ATTACHED WELD DETAIL SHEETS.

V. PROCEDURES FOR SUBMERGED ARC WELDING WITH A SINGLE ELECTRODE
All submerged arc butt welds shall be made in the flat or horizontal position. Fillet welds may be made in either the flat or horizontal position except that the fillet pass fillet welds made in the horizontal position shall not exceed 5/16 inch.

The thickness of weld layers, except root and surface layers, shall not exceed 1/4 inch. When 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 5/8 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 spaced, generally 1/8 to 3/16 inch, that they do not produce objectionable changes in appearance of the weld surface or result in a decrease 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. Extensions shall be removed upon completion and cooling of the weld and the ends of the welds shall be made smooth and flush with the edges of the abutting 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 melt-through during the initial submerged arc welding pass.

VI. FABRICATING SEQUENCE
Butt welds in flange and web plates shall be completed prior to assembling the girder. Where plates are ordered in multiple widths the welds shall be made before flange splitting. If circumferential is necessary after welding, it shall be done mechanically or by heating. Flange plates up to 1/4 inch thickness may be cupped before being assembled into the girder to compensate for distortion caused by welding.

The web plates shall be trimmed along both edges to correct camber and width, with allowance for shrinkage during welding. After the flange and web butt welds are complete they shall be assembled and tack welded, fitting the flange plates tight and square against the edges of the web. Flange to web fillet welds shall be made using the submerged arc process.

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

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

All necessary camber adjustments will be made, as such as is possible, by proper blocking of the member when welding the flange to web joint.

Any minor camber and/or sweep adjustments will be made by the application of heat, not exceeding 1100 degrees Fahrenheit, by an experienced technician and under careful supervision.

Camber 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 camber needed, the thickness and length of the flange, and the length and weight of the member. Most camber 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.

Torsional stress will be relieved by the application of heat to the two 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 no instance may the metal temperature exceed 1100 degrees Fahrenheit regardless of the type of adjustment to be accomplished.

WELDING PROCEDURE FOR A.S.T.M. PREQUALIFIED JOINTS
W 1
PROCEDURE SPECIFICATION

Material Specification: ASTM A-36, A-572, A-441, A-588
Welding Process: Submerged Arc
Manual or Machine: Machine
Position of Welding: 1F and 2F
Filler Metal Specification: A.S.T.M. A5.17-76
Filler Metal Classification: E70-18
Polarity: DC
Single or Multiple Arc: Single Electrode
Electrical Stick Out: Standard
Root Treatment: Manual Cleaning
Preheat and Interpass Temperature: See attached preheat chart
Open Circuit Voltage: 60

WELDING PROCEDURE

Pass No.	Wire Size	Welding Current, AMPERE VOLTS	Travel IPM	Joint Detail
1	1/8	160	6-9	TACK & REPAIR WELDS
1	5/32	215	8-11	Fillet welds
1	3/16	130	9-15	-
1	7/32	275	9-15	-
1	1/4	315	11-17	-

* Weld size determined by travel speed
* Voltage adjusted for proper bead shape (DC)

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the "Limitation of Variables" given in the American Welding Society Code, A.S.T.M. D1.1.

WELDING PROCEDURE FOR A.S.T.M. PREQUALIFIED JOINTS
W 2
PROCEDURE SPECIFICATION

Material Specification: ASTM A-36, A-572, A-441, A-588
Welding Process: Submerged Arc
Manual or Machine: Machine
Position of Welding: 4F
Filler Metal Specification: A.S.T.M. A5.17-76
Filler Metal Classification: E70-18
Polarity: DC
Single or Multiple Arc: Single Electrode
Electrical Stick Out: Standard
Root Treatment: Manual Cleaning
Preheat and Interpass Temperature: See attached preheat chart
Open Circuit Voltage: 60

WELDING PROCEDURE

Pass No.	Wire Size	Welding Current, AMPERE VOLTS	Travel IPM	Joint Detail
1	1/8	140	6-9	Tack welds
1	5/32	200	8-11	Tack welds

* Remove Mill Scale on Flange to Web Welds

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the "Limitation of Variables" given in the American Welding Society Code, A.S.T.M. D1.1.

WELDING PROCEDURE FOR A.S.T.M. PREQUALIFIED JOINTS
W 5
PROCEDURE SPECIFICATION

Material Specification: ASTM A-36, A-572, A-441, A-588
Welding Process: Submerged Arc
Manual or Machine: Machine
Position of Welding: 1F and 2F
Filler Metal Specification: A.S.T.M. A5.17-76
Filler Metal Classification: E70-18
Polarity: DC
Single or Multiple Arc: Single Electrode
Electrical Stick Out: Standard
Root Treatment: Manual Cleaning
Preheat and Interpass Temperature: See attached preheat chart
Open Circuit Voltage: 60

WELDING PROCEDURE

Pass No.	Wire Size	Welding Current, AMPERE VOLTS	Travel IPM	Joint Detail
1	1/32	400	14	1/4" Fillet
1	1/32	400	14	5/16" Fillet
1	1/32	400	14	3/8" Fillet

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the "Limitation of Variables" given in the American Welding Society Code, A.S.T.M. D1.1.

WELDING PROCEDURE FOR A.S.T.M. PREQUALIFIED JOINTS
W 6
PROCEDURE SPECIFICATION

Material Specification: ASTM A-36, A-572, A-441, A-588
Welding Process: Submerged Arc
Manual or Machine: Machine
Position of Welding: 1F
Filler Metal Specification: A.S.T.M. A5.17-76
Filler Metal Classification: E70-18
Polarity: DC
Single or Multiple Arc: Lincoln 661 Single Electrode
Electrical Stick Out: Standard
Root Treatment: Manual Cleaning
Preheat and Interpass Temperature: See attached preheat chart
Open Circuit Voltage: 60

WELDING PROCEDURE

Pass No.	Wire Size	Welding Current, AMPERE VOLTS	Travel IPM	Joint Detail
1	3/32	400	14	1/4" Fillet
1	3/32	400	14	3/8" Fillet
1	3/32	400	14	1/2" Fillet

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the "Limitation of Variables" given in the American Welding Society Code, A.S.T.M. D1.1.

WELDING PROCEDURE FOR A.S.T.M. PREQUALIFIED JOINTS
W 7
PROCEDURE SPECIFICATION

Material Specification: ASTM A-36, A-572, A-441, A-588
Welding Process: Submerged Arc
Manual or Machine: Machine
Position of Welding: 4F
Filler Metal Specification: A.S.T.M. A5.17-76
Filler Metal Classification: E70-18
Polarity: DC
Single or Multiple Arc: Lincoln 661 Single Electrode
Electrical Stick Out: Standard
Root Treatment: Manual Cleaning
Preheat and Interpass Temperature: See attached preheat chart
Open Circuit Voltage: 60

WELDING PROCEDURE

Pass No.	Wire Size	Welding Current, AMPERE VOLTS	Travel IPM	Joint Detail
1	1/32	400	14	1/4" Fillet
1	1/32	400	14	3/8" Fillet
1	1/32	400	14	1/2" Fillet

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the "Limitation of Variables" given in the American Welding Society Code, A.S.T.M. D1.1.

WELDING PROCEDURE FOR A.S.T.M. PREQUALIFIED JOINTS
W 11
PROCEDURE SPECIFICATION

Material Specification: ASTM A-36, A-588
Welding Process: Submerged Arc
Manual or Machine: Machine
Position of Welding: 1F
Filler Metal Specification: A.S.T.M. A5.17-76
Filler Metal Classification: E70-18
Polarity: DC
Single or Multiple Arc: Lincoln 661 Single Electrode
Electrical Stick Out: Standard
Root Treatment: Manual Cleaning
Preheat and Interpass Temperature: See attached preheat chart
Open Circuit Voltage: 60

WELDING PROCEDURE

Pass No.	Wire Size	Welding Current, AMPERE VOLTS	Travel IPM	Joint Detail
All	3/32	400	14	18

This procedure may vary from procedure qualification records attached, due to fabrication sequence, fit-up, pass size, etc. within the "Limitation of Variables" given in the American Welding Society Code, A.S.T.M. D1.1.

MINIMUM PREHEAT AND INTERPASS TEMPERATURE

Thickness of thickest part of metal at weld	ASTM A5.17-76, E70-18, and E70-18
Welding - Shielded Metal Arc	30° F
Welding - Submerged Arc	30° F
Over 1/4 to 1-1/2, incl.	100° F
Over 1-1/2 to 2-1/2, incl.	150° F
Over 2-1/2	225° F

1. Welding shall not be done when the ambient temperature is lower than 32° F. When the base metal is within the temperature listed on the welding procedure, the thickness of material to be welded shall not exceed the thickness of material in each member that the surface of the parts on which weld metal is being deposited are at or above the specified minimum temperature for a distance equal to the thickness of the part being welded, not less than 1 inch, both laterally and in advance of the welding. Preheat and interpass temperatures shall be sufficient to prevent crack formation. Temperature above the specified minimum shall be maintained until the metal has cooled to at least 10° F and maintain this minimum temperature during welding.

2. Only low hydrogen electrodes shall be used for welding A5.17-76 steel more than 1 inch thick.

WELDING PROCEDURE FOR A.S.T.M. PREQUALIFIED JOINTS
W 15
PROCEDURE SPECIFICATION

Material Specification: ASTM A-36, A-572, A-441, A-588
Welding Process: Submerged Arc
Manual or Machine: Machine
Position of Welding: 1F
Filler Metal Specification: A.S.T.M. A5.17-76
Filler Metal Classification: E70-18
Polarity: DC
Single or Multiple Arc: Lincoln 661, Twin wire spaced 5/16
Electrical Stick Out: Standard
Root Treatment: Manual Cleaning
Preheat and Interpass Temperature: See attached preheat chart
Open Circuit Voltage: 60

WELDING PROCEDURE

Pass No.	Wire Size	Welding Current, AMPERE VOLTS	Travel IPM	Joint Detail
1	3/32	875	21	5/16" Fillet
1	3/32	925	22	3/8" Fillet
1	3/32	975	24	1/2" Fillet

This procedure may vary due to fabrication sequence, fit-up, pass size, etc. within the "Limitation of Variables" given in the American Welding Society Code, A.S.T.M. D1.1.

* Remove all mill scale for flange to web welds.

NO.	REVISION	DATE
WELDING PROCEDURE		
W.S.P. 1000-1000-1000 M. 1000-1000-1000		
STATE CONTRACT OR REF. NO.	CONTRACTOR	
IN CHARGE	MADE BY	CHKD BY
CONTRACT NUMBER	DRAWING NUMBER	DATE

GENERAL NOTES

MATERIALS

1. ALL STEEL TO BE A.S.T.M. A36-75 (UNLESS NOTED).
2. LEAD PLATES TO BE A.S.T.M. B29-55 (1971).
3. ALL WEB, FLANGE AND SPLICE PLATE MATERIAL TO BE A.S.T.M. A36-75 WITH CHАРRY V-NOTCH TEST AS PER SPEC'S.
4. STEEL TO RECEIVE CHАРRY V-NOTCH TEST SHALL BE NOTED THUS: (T) ON SHOP DWGS.

PAINTING

1. ALL STEEL TO BE BLAST CLEANED AS PER SSPC-SPI0 FOR NEAR WHITE BLAST CLEANING IMMEDIATELY PRIOR TO PAINTING.
2. PAINT: ONE SHOP COAT FED. SPEC. TTP-615d TYPE II (AASHTO M-229 TYPE II) 1.5 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 FS.
3. FOR WEB CAMBER DETAILS SEE DRAWING PREFIXED WC.
4. ⊗ DENOTES THICKER EDGE OF SOLE PLATE.

WELDING

1. ALL WELDS TO BE MADE BY SUBMERGED ARC PROCESS.
2. FLANGE PLATE SPLICES ARE TO BE INSPECTED BY LAW ENGINEERING TESTING CO.
3. ALL FLANGE 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. TENSION FLANGE SPLICES - TEST 100%
 - b. COMPRESSION FLANGE SPLICES - TEST 85%
6. SPECIFICATIONS: AWS D11-75 WITH 1-76 & 2-77 REVISIONS AASHTO 1974 STANDARD SPECIFICATIONS FOR WELDING AND SPECIAL PROVISIONS A & B (76) SHALL SUPERSEDE THE AWS SPECIFICATIONS.
7. MAGNETIC PARTICLE INSPECTION IN ACCORDANCE WITH SP 48 (76) - AASHTO 1977 STD. SPEC. FOR WELDING.

REAMING

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

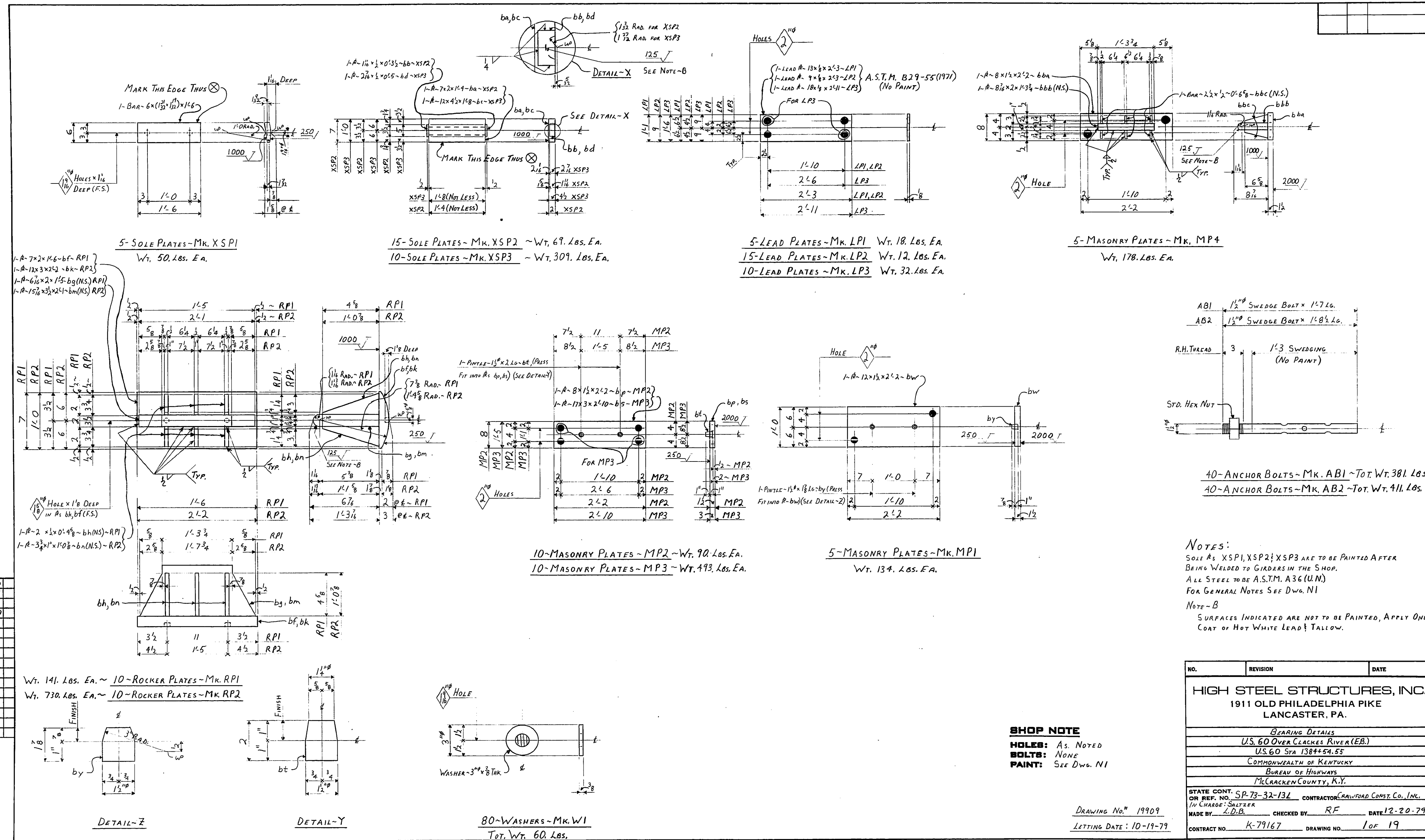
RA: SUB-PUNCH $\frac{1}{16}$ " AND REAM TO $\frac{1}{16}$ " ($\frac{3}{4}$ " MAX. THICKNESS) OR SUB-DRILL

GENERAL

1. ALL RE-ENTRANT CUTS TO HAVE A 1" RADIUS (MIN).
2. SHOP INSPECTION BY LAW ENGINEERING TESTING CO.
3. SPECIFICATIONS: KENTUCKY STANDARD SPECIFICATIONS FOR ROAD AND BRIDGE CONSTRUCTION, CURRENT EDITION (1979)

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
<u>GENERAL NOTES</u>		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA 1384+54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MCCRACKEN COUNTY, KENTUCKY		
STATE CONT OR REP. NO	SP-73-32-13L	CONTRACTOR
IN CHARGE	SALTZER	CRAWFORD CONST. CO., INC.
MADE BY	L.D.B.	CHECKED BY
		RF
		DATE
		12-18-77
CONTRACT NO.	K-79167	DRAWING NO.
		NI

DRAWING No. 19109
LETTING DATE: 10/19/79



5-SOLE PLATES-Mk. XSP1
Wt. 50. LBS. EA.

15-SOLE PLATES-Mk. XSP2 ~ Wt. 69. LBS. EA.
10-SOLE PLATES-Mk. XSP3 ~ Wt. 301. LBS. EA.

5-LEAD PLATES-Mk. LPI Wt. 18. LBS. EA.
15-LEAD PLATES-Mk. LP2 Wt. 12. LBS. EA.
10-LEAD PLATES-Mk. LP3 Wt. 32. LBS. EA.

5-MASONRY PLATES-Mk. MP4
Wt. 178. LBS. EA.

10-MASONRY PLATES-Mk. MP2 ~ Wt. 90. LBS. EA.
10-MASONRY PLATES-Mk. MP3 ~ Wt. 493. LBS. EA.

5-MASONRY PLATES-Mk. MP1
Wt. 134. LBS. EA.

Wt. 141. LBS. EA. ~ 10-ROCKER PLATES-Mk. RPI
Wt. 730. LBS. EA. ~ 10-ROCKER PLATES-Mk. RP2

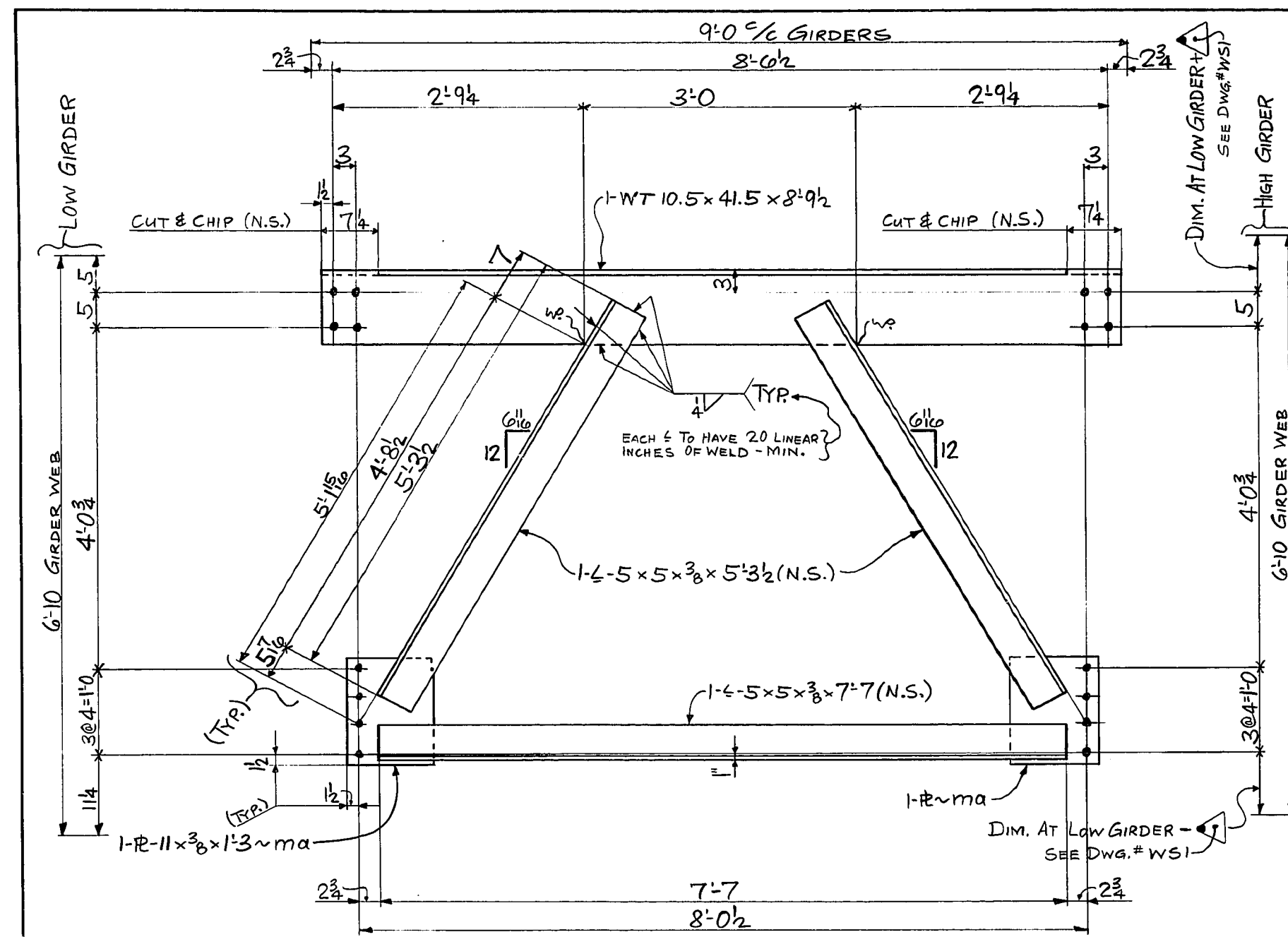
80-WASHERS-Mk. W1
Tot. Wt. 60. LBS.

NOTES:
SOLE AS XSP1, XSP2, XSP3 ARE TO BE PAINTED AFTER BEING WELDED TO GIRDERS IN THE SHOP.
ALL STEEL TO BE A.S.T.M. A36 (U.N.)
FOR GENERAL NOTES SEE DWG. N1
NOTE-B
SURFACES INDICATED ARE NOT TO BE PAINTED, APPLY ONE COAT OF HOT WHITE LEAD & TALLOW.

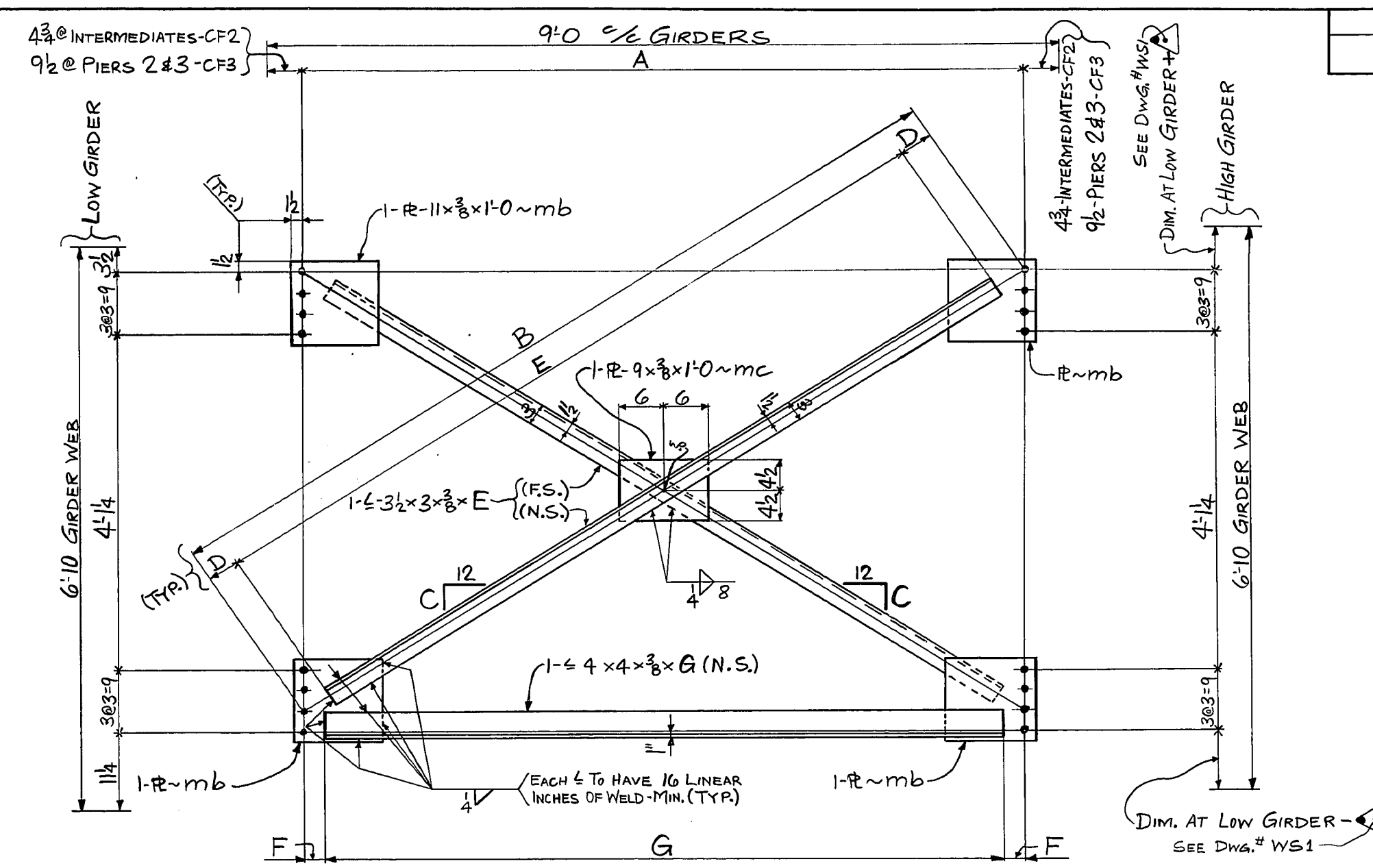
SHOP NOTE
HOLES: AS NOTED
BOLTS: NONE
PAINT: SEE DWG. N1

DRAWING No. 19909
LETTING DATE: 10-19-79

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
BEARING DETAILS		
U.S. 60 OVER CLEVELAND RIVER (E.B.)		
U.S. 60 SPA 1384+54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
McCRACKEN COUNTY, KY.		
STATE CONT. OR REF. NO.	SP-73-32-131	CONTRACTOR CRANFORD CONST. CO., INC.
IN CHARGE: SOLTZER	MADE BY: L.D.B.	CHECKED BY: RF
		DATE: 12-20-79
CONTRACT NO. K-79167	DRAWING NO. 1 OF 19	



16- CROSS FRAMES - MK. CF1
Wt. 1,008. Lbs. Ea.



No.	REQ'D	MARK	A	B	C	D	E	F	G	Wt.
68	CF2	8'-2 1/2	9'-9 3/8	7'-8 1/8	4'-10 1/8	9'-0	2'-3 1/2	7'-1 9/16		Wt. 286. Lbs. Ea.
8	CF3	7'-5	9'-1 3/4	8'-10 1/8	4'-8 1/8	8'-4	3	6'-11		Wt. 267. Lbs. Ea.

Member	Dimensions	Weight	Quantity	Total Weight
LB1	11'-7 1/2	WT 5 x 13 x 11'-10 1/2	20 - REQ'D	~ Wt. 154. Lbs. Ea.
LB2	12'-3	WT 5 x 13 x 12'-6	24 - REQ'D	~ Wt. 163. Lbs. Ea.
LB3	12'-8 3/8	WT 5 x 13 x 12'-11 1/8	4 - REQ'D	~ Wt. 170. Lbs. Ea.
LB4	11'-5 1/2	WT 5 x 13 x 11'-8 3/4	4 - REQ'D	~ Wt. 153. Lbs. Ea.

ALL RE-ENTRANT CUTS TO HAVE 1" MIN. RAD.

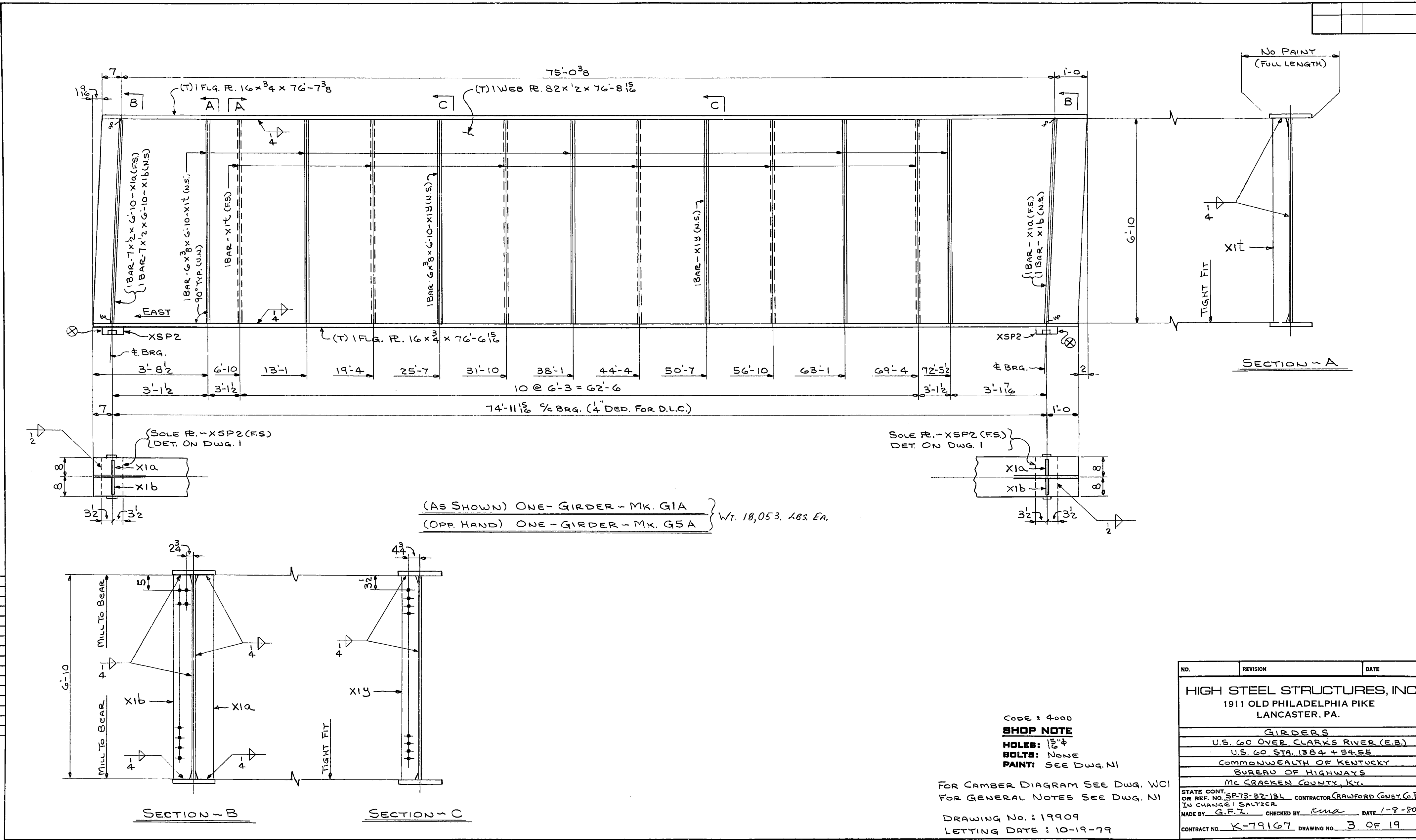
FOR GENERAL NOTES SEE DWG. # N1

SHOP NOTE
HOLES: 5/16"
BOLTS: NONE
PAINT: SEE DWG. # N1

CROSS FRAME - CODE: 5300
 LATERAL BRACING - CODE: 5500

DRAWING No.: 19909
 LETTING DATE: 10-19-79

No.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
CROSS FRAMES & LATERAL BRACING		
U.S. 60 OVER CLARK'S RIVER (E. B.)		
U.S. 60 STA. 1384 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
M ^c CRACKEN COUNTY, KY.		
STATE CONT. P. 73-32-13L	CONTRACTOR	CRANFORD CONST. CO., INC.
OR REF. NO. 10	IN CHARGE	SALTZER
MADE BY	D. D. G.	CHECKED BY
		RF
		DATE
		12-11-79
CONTRACT NO.	K-79167	DRAWING NO.
		2 OF 19



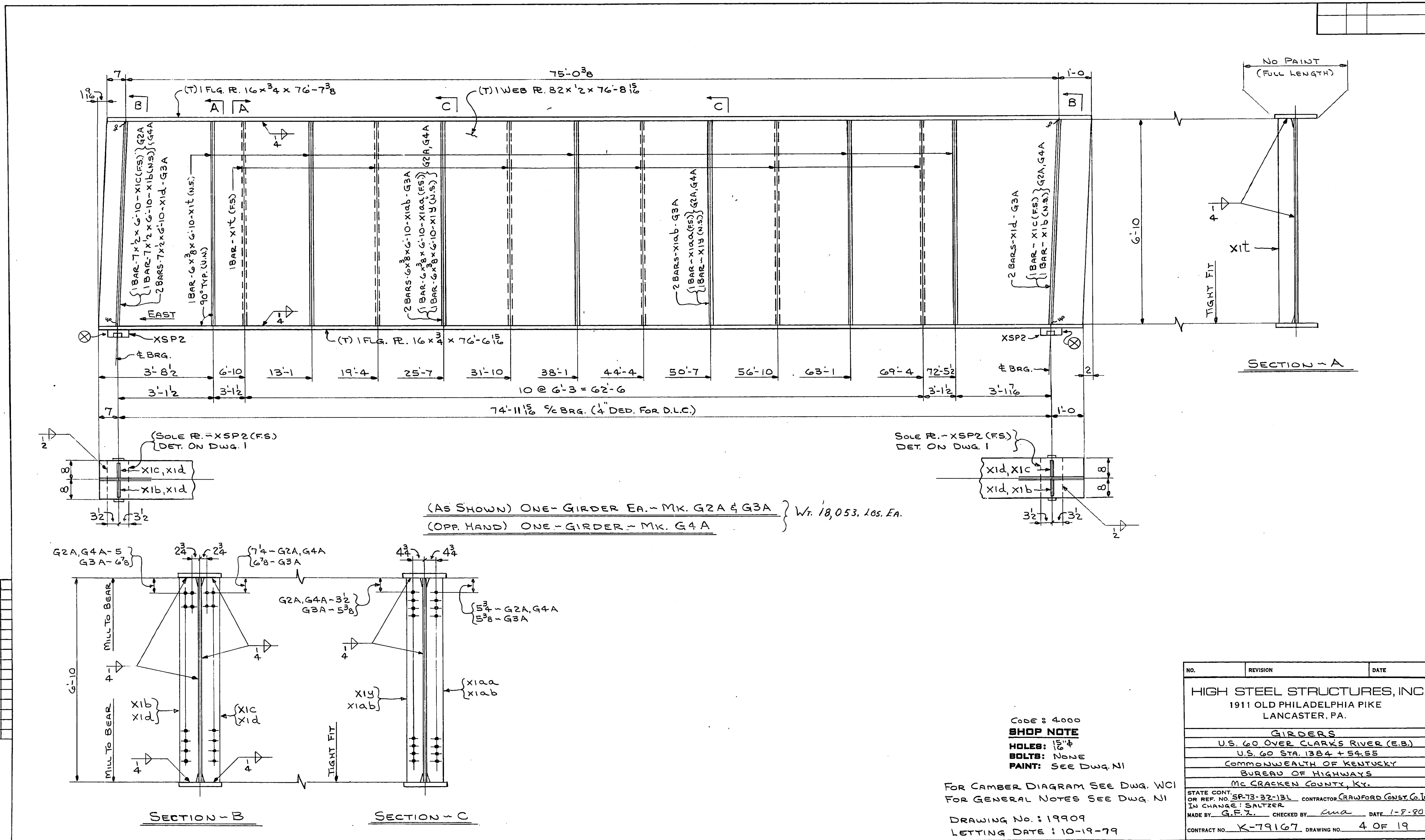
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92	X92
93	X93
94	X94
95	X95
96	X96
97	X97
98	X98
99	X99
100	X100

(AS SHOWN) ONE GIRDER - MK. G1A
 (OPP. HAND) ONE GIRDER - MK. G5A } Wt. 18,053 LBS. EA.

Code 4 4000
SHOP NOTE
 HOLES: 1/2" φ
 BOLTS: NONE
 PAINT: SEE DWG. N1

FOR CAMBER DIAGRAM SEE DWG. WCI
 FOR GENERAL NOTES SEE DWG. N1
 DRAWING No.: 19909
 LETTING DATE: 10-19-79

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDERS		
U.S. 60 OVER CLARKS RIVER (E.B.)		
U.S. 60 STA. 1384 + 84.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
Mc CRACKEN COUNTY, KY.		
STATE CONT.	SR-73-32-13L	CONTRACTOR CRAWFORD CONST. CO. INC.
OR REF. NO.		
IN CHARGE:	SALTZER	
MADE BY:	G.F.Z.	CHECKED BY: <i>ema</i> DATE: 1-9-80
CONTRACT NO.	K-79167	DRAWING NO. 3 OF 19

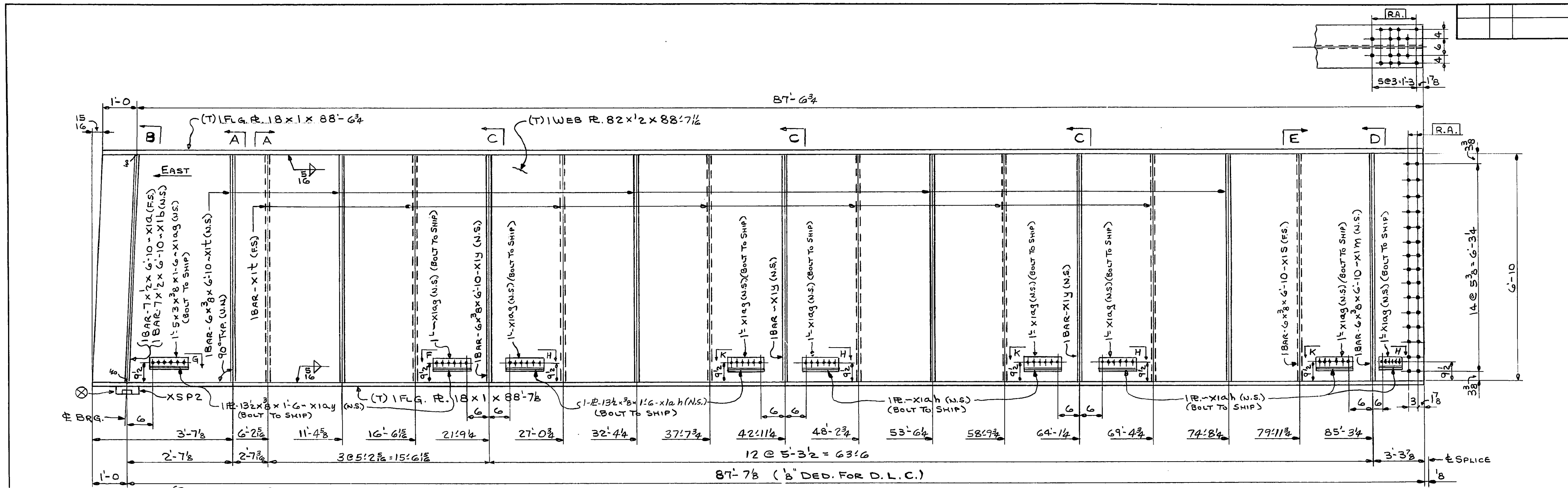


a	x1	1/2
b	4	4
c	4	4
d	4	4
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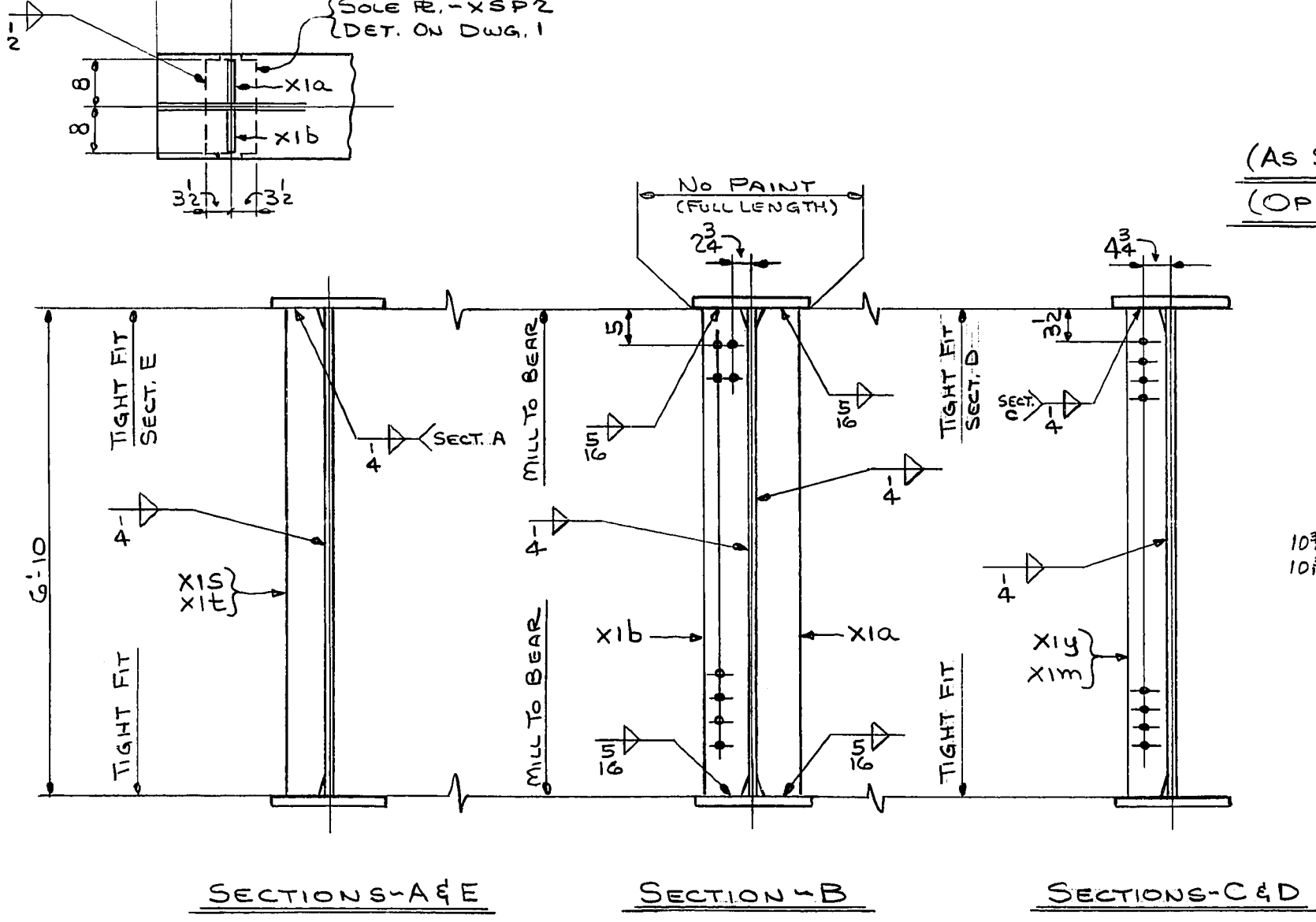
CODE 3 4000
BHOP NOTE
 HOLES: 1 1/2" φ
 BOLTS: NONE
 PAINT: SEE DWG. N1

FOR CAMBER DIAGRAM SEE DWG. WCI
 FOR GENERAL NOTES SEE DWG. N1
 DRAWING No. : 19909
 LETTING DATE : 10-19-79

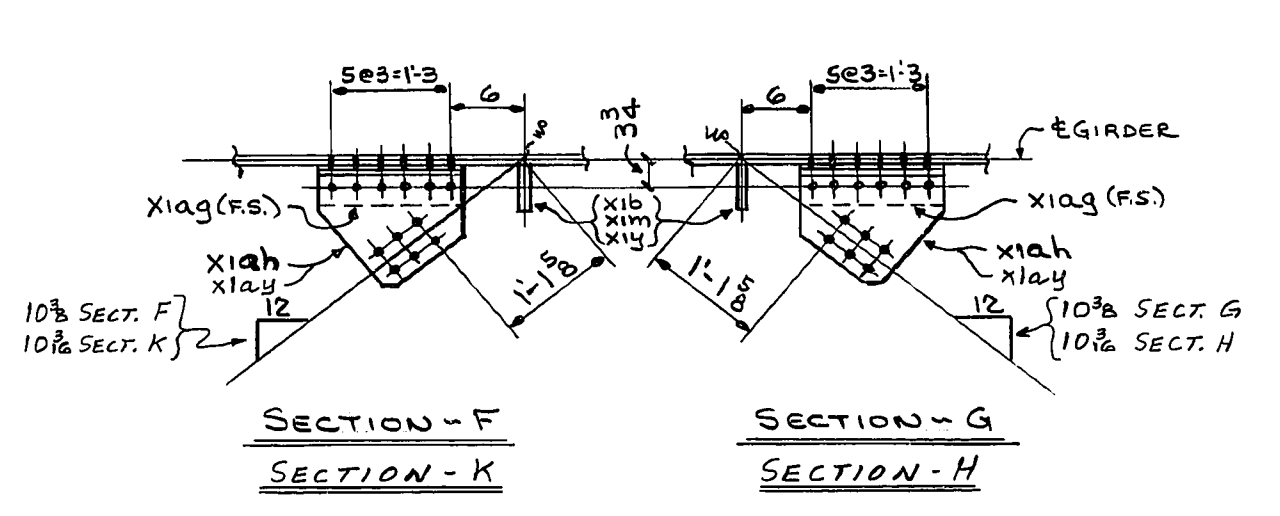
NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDERS		
U.S. 60 OVER CLARYS RIVER (E.B.)		
U.S. 60 STA. 1384 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, KY.		
STATE CONT. OR REF. NO. SP-73-32-131 CONTRACTOR CRAWFORD CONST. CO. INC.		
IN CHARGE: SALTZER		
MADE BY: G.F.Z. CHECKED BY: <i>ama</i> DATE: 1-8-80		
CONTRACT NO. K-79167 DRAWING NO. 4 OF 19		



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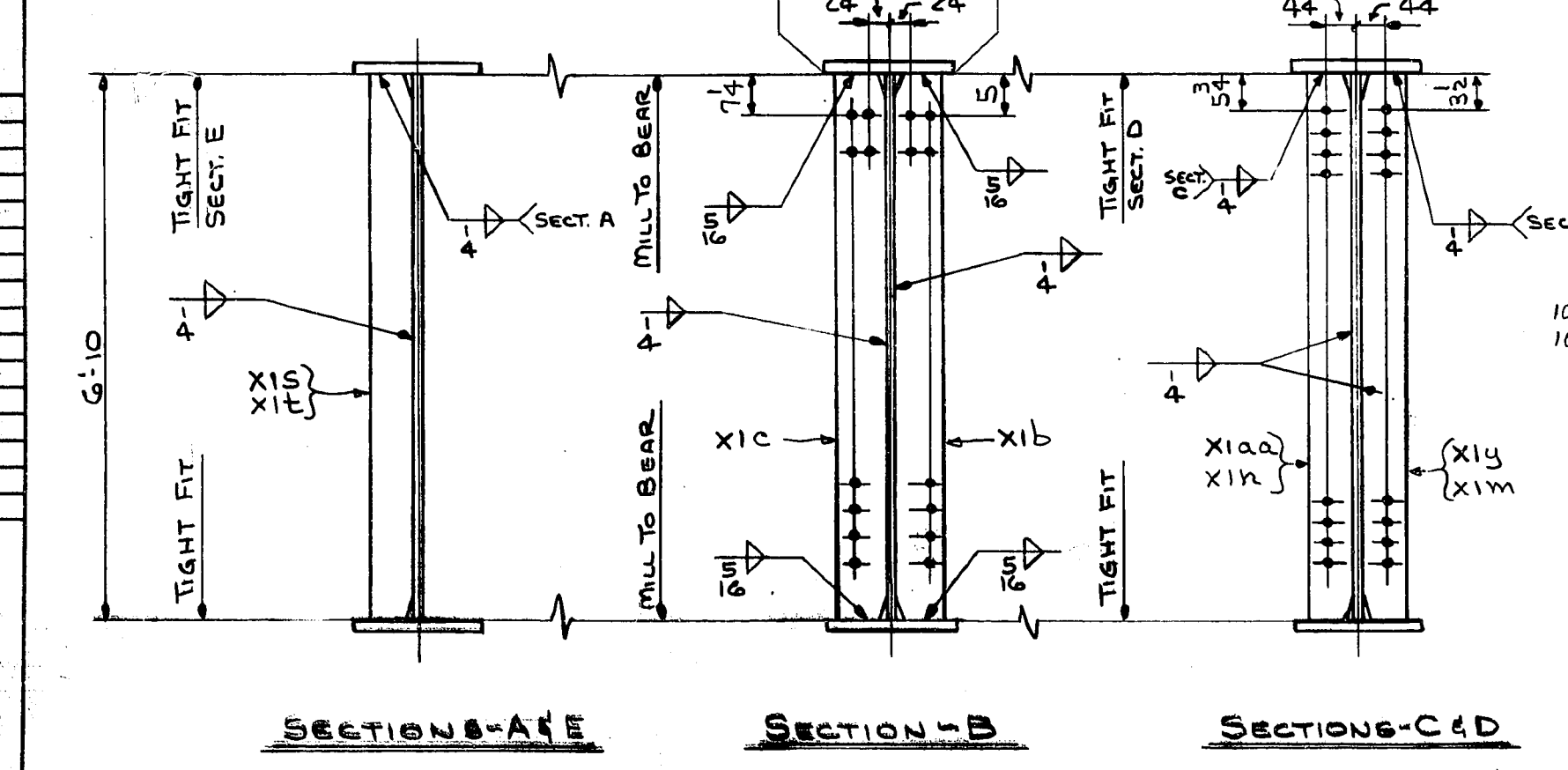
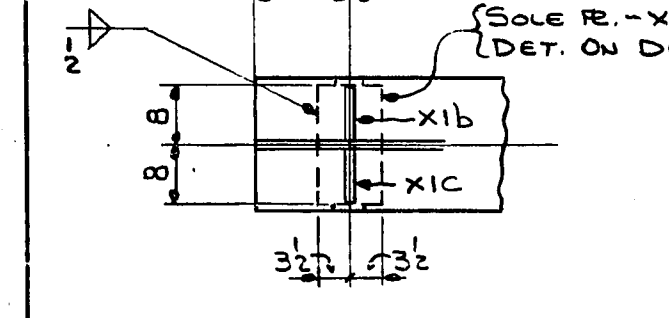
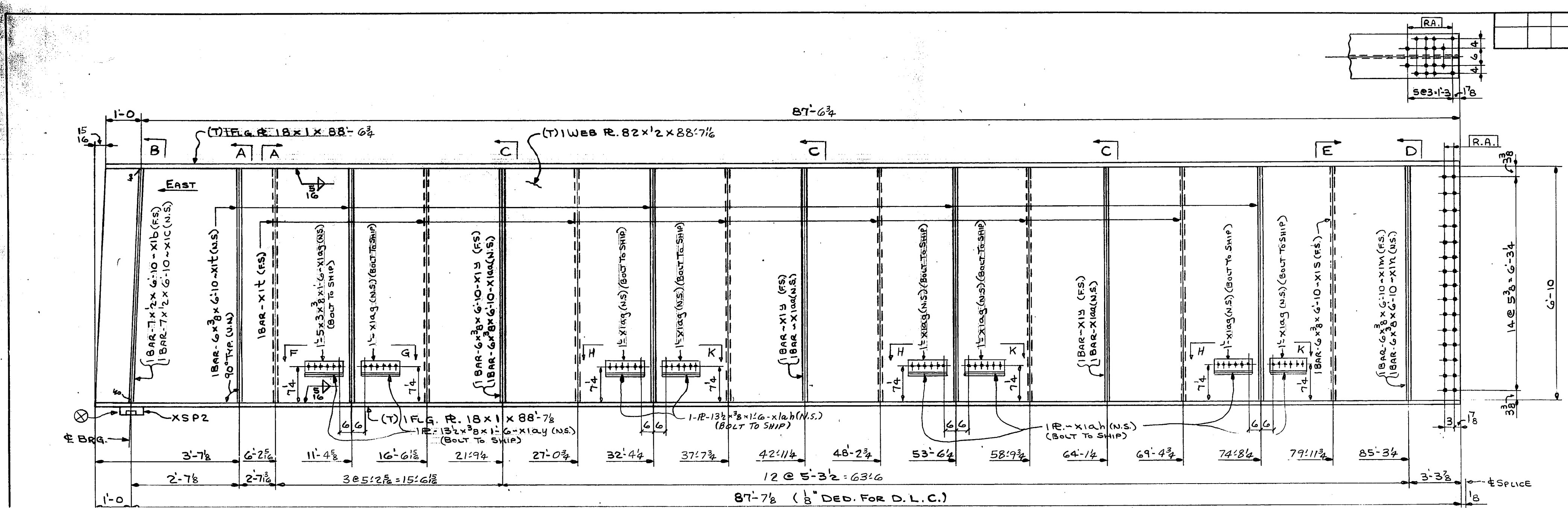


(AS SHOWN) ONE GIRDER - MK. GIB } Wt. 2,747. LBS. EA.
 (OPP HAND) ONE GIRDER - MK. GE

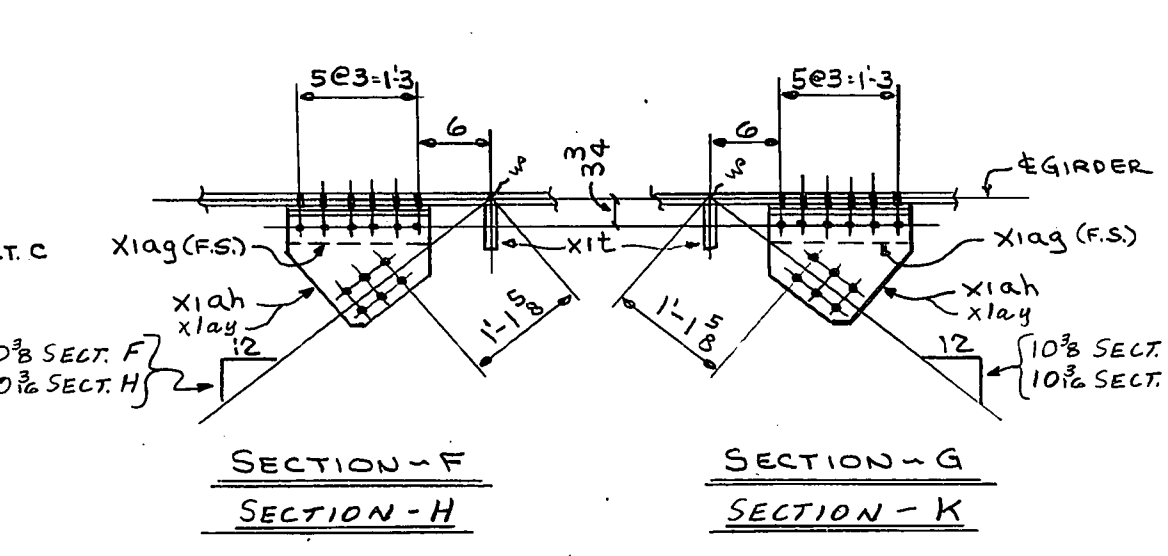


Code: 4000
SHOP NOTE
 HOLES: 1/2\" (U.N.)
 BOLTS: NONE
 PAINT: SEE DWG. N1.
 FOR CAMBER DIAGRAM SEE DWG. WCI
 FOR GENERAL NOTES SEE DWG. N1
 DRAWING No. : 19909
 LETTING DATE : 10-19-79

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC.		
1911 OLD PHILADELPHIA PIKE		
LANCASTER, PA.		
GIRDERS		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 1324 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
Mc CRACKEN COUNTY, KY.		
STATE CONT.	CONTRACTOR	DATE
OR REF. NO. SP-73-32-13L	CRAWFORD CONST. CO. INC.	1-9-80
IN CHARGE: SALTZER		
MADE BY: G.F.Z.	CHECKED BY: Kua	
CONTRACT NO. K-79167	DRAWING NO.	5 OF 19



(AS SHOWN) ONE GIRDER - MK. G4B } WT. 29,864 LBS. EA.
 (OPP. HAND) ONE GIRDER - MK. G2B }

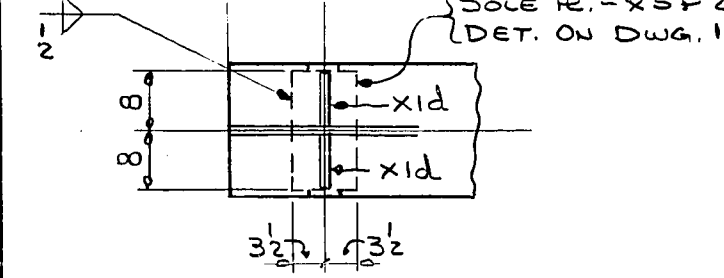
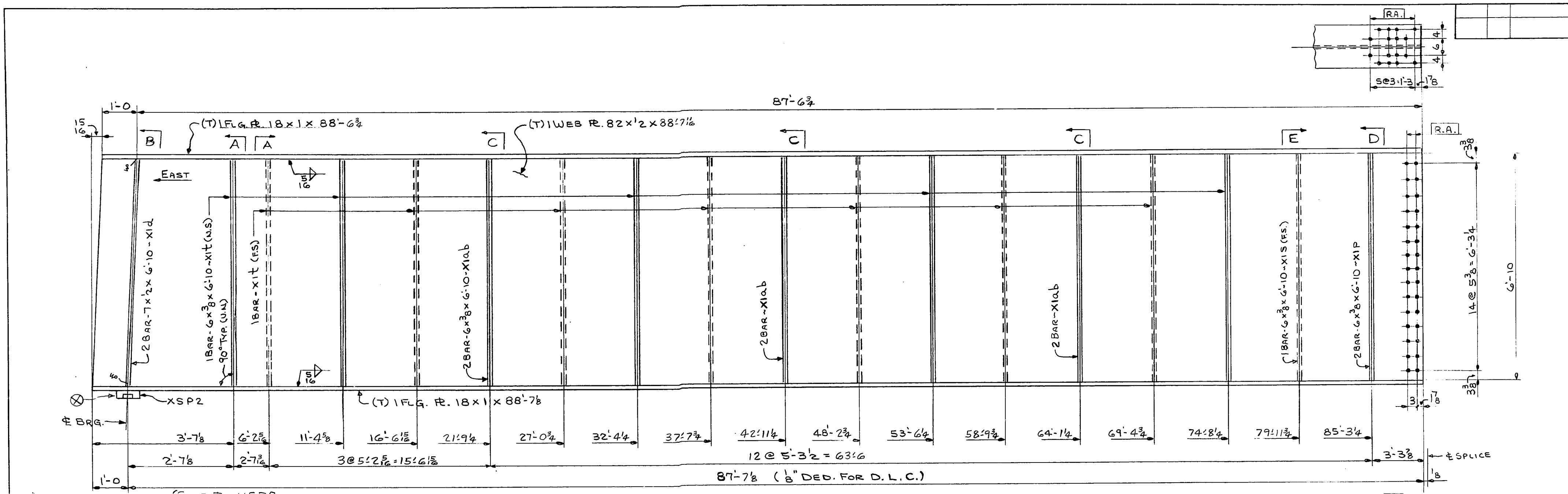


Code: 4000
SHOP NOTE
 HOLES: 1/8\" (U.N.)
 BOLTS: NONE
 PAINT: SEE DWG. N1.

FOR CAMBER DIAGRAM SEE DWG. WCI
 FOR GENERAL NOTES SEE DWG. N1
 DRAWING No. : 19909
 LETTING DATE : 10-19-79

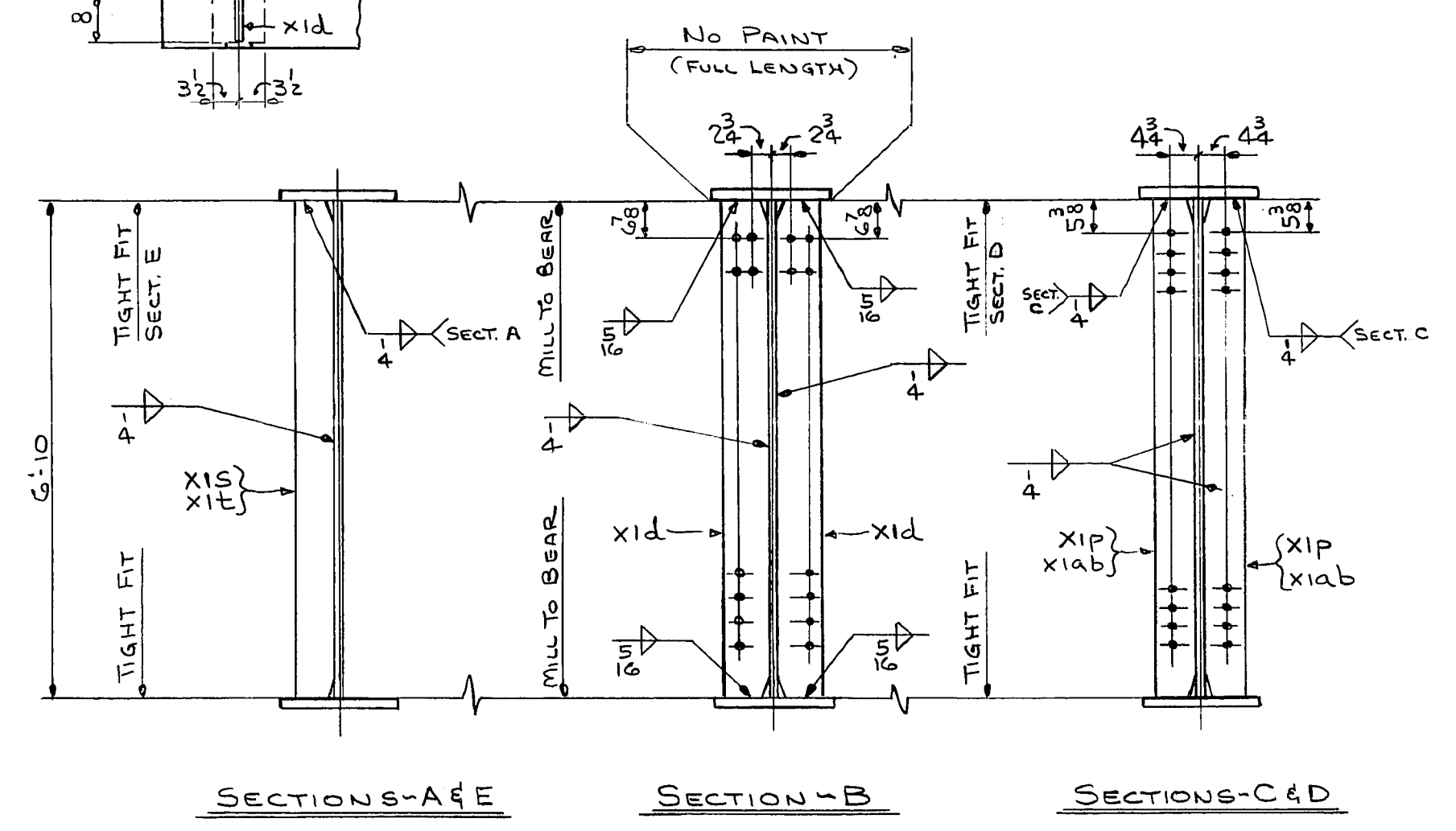
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NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDERS		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 1384 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, KY.		
STATE CONT.	CONTRACTOR	DATE
OR REF. NO. SP-73-32-13L	CRAWFORD CONST. CO., INC.	
IN CHARGE: SALTER		
MADE BY: GLENN	CHECKED BY: KMA	DATE: 1-9-80
CONTRACT NO. K-79167	DRAWING NO. 6	OF 19



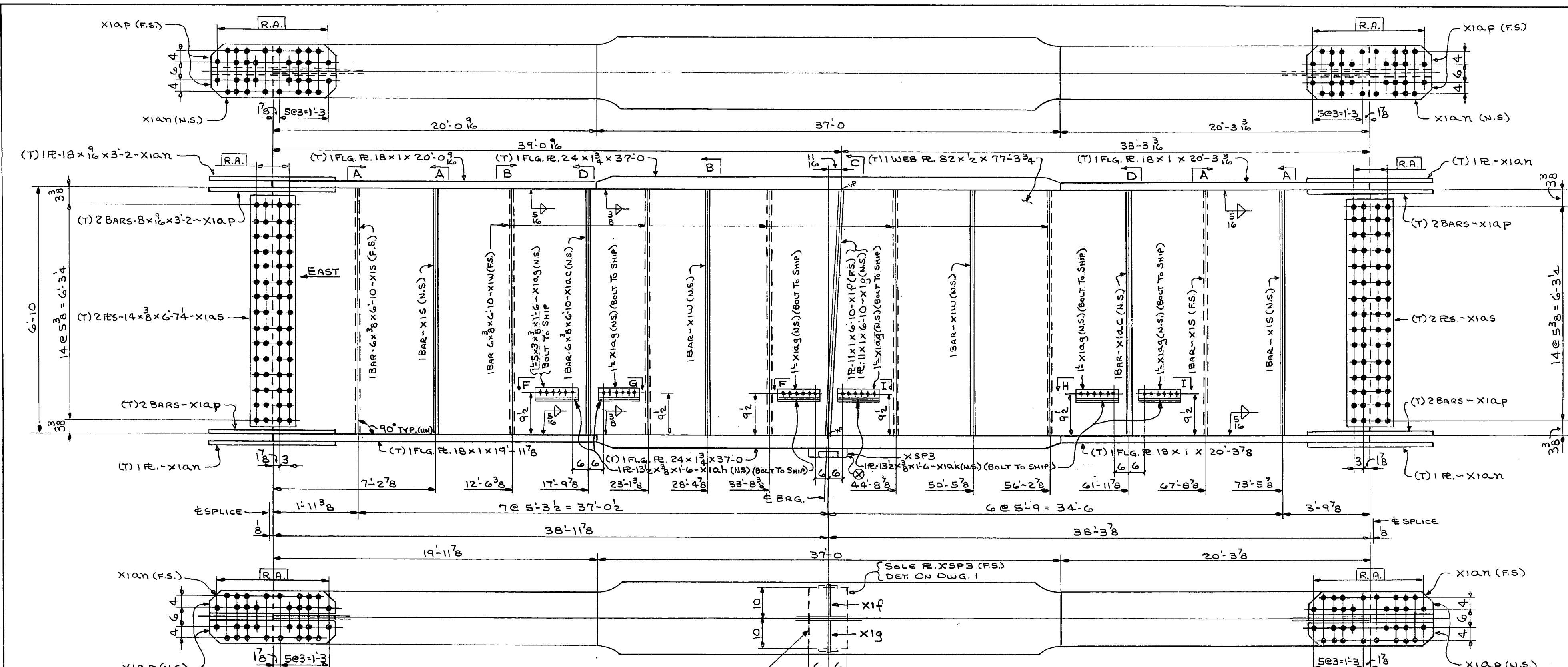
ONE GIRDER - Mk. G3B
 WT. 24,591 Lbs. EA.

a	x1 1/2
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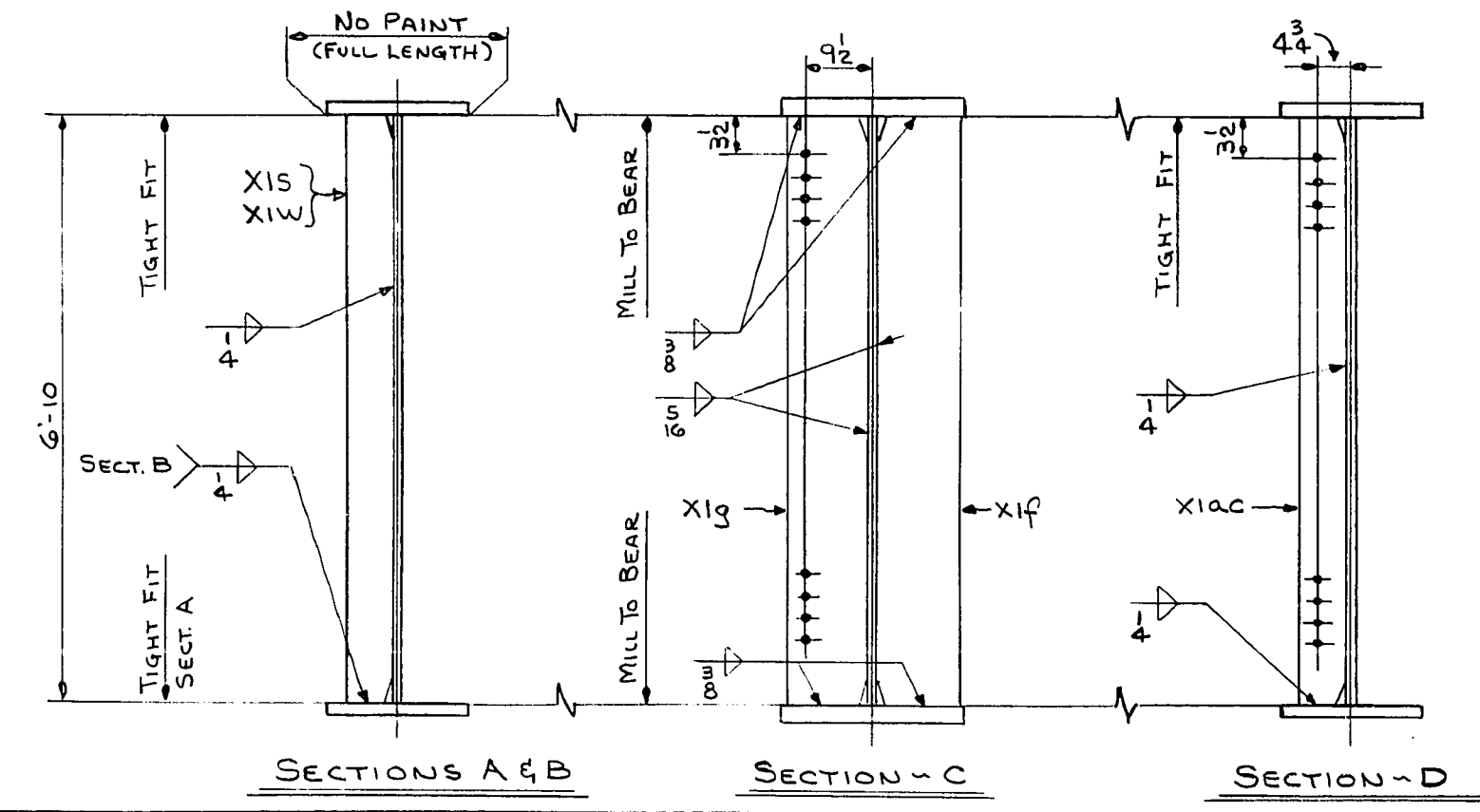


Code: 4000
SHOP NOTE
HOLES: 1 5/8\"/>

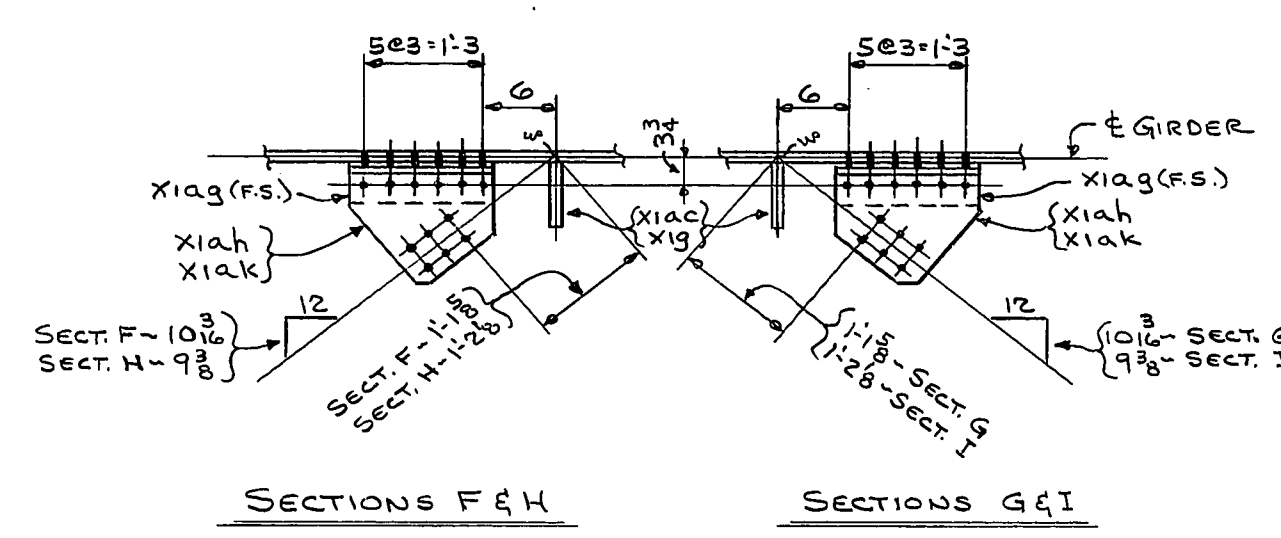
NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDER		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 1384 ± 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, KY.		
STATE CONT. OR REF. NO. SP-73-32-13L CONTRACTOR CRAWFORD CONST. CO., INC.		
IN CHARGE: SALTZER		
MADE BY: G.F.Z. CHECKED BY: R.M. DATE: 1-8-50		
CONTRACT NO. K-79167 DRAWING NO. 7 OF 19		



X1A1P	
a	
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c	4
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i	6
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k	6
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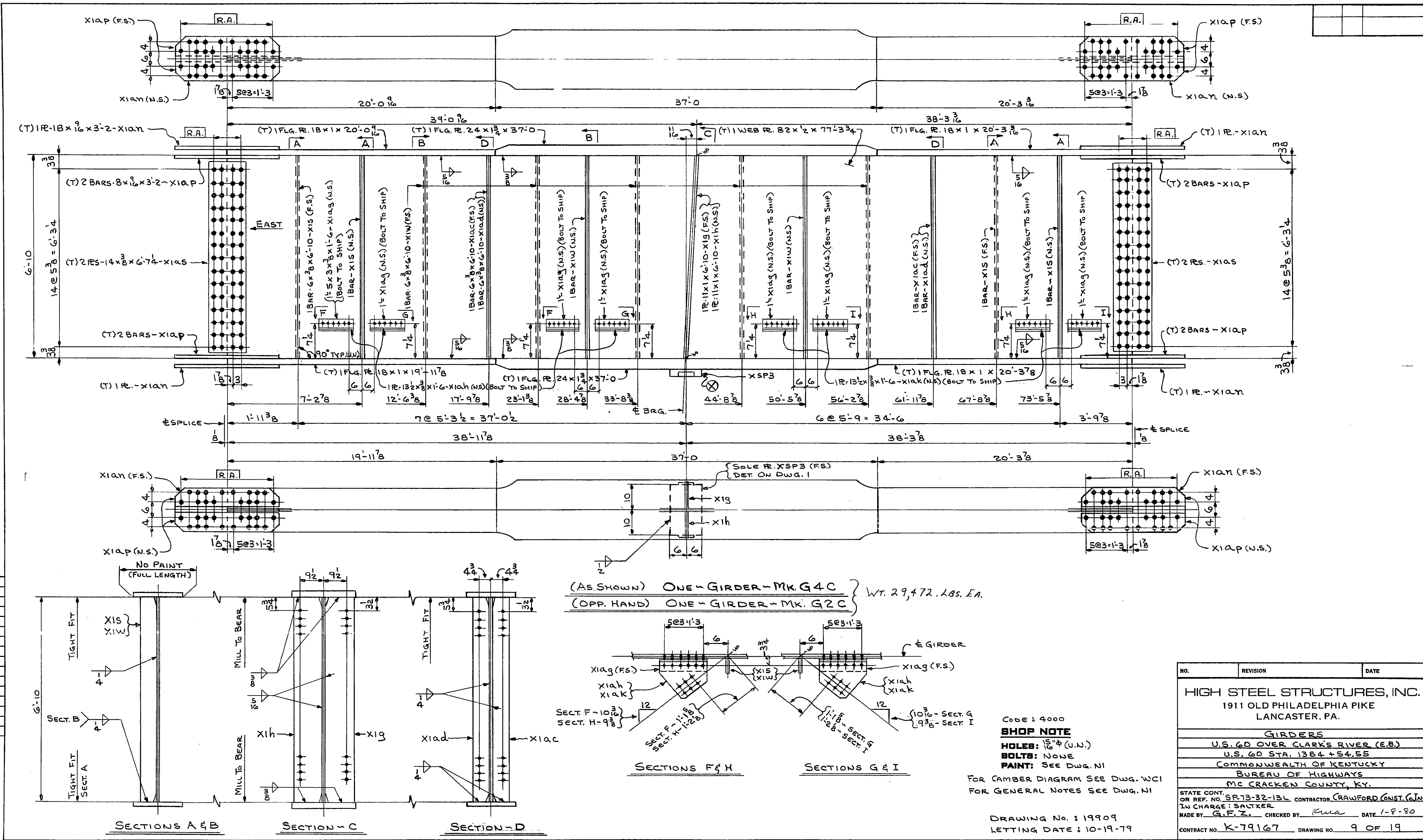
(AS SHOWN) ONE GIRDER - MK. G1C } Wt. 29,287, lbs. Ea.
 (OPP. HAND) ONE GIRDER - MK. G5C }



Code : 4000
SHOP NOTE
 HOLES: 1/8" (U.N.)
 BOLTS: None
 PAINT: See Dwg. N1
 FOR CAMBER DIAGRAM SEE DWG. WCI
 FOR GENERAL NOTES SEE DWG. N1

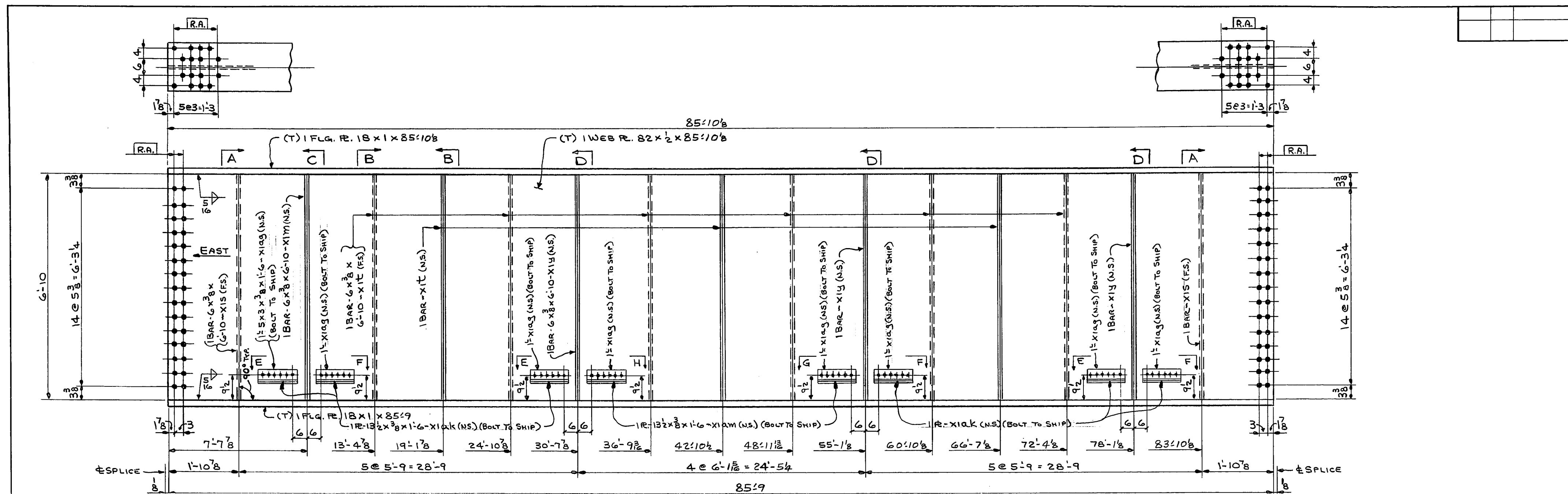
DRAWING No. : 19909
 LETTING DATE : 10-19-79

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDERS		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 1384 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, KY.		
STATE CONT. OR REF. NO. SP-13-32-13L CONTRACTOR: CRAWFORD CONST. CO. INC.		
IN CHARGE: SAUTER		
MADE BY: G.F.Z. CHECKED BY: <i>cmd</i> DATE: 1-8-80		
CONTRACT NO. K-79167 DRAWING NO. 8 OF 19		



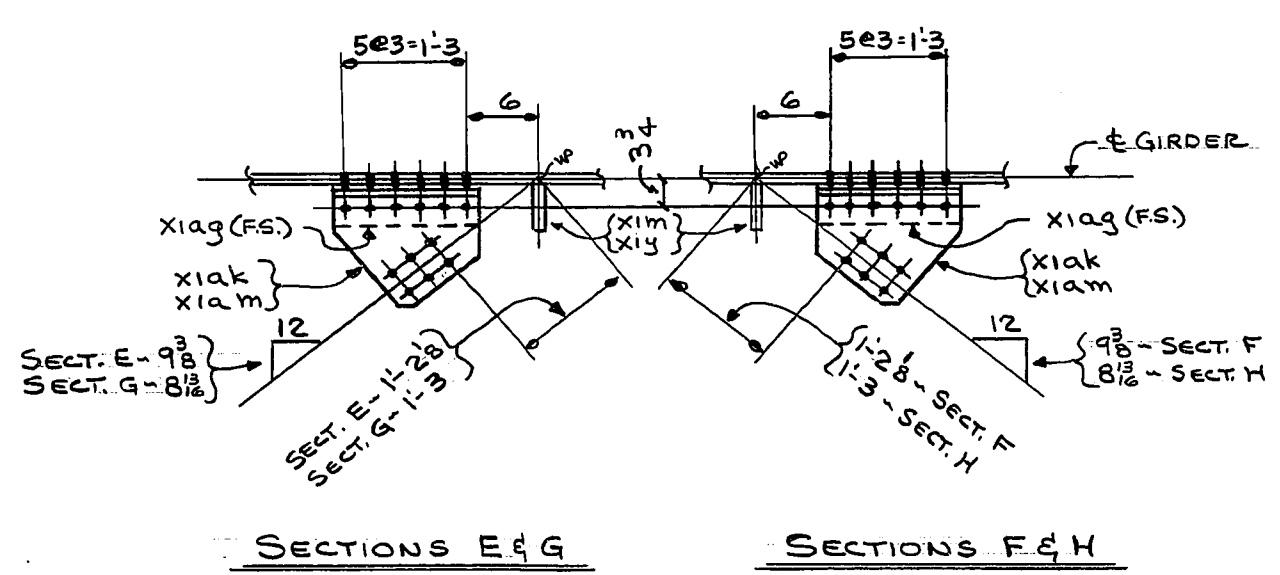
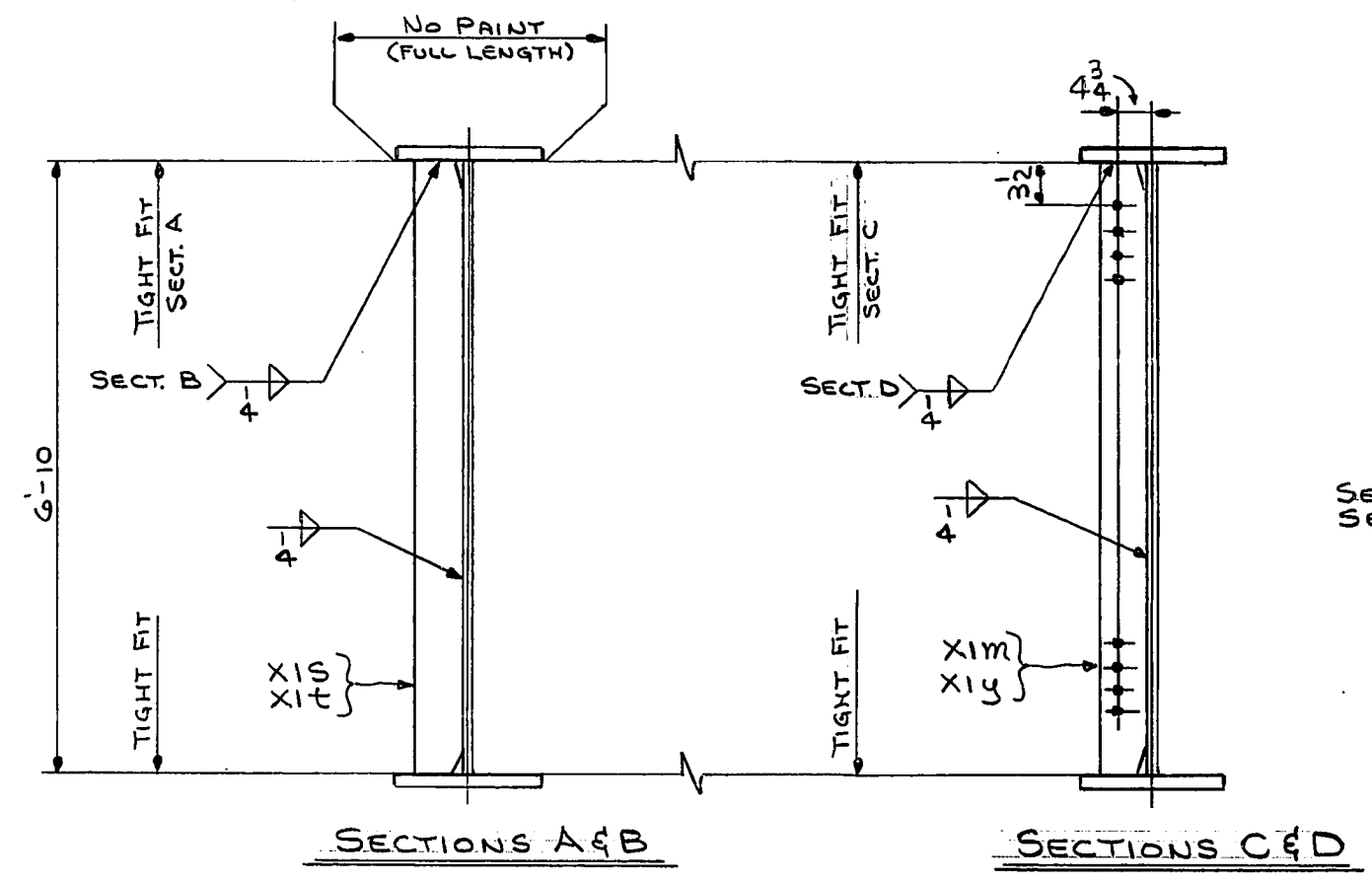
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X1A1N	
X1A1G	
X1A1H	
X1A1K	
X1A1C	
X1A1D	
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X1S	
X1W	
X1H	
X1A1	
X1A1I	
X1A1J	
X1A1K	
X1A1L	
X1A1M	
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X1A1O	
X1A1P	
X1A1Q	
X1A1R	
X1A1S	
X1A1T	
X1A1U	
X1A1V	
X1A1W	
X1A1X	
X1A1Y	
X1A1Z	

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDERS		
U.S. 60 OVER CLARKS RIVER (E.B.)		
U.S. 60 STA. 13B4 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, KY.		
STATE CONT. OR REF. NO.	SP-73-32-13L	CONTRACTOR CRAWFORD GUST. GINS
IN CHARGE:	SAUTER	
MADE BY:	G.F.Z.	CHECKED BY: <i>Kra</i> DATE: 1-8-80
CONTRACT NO.	K-79167	DRAWING NO. 9 OF 19



(AS SHOWN) ONE GIRDER - MK. G1D } Wt. 23,613 lbs. Ea.
 (OPP. HAND) ONE GIRDER - MK. G5D

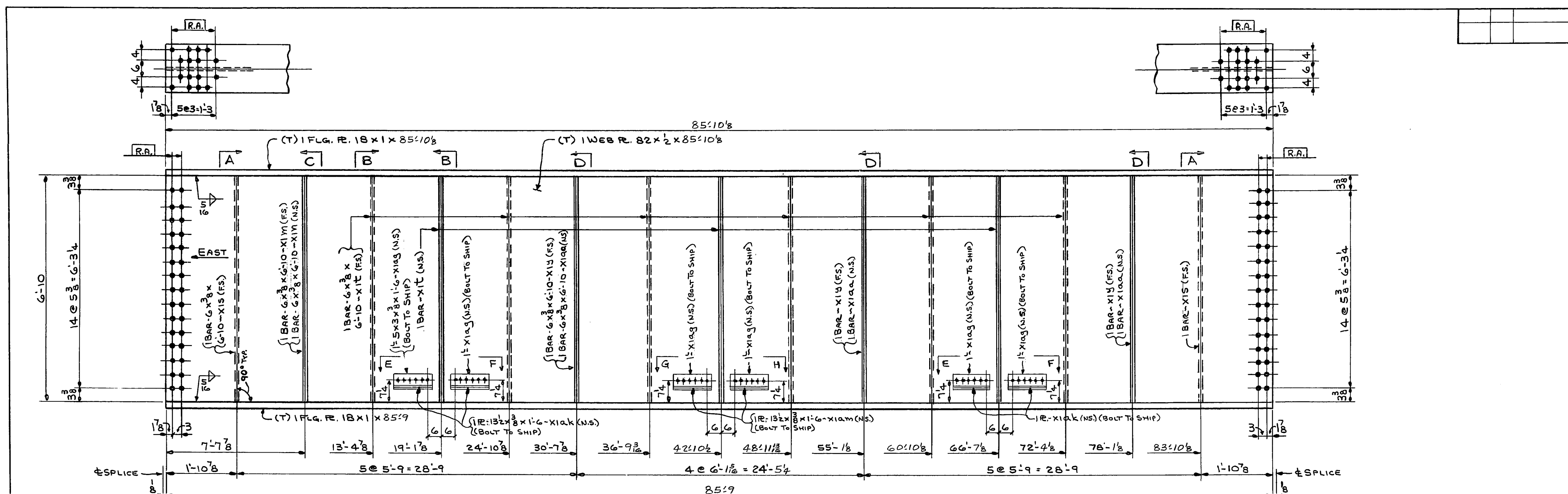
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x	
y	
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CODE: 4000
SHOP NOTE
 HOLES: 15/16" (U.N.)
 BOLTS: NONE
 PAINT: SEE DWG. N1
 FOR CAMBER DIAGRAM SEE DWG. WCI
 FOR GENERAL NOTES SEE DWG. N1

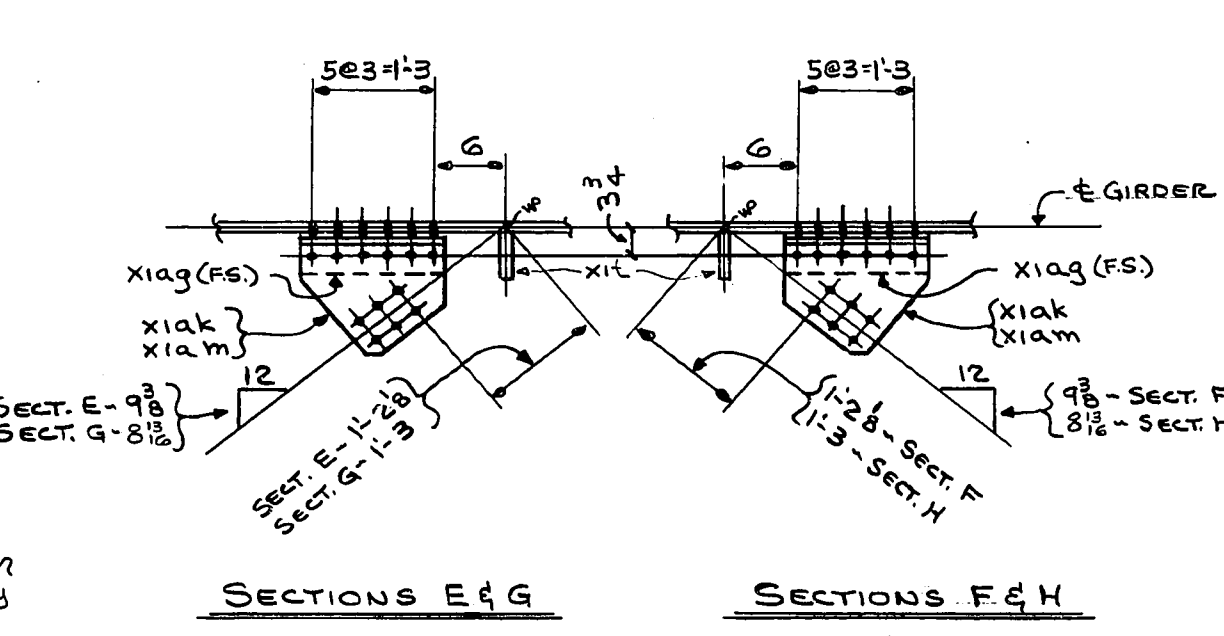
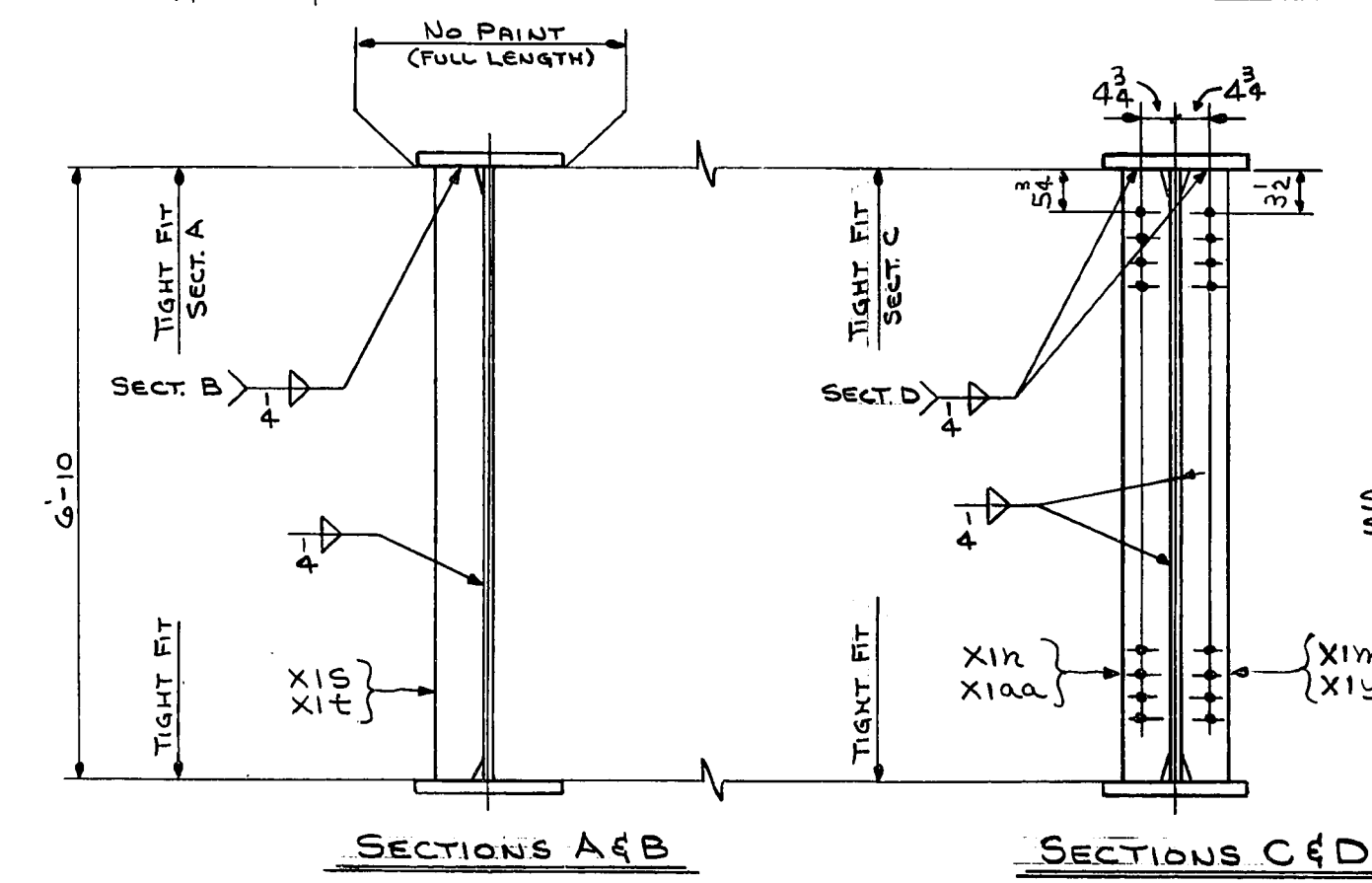
DRAWING No: 19909
 LETTING DATE: 10-19-79

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDERS		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 1384 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, KY.		
STATE CONT. OR REF. NO. SP-73-32-13L CONTRACTOR CRAWFORD CONST. CO., INC.		
IN CHARGE: SALTZER		
MADE BY: G.F.Z. CHECKED BY: KWA DATE: 1-8-80		
CONTRACT NO. K-79167 DRAWING NO. 11 OF 19		



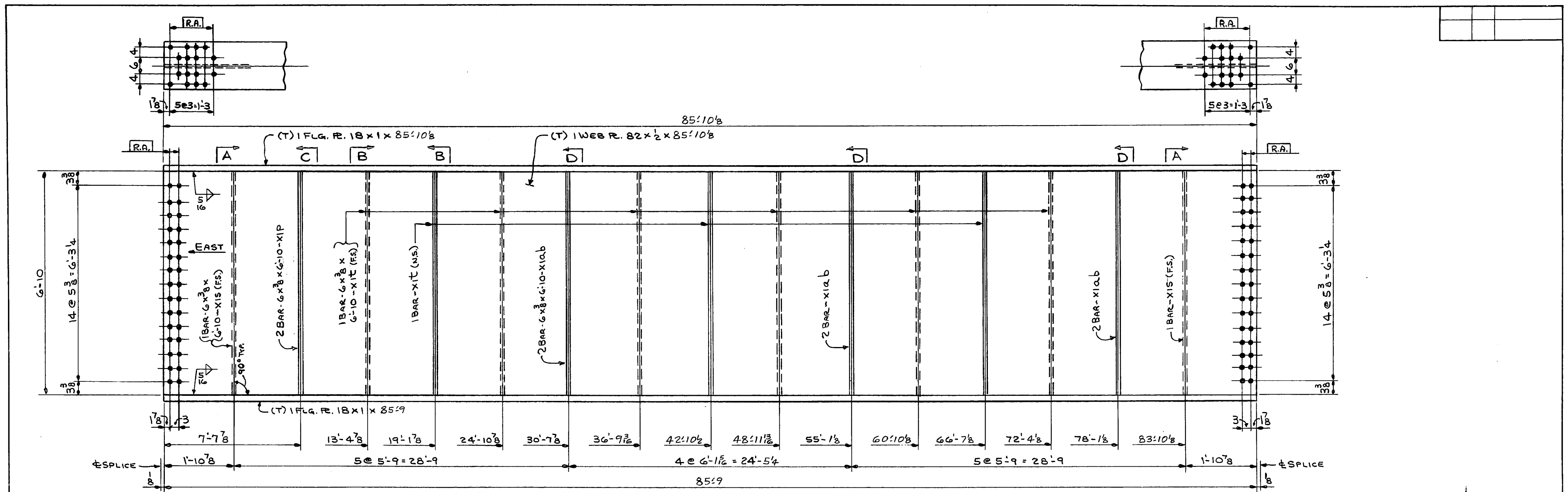
(AS SHOWN) ONE GIRDER - MK. G4D
 (OPP. HAND) ONE GIRDER - MK. G2D } WT. 23,741. LBS. EA.

1	1/2
2	3/4
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4	1 1/4
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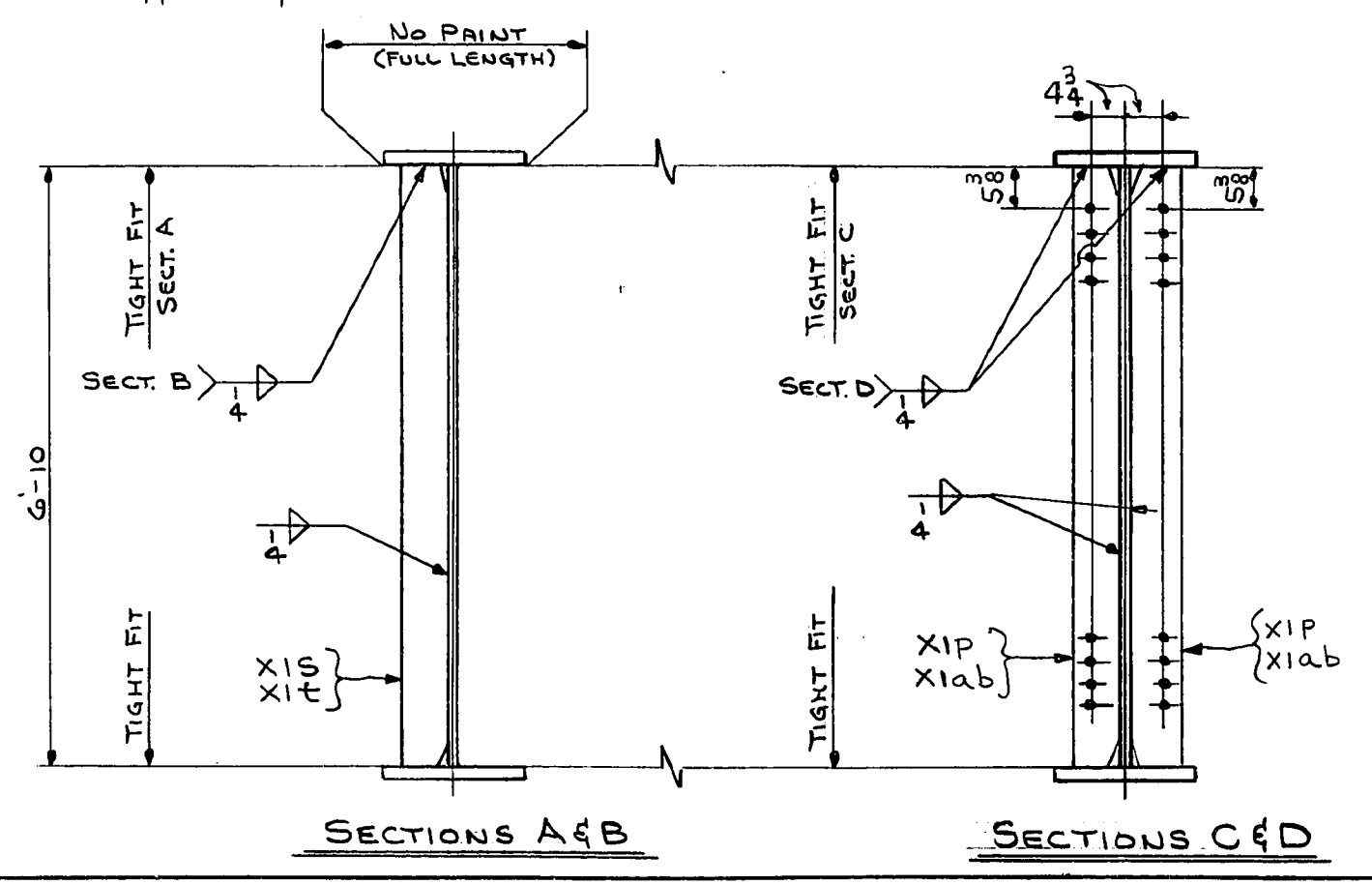


CODE: 4000
SHOP NOTE
 HOLES: 5/8" (U.N.)
 BOLTS: NONE
 PAINT: SEE DWG. N1
 FOR CAMBER DIAGRAM SEE DWG. WCI
 FOR GENERAL NOTES SEE DWG. N1
 DRAWING No: 19909
 LETTING DATE: 10-19-79

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDERS		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 1384 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, KY.		
STATE CONT.	SP-73-32-13L	CONTRACTOR
OR REF. NO.		RAWFORD CONST. CO., INC.
IN CHARGE:	SALTZER	
MADE BY:	G.F.Z.	CHECKED BY: <i>Kma</i> DATE: 1-8-80
CONTRACT NO.	K-79167	DRAWING NO. 12 OF 19



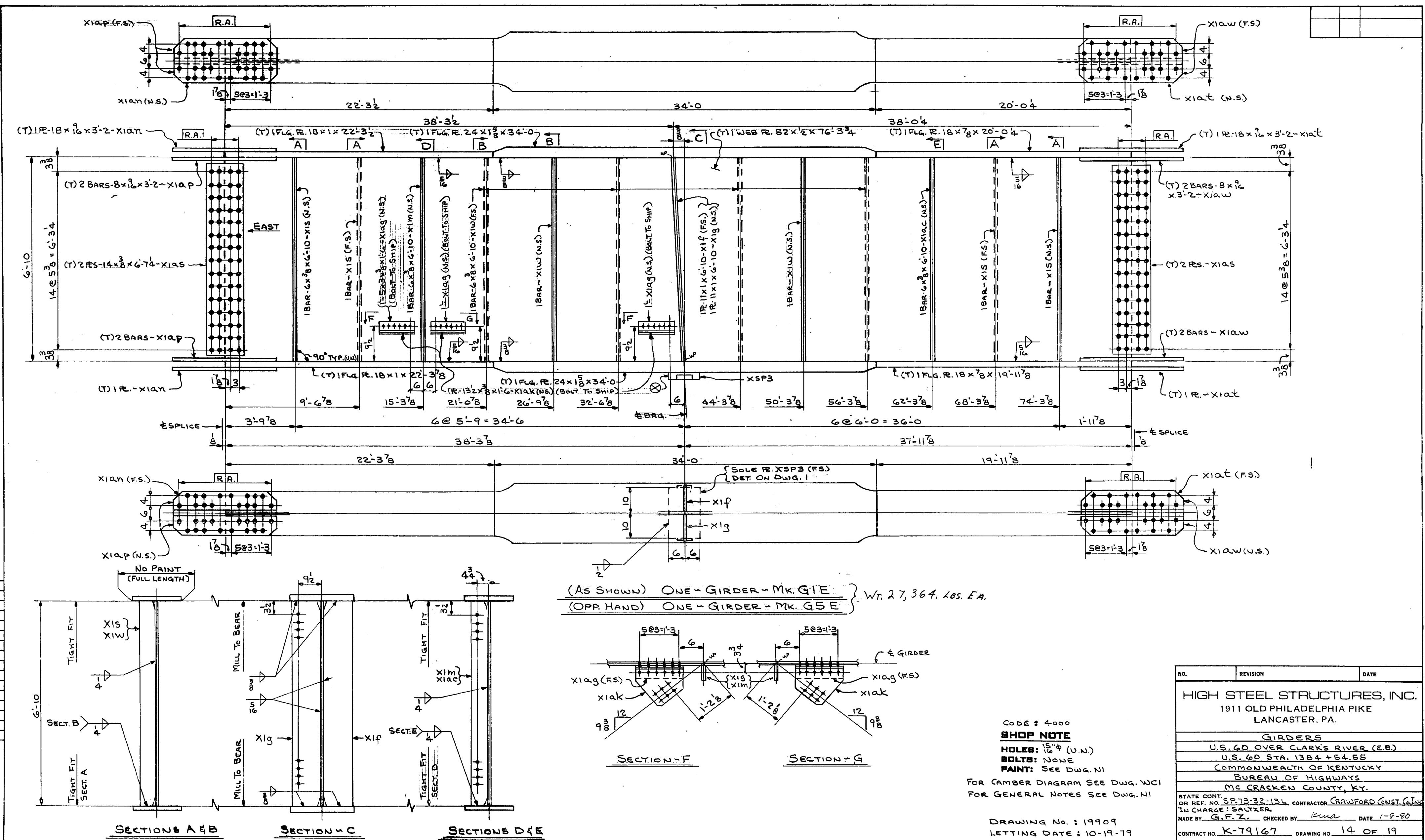
ONE GIRDER - MK. G3 D
Wt. 23,289 Lbs. EA.



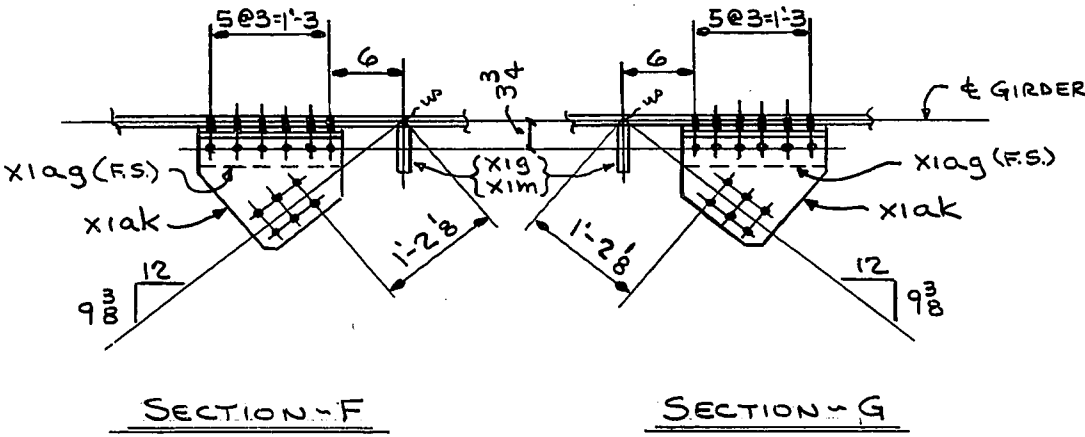
CODE : 4000
SHOP NOTE
 HOLES: 1/2" (U.N.)
 BOLTS: NONE
 PAINT: SEE DWG. N1
 FOR CAMBER DIAGRAM SEE DWG. WCI
 FOR GENERAL NOTES SEE DWG. N1
 DRAWING No : 19909
 LETTING DATE : 10-19-79

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDER		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 1384 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, KY.		
STATE CONT. SP. 73-32-13L CONTRACTOR: RAWFORD GUST. CO. INC.		
OR REF. NO. 2 IN CHARGE: SAUTZER		
MADE BY: G.F.Z. CHECKED BY: <i>Kma</i> DATE: 1-8-80		
CONTRACT NO. K-79167 DRAWING NO. 13 OF 19		

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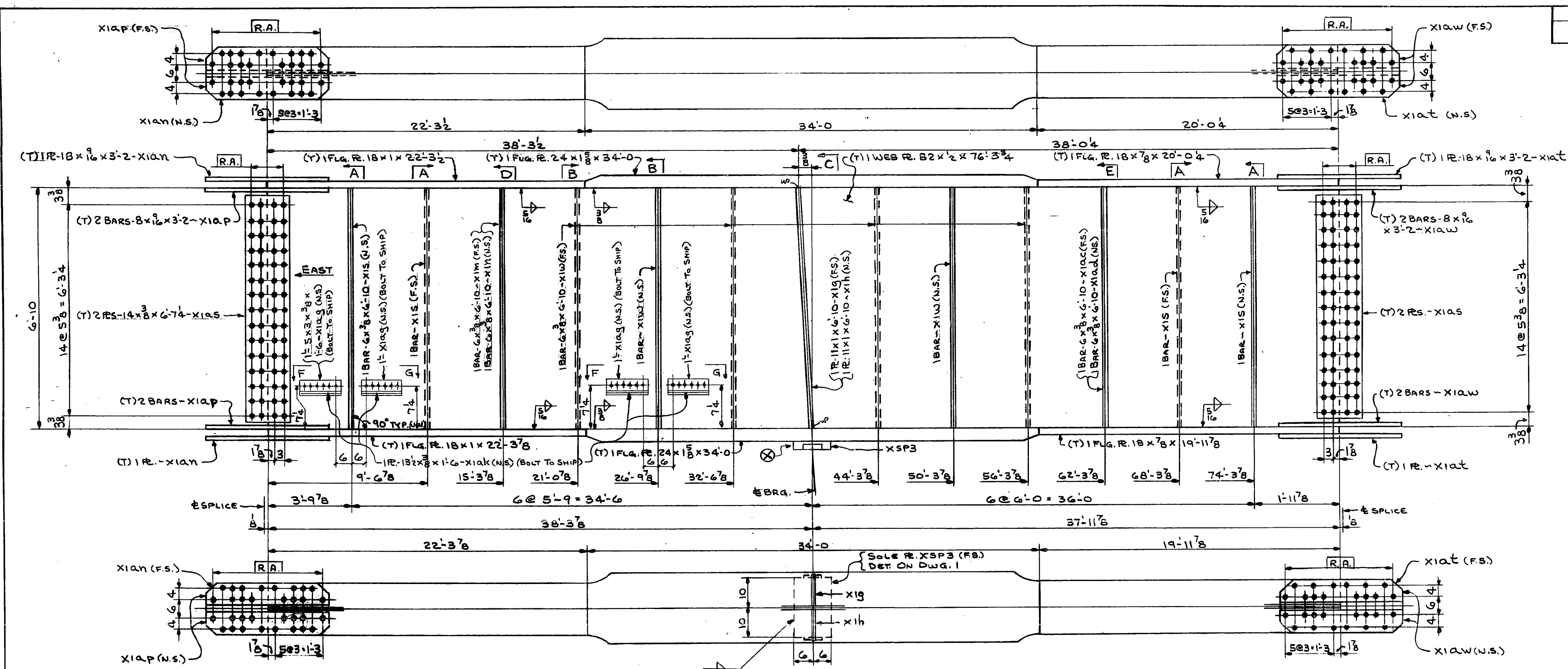
(AS SHOWN) ONE GIRDER - MK. G1E } Wt. 27,364, lbs. EA.
 (OPP. HAND) ONE GIRDER - MK. G5E



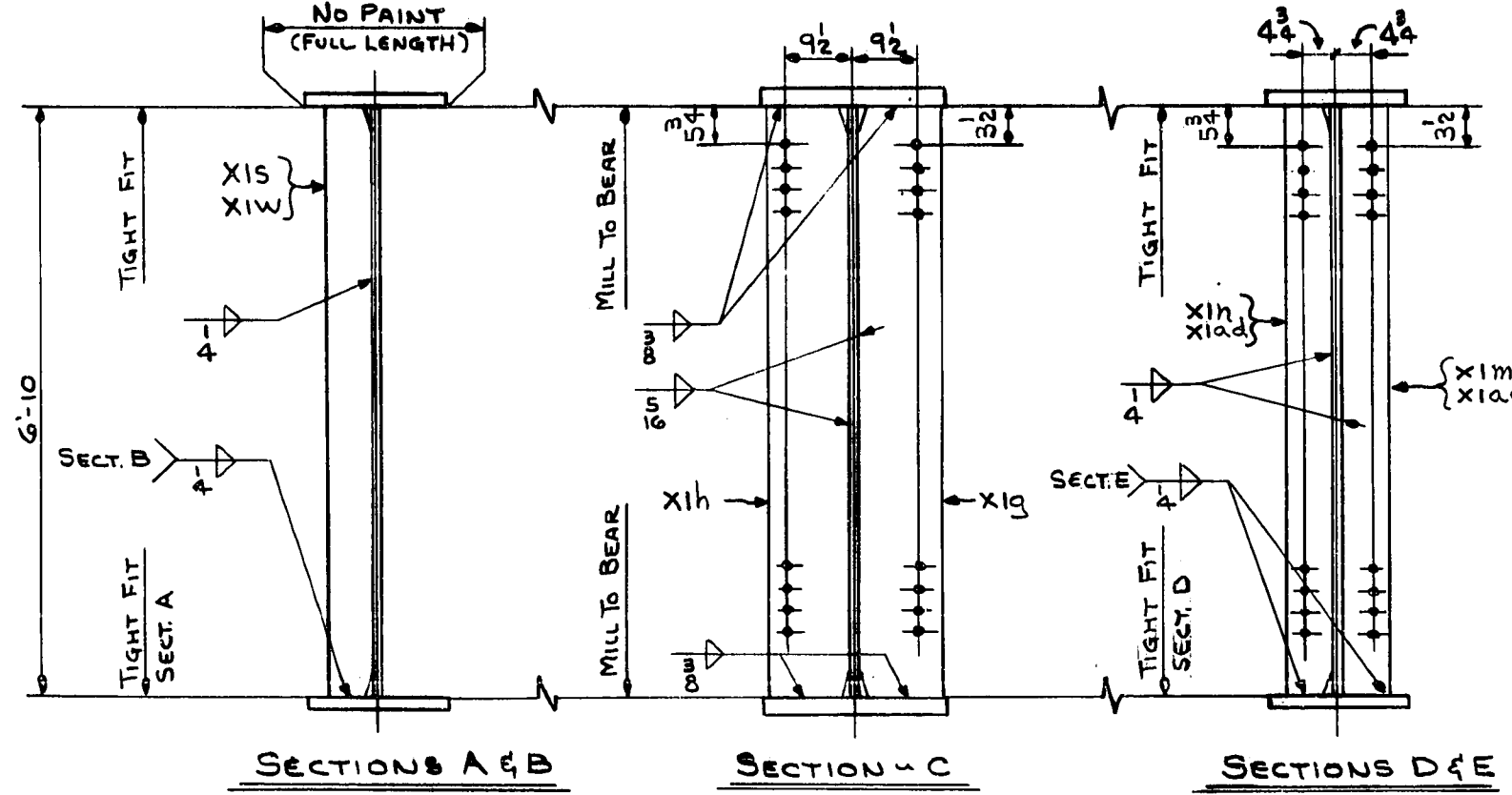
CODE 4000
SHOP NOTE
 HOLES: 15/16" (U.N.)
 BOLTS: NONE
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 FOR CAMBER DIAGRAM SEE DWG. WCI
 FOR GENERAL NOTES SEE DWG. N1

DRAWING No. : 19909
 LETTING DATE : 10-19-79

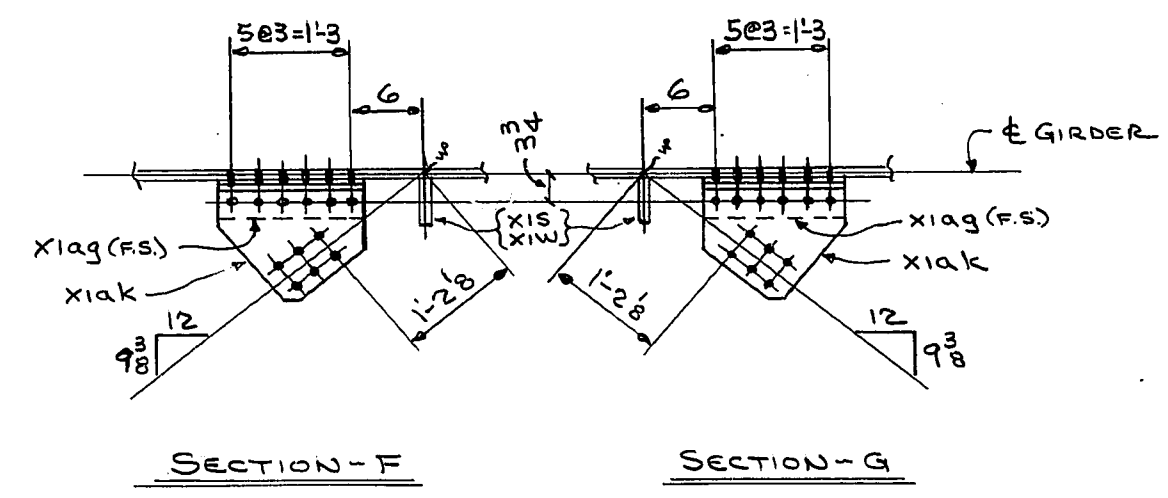
NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDERS		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 1384+54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, KY.		
STATE CONT. OR REF. NO. SP-13-32-13L CONTRACTOR CRAWFORD CONST. CO. INC.		
IN CHARGE: SALTREX		
MADE BY: G.F.Z. CHECKED BY: Kma DATE: 1-2-80		
CONTRACT NO. K-79167 DRAWING NO. 14 OF 19		



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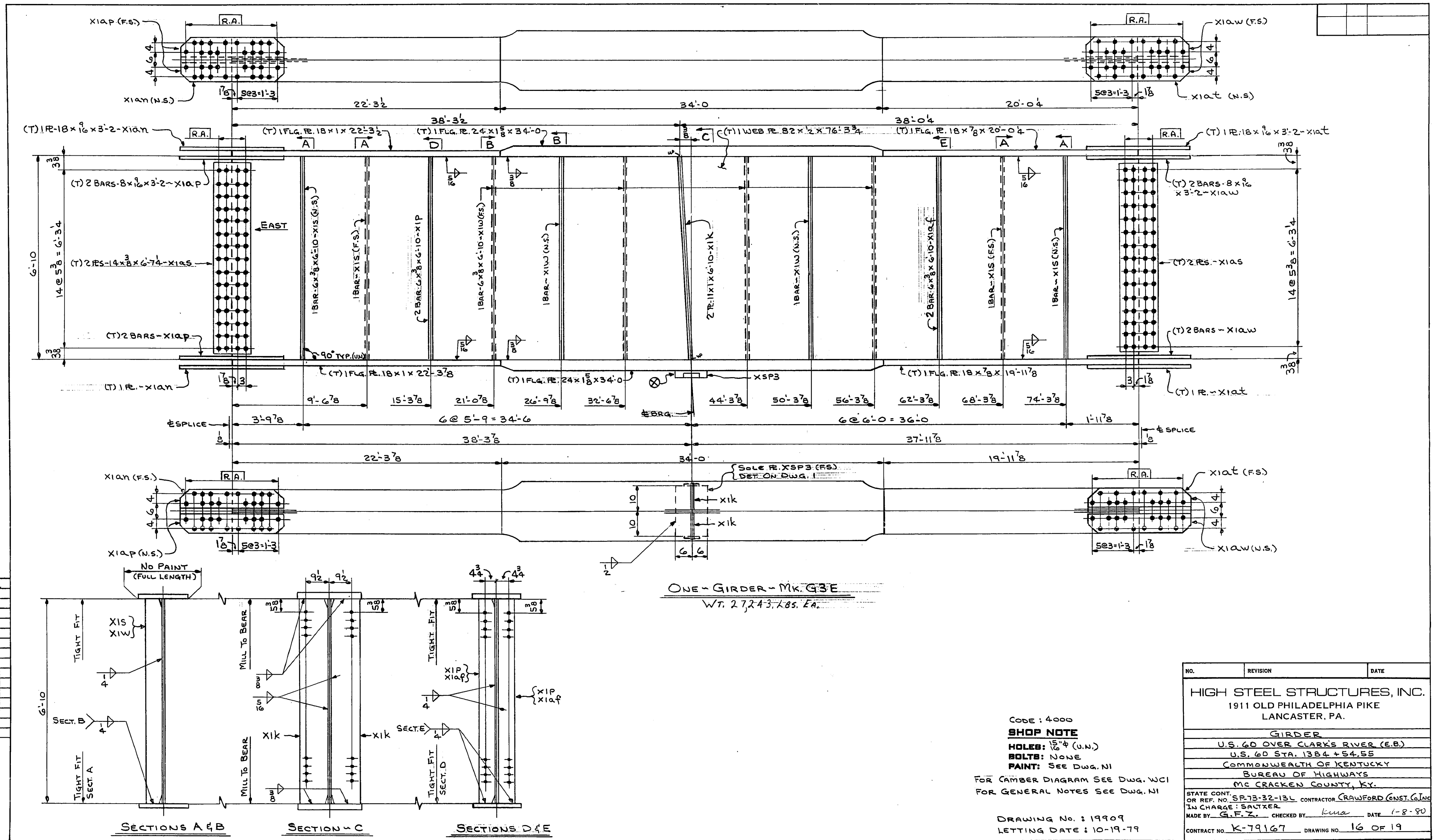
(AS SHOWN) ONE GIRDER - MK. G4E } Wt. 27,509 lbs. EA.
 (OPP. HAND) ONE GIRDER - MK. G2E }



CODE: 4-000
SHOP NOTE
 HOLES: 1/8" (U.N.)
 BOLTS: NONE
 PAINT: SEE DWG. N1
 FOR CAMBER DIAGRAM SEE DWG. WCI
 FOR GENERAL NOTES SEE DWG. N1

DRAWING NO. : 19909
 LETTING DATE : 10-19-79

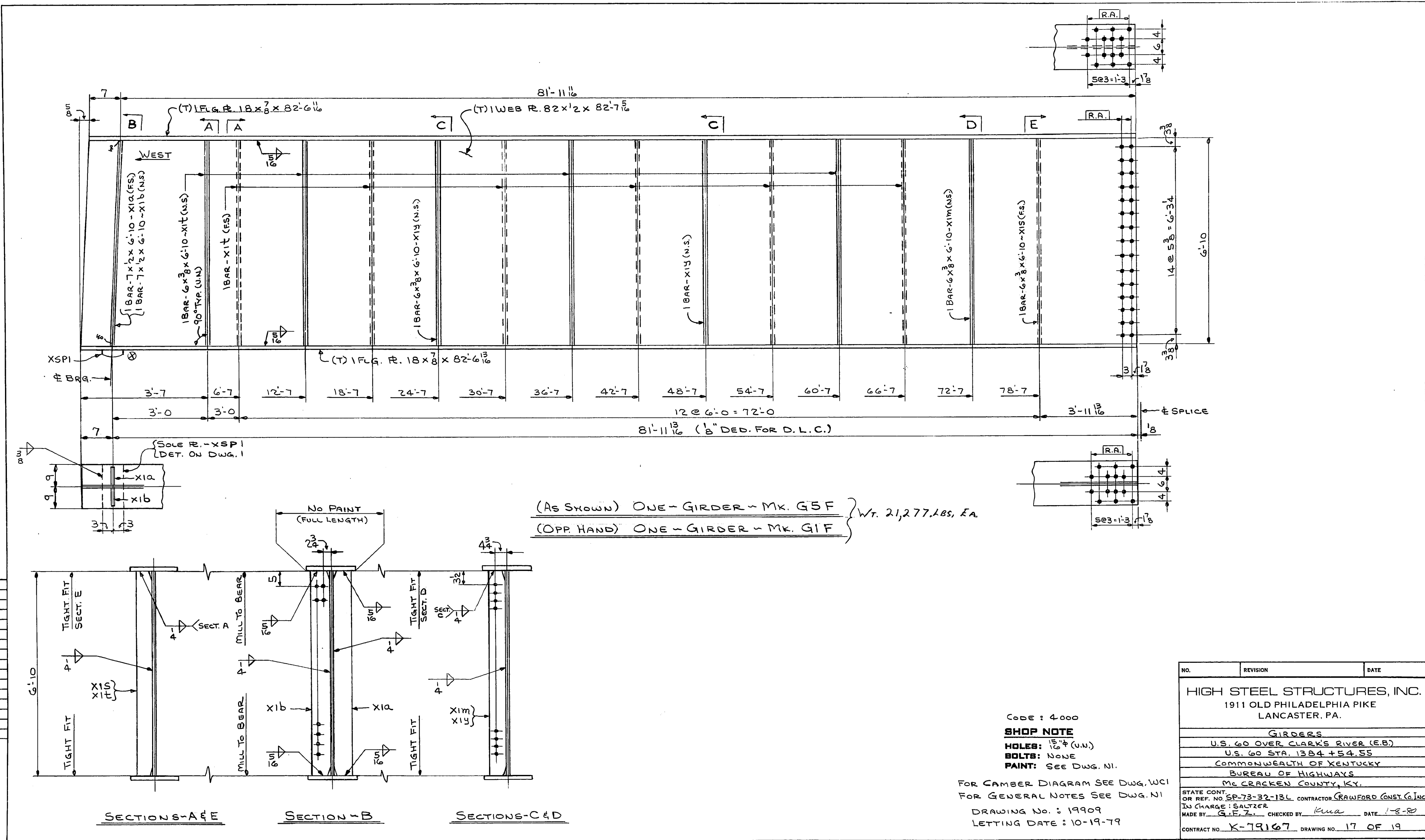
NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDERS		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 1384 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, KY.		
STATE CONT.	CONTRACTOR	DATE
OR REF. NO. SP-13-32-13L	CRAWFORD CONST. CO. INC.	
IN CHARGE: SALTZER		
MADE BY: G.F.Z.	CHECKED BY: KWA	DATE: 1-8-80
CONTRACT NO. K-79167	DRAWING NO. 15	OF 19

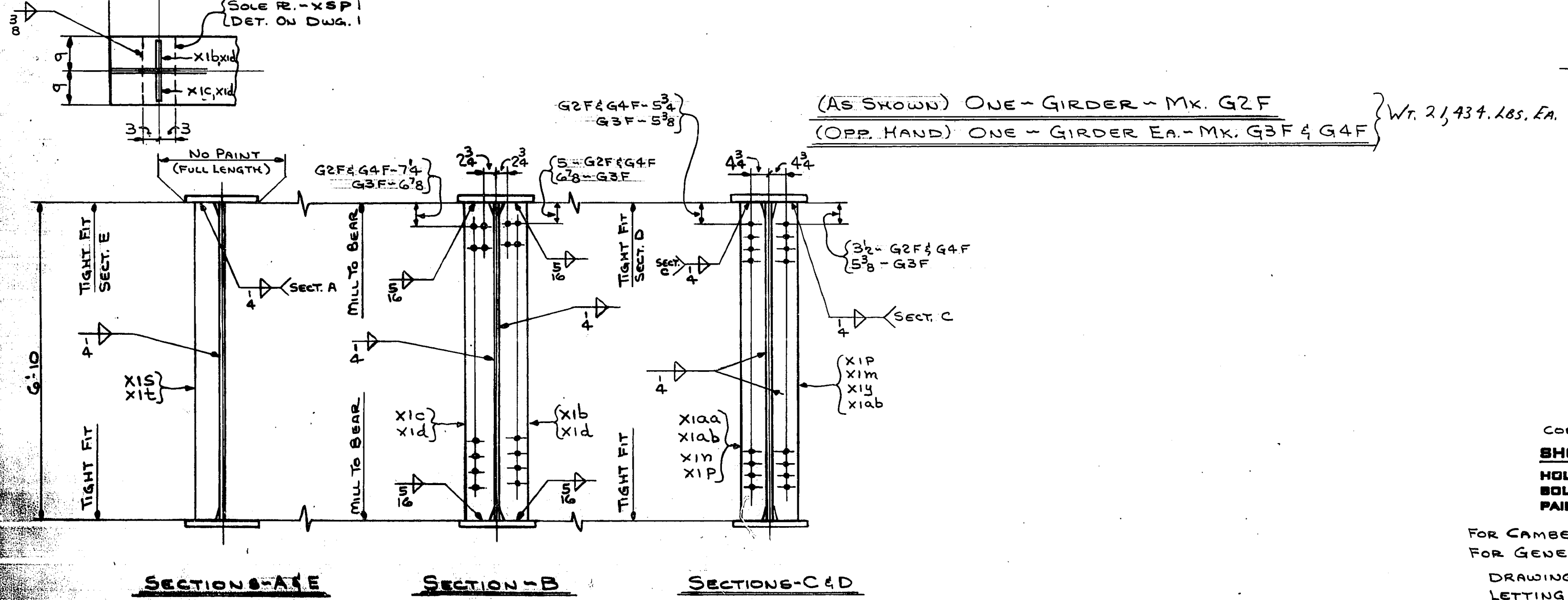
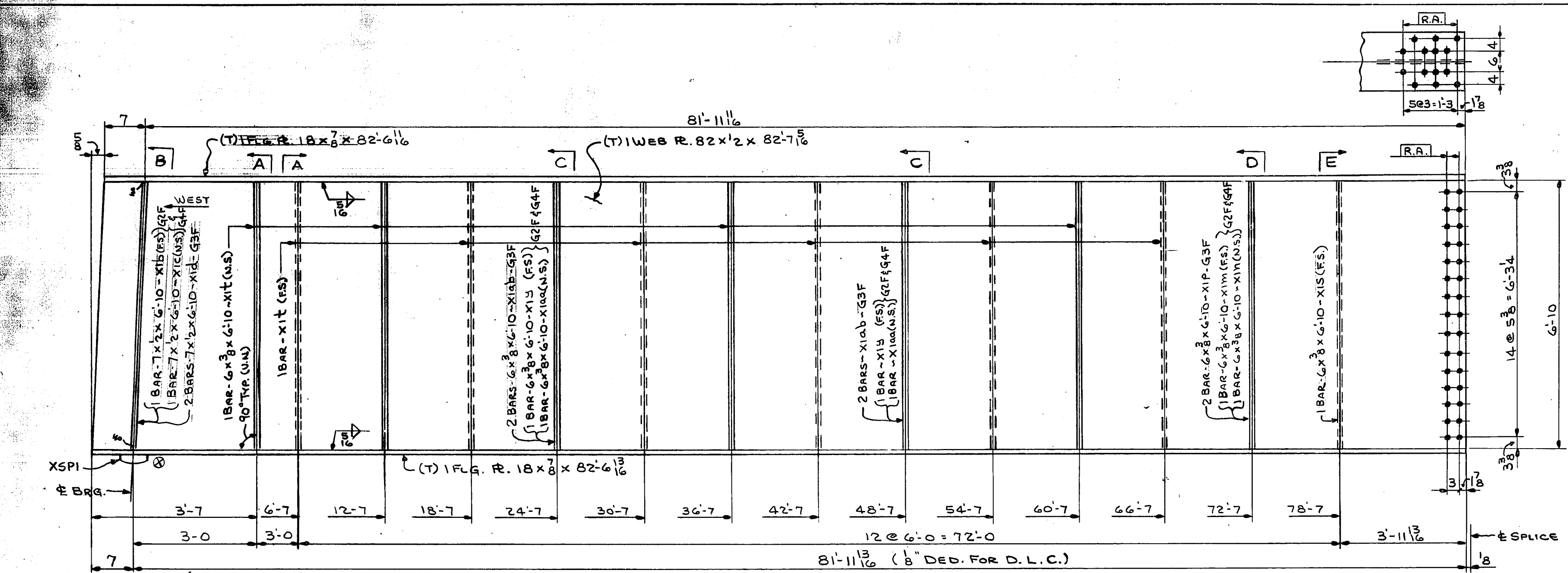


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CODE: 4000
SHOP NOTE
 HOLES: 1/8" (U.S.)
 BOLTS: NONE
 PAINT: SEE DWG. N1
 FOR CAMBER DIAGRAM SEE DWG. WC1
 FOR GENERAL NOTES SEE DWG. N1
 DRAWING NO.: 19909
 LETTING DATE: 10-19-79

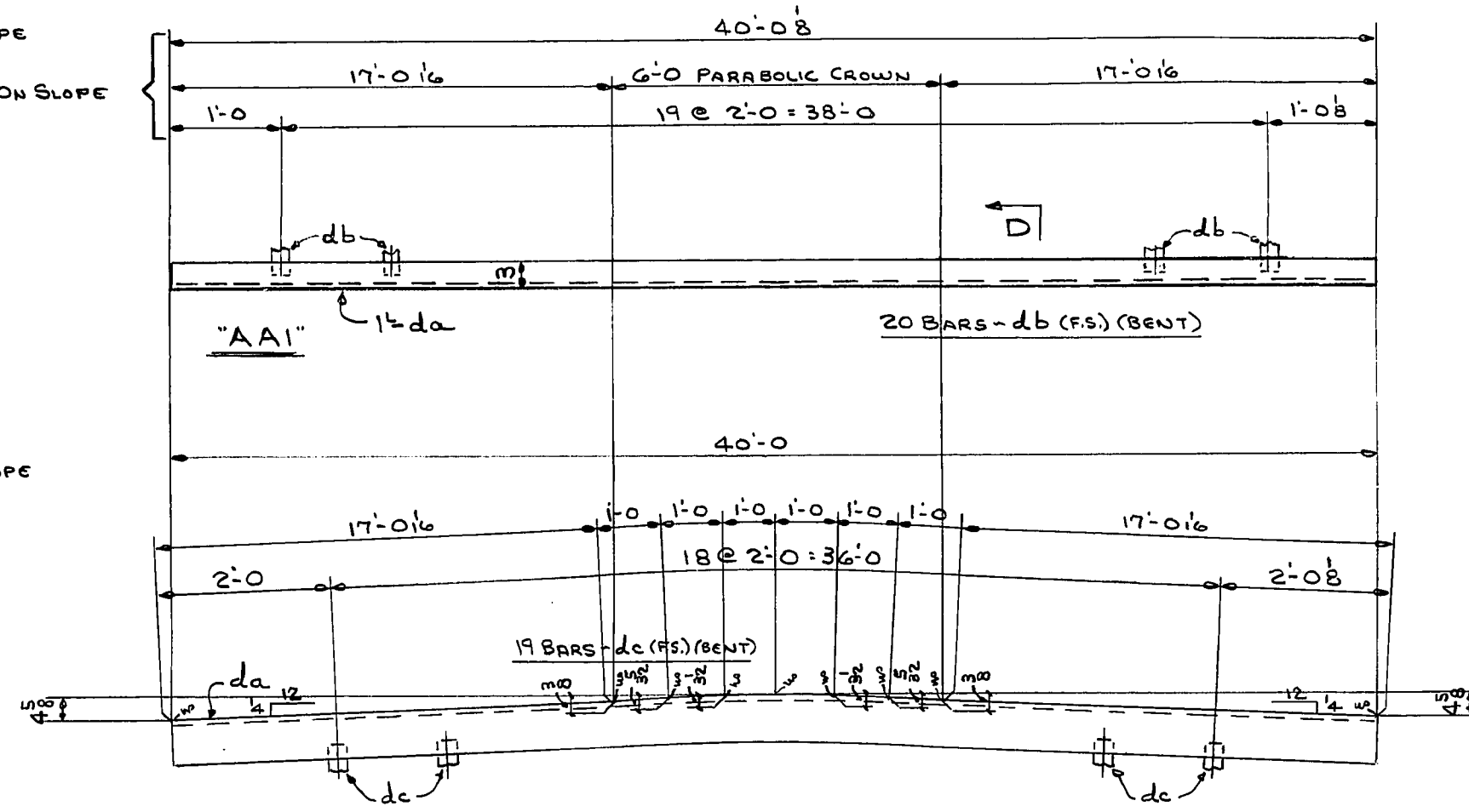
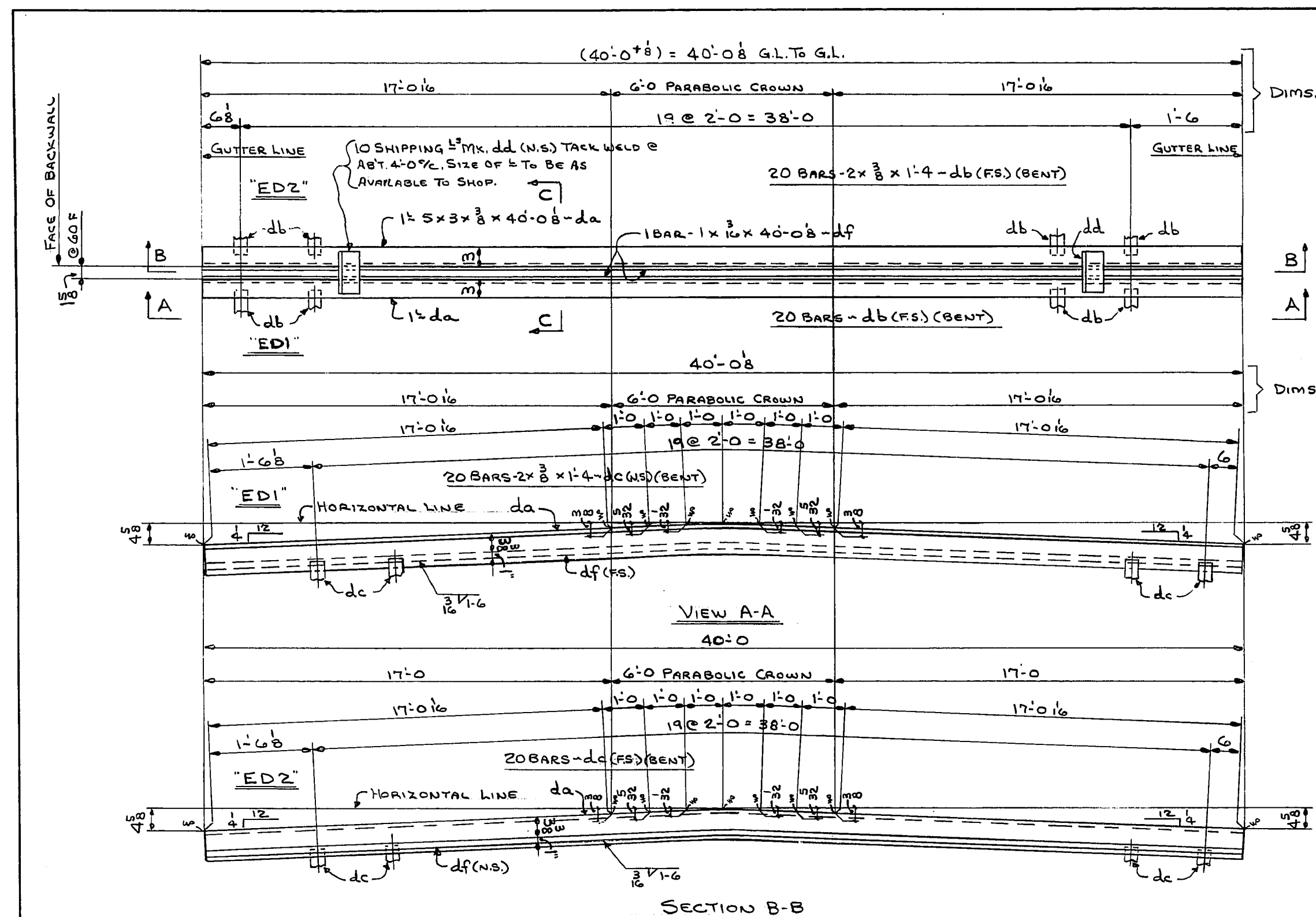
NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDER		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 1384 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, KY.		
STATE CONT. OR REF. NO. SR-13-32-13L CONTRACTOR CRAWFORD CONST. CO. INC.		
IN CHARGE: SALTZER		
MADE BY: G.F.Z. CHECKED BY: kma DATE 1-8-80		
CONTRACT NO. K-79167 DRAWING NO. 16 OF 19		



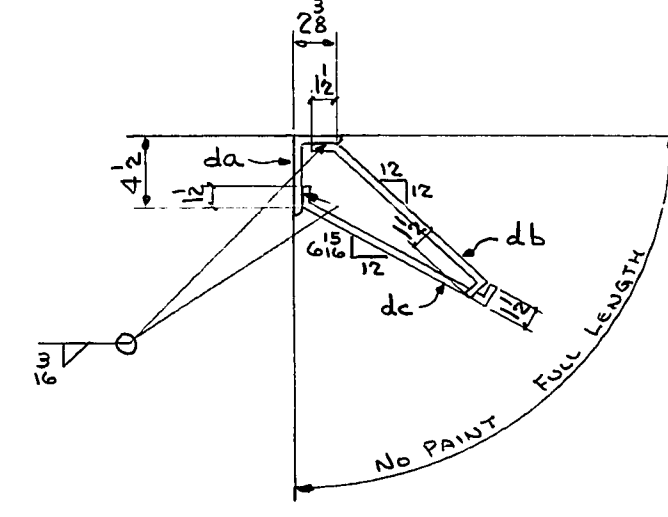
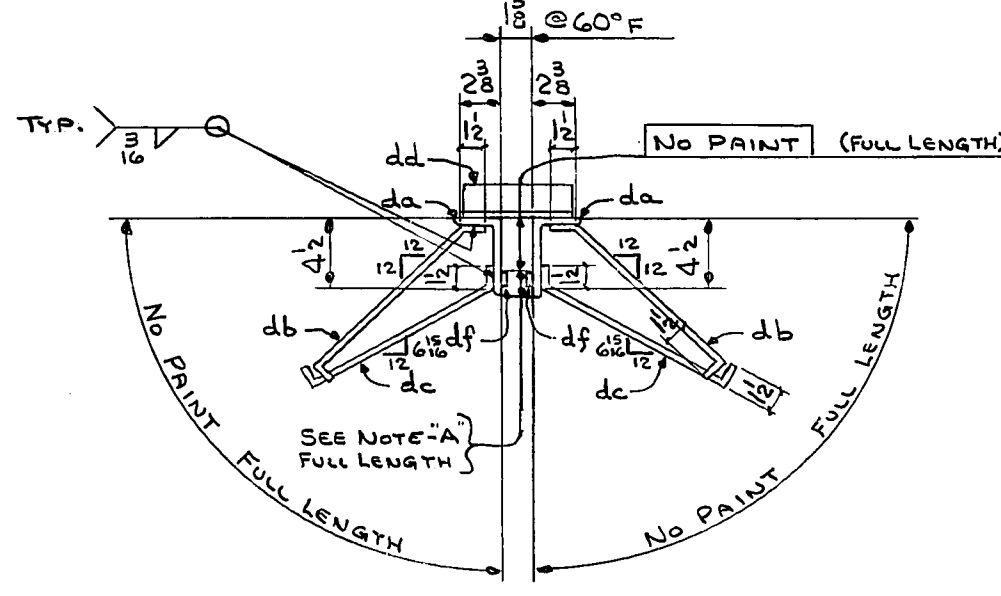


CODE : 4000
SHOP NOTE
 HOLES: $\frac{1}{8}$ " (U.N.)
 BOLTS: NONE
 PAINT: SEE DWG. N1.
 FOR CAMBER DIAGRAM SEE DWG. WC1
 FOR GENERAL NOTES SEE DWG. N1
 DRAWING No. : 19909
 LETTING DATE : 10-19-79

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
GIRDERS		
U.S. 60 OVER CLARK'S RIVER (E.B.)		
U.S. 60 STA. 1384 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
ME. CRACKEN COUNTY, KY.		
STATE CONT. OR REF. NO. SP-73-32-13L	CONTRACTOR: CRAWFORD CONST. CO. INC.	
IN CHARGE: SALTZER	DATE: 1-8-80	
MADE BY: G.E.Z.	CHECKED BY: Kua	
CONTRACT NO. K-79167	DRAWING NO. 18 OF 19	



2- ABUTMENT ANGLES - Mk. AA1
Wt. 460. LBS. EA.



SECTION C-C

SECTION D-D

2- EXPANSION DAMS - Mk. ED1 } ASSEMBLE & SHIP AS A UNIT
 2- EXPANSION DAMS - Mk. ED2 }
 TOTAL WT. OF ONE UNIT ~ 920. LBS. EA.

NOTE - A

SURFACES INDICATED ARE INACCESSIBLE AFTER ERECTION; APPLY 3 COATS OF SHOP PAINT.

Code : 5800

SHOP NOTE

HOLES: NONE
 BOLTS: NONE
 PAINT: SEE DWG. N1

FOR GENERAL NOTES SEE DWG. N1

DRAWING No. : 19909
 LETTING DATE : 10-19-79

NO.	REVISION	DATE
HIGH STEEL STRUCTURES, INC. 1911 OLD PHILADELPHIA PIKE LANCASTER, PA.		
EXPANSION DAMS & ABUTMENT ANGLES		
U.S. 60 OVER CLARK'S RIVER (C.B.)		
U.S. 60 STA. 1384 + 54.55		
COMMONWEALTH OF KENTUCKY		
BUREAU OF HIGHWAYS		
MC CRACKEN COUNTY, KY.		
STATE CONT. OR REF. NO. SP-73-32-13L CONTRACTOR: CRAWFORD CONST. CO., INC.		
IN CHARGE: SAUTZER		
MADE BY: G.F.Z.	CHECKED BY: <i>ewa</i>	DATE: 1-8-80
CONTRACT NO. K-79167		DRAWING NO. 19 OF 19

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