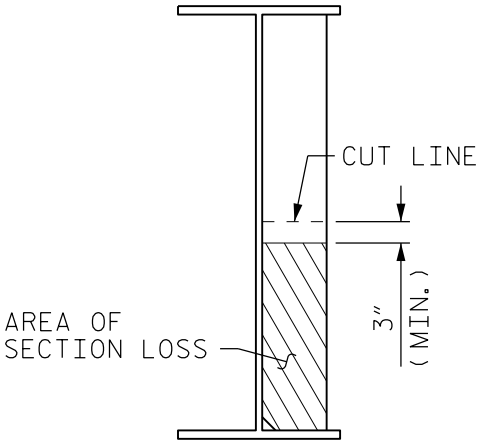
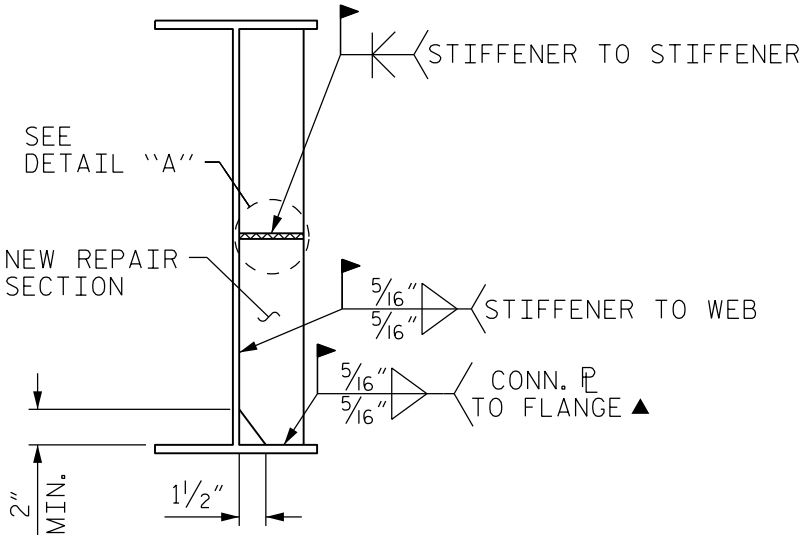


STIFFENER/CONN. PL REMOVAL



STIFFENER/CONN. PL REPAIR

▲ FOR STIFFENERS, MILL TO BEAR AND DO NOT WELD

I HEREBY CERTIFY THAT ALL WELDS ARE SATISFACTORILY COMPLETED AS SHOWN ABOVE

SIGNATURE DATE

MATERIALS & TESTS UNIT WELD INSPECTOR

NOTE:

STEEL FOR BEAM REPAIR SECTION SHALL EQUAL OR EXCEED THE YIELD STRENGTH OF EXISTING BEAM. USE NEW OR SALVAGED "LIKE NEW" STEEL ONLY.

YOU MAY ELECT TO REPLACE THE ENTIRE STIFFENER/CONNECTOR PLATE.

STIFFENER/CONNECTOR PL REPAIR

STIFFENER/CONNECTOR ℄ REPAIR SEQUENCE:

1. COORDINATE SCHEDULE WITH MATERIALS AND TESTS UNIT WELD INSPECTOR AT LEAST FOUR DAYS PRIOR TO ANTICIPATED WORK.

2. CUT OUT BY APPROPRIATE MEANS THE DAMAGED STIFFENER/CONNECTOR PLATES AREA. IF THE CONCRETE DIAPHRAGM INTERFERES WITH THE REPAIR, CHIP AWAY CONCRETE AND REMOVE DAMAGED AREA. (PICTURE REQUIRED)

3. MECHANICALLY CLEAN RUST, SCALE, AND EXISTING PAINT TO AT LEAST 3" BEYOND REPAIR AREA. (PICTURE REQUIRED)

4. INSTALL THE CUT-TO-FIT SECTION, FULLY WELD ALONG TOP AND SIDES OF PLATE AS SHOWN. (PICTURE REQUIRED)

5. ALL WELDING SHALL BE IN ACCORDANCE WITH CURRENT APPLICABLE AWS AND NCDOT STANDARD SPECIFICATIONS.

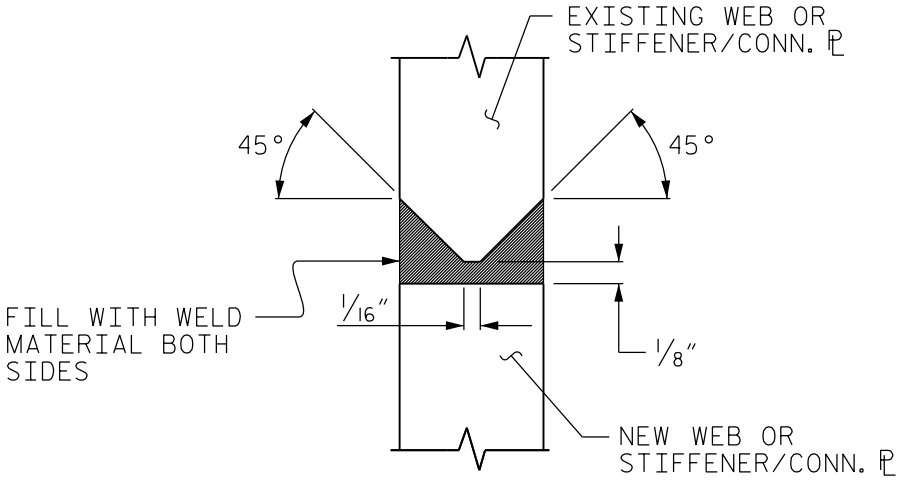
6. ALL WELDS SHALL BE INSPECTED AND TESTED BY THE NCDOT MATERIALS AND TESTS UNIT IN ACCORDANCE WITH THE CURRENT AWS BRIDGE WELDING CODE AND STANDARD SPECIFICATIONS. SUBMIT APPLICABLE REPAIR DETAIL SIGNED BY THE WELD INSPECTOR WITH REPAIR PHOTOS.

7. ONCE THE REPAIR IS COMPLETE, GRIND ALL WELDS FLUSH. CLEAN AREA TO REMOVE DEBRIS AND OILS FROM REPAIR PROCESS PRIOR TO CLEANING AND PAINTING. (PICTURE REQUIRED)

8. CLEAN AND PAINT REPAIRED STRUCTURAL STEEL.

9. AFTER STIFFENER/CONNECTOR PLATES ARE REPAIRED AND PAINTED, ANY CONCRETE REMOVED FROM THE BENT DIAPHRAGMS SHALL BE CAST BACK. ANY REINFORCING STEEL CUT DURING THE REMOVAL PROCESS SHALL BE SPLICED WITH A SIMLAR SIZE BAR WITH AT LEAST A ONE FOOT SPLICE TO THE EXISTING STEEL. (PICTURE REQURIED)

STIFFENER/CONNECTOR ℄ REPAIR SEQUENCE


EXISTING WEB OR
STIFFENER/CONN. PL
45°
45°
FILL WITH WELD
MATERIAL BOTH
SIDES
1/16"
1/8"
NEW WEB OR
STIFFENER/CONN. PL

DETAIL A