

**GALVANIZED COATING SYSTEM FOR STRUCTURAL STEEL BRIDGES**

**1.1.1 DESCRIPTION**

IN ADDITION TO THE REQUIREMENTS OF CMS ITEM 513, THIS ITEM SHALL CONSIST OF FURNISHING ALL NECESSARY LABOR, MATERIALS AND EQUIPMENT TO CLEAN AND GALVANIZE ALL STRUCTURAL STEEL SURFACES, AS SPECIFIED HEREIN. THE GALVANIZED COATING SYSTEM MAY BE APPLIED BY A GALVANIZER NOT QUALIFIED AS A FABRICATION SHOP UNDER CMS ITEM 513, BUT THE APPROVED FABRICATOR OF THE STRUCTURAL STEEL SHALL BE RESPONSIBLE FOR THE QUALITY OF THE APPLIED GALVANIZED COATING SYSTEM AND ANY REPAIRS, RE-FABRICATING, ADDITIONAL LAYDOWNS REQUIRED TO ASSURE THE FABRICATED STEEL MEETS ALL REQUIREMENTS OF THIS SPECIFICATION. CMS SECTIONS 513.27 AND 513.28 SHALL NOT APPLY.

THIS ITEM SHALL ALSO INCLUDE GALVANIZING, PER 711.02, OF ALL NUTS, WASHERS, BOLTS, ANCHOR BOLTS.

SHEAR STUDS SHALL BE FIELD WELDED. THE TOP SURFACE OF THE GIRDER TOP FLANGES SHALL BE FINISHED WITH AN APPROVED COATING SYSTEM THAT PREVENTS GALVANIZATION, BUT WILL NOT COMPROMISE THE WELDING OF THE SHEAR STUDS.

**1.1.2 PRE-FABRICATION MEETING**

IN ADDITION TO THE PRE-FABRICATION MEETING REQUIREMENTS UNDER CMS SECTION 513.07, BOTH THE FABRICATOR'S QUALITY CONTROL SPECIALIST, (QCPS) AND GALVANIZED COATING APPLICATOR SHALL BE PRESENT AND DISCUSS METHODS OF OPERATION, QUALITY CONTROL, INCLUDING REPAIRS, TRANSPORTATION, ERECTION METHODS TO ACCOMPLISH ALL PHASES OF THE PREPARATION AND COATING WORK REQUIRED BY THIS SPECIFICATION.

**1.1.3 QUALITY CONTROL**

**1.1.3.1 QUALITY CONTROL SPECIALIST**

THE QCPS (QUALITY CONTROL PAINT SPECIALIST) REQUIRED UNDER CMS SECTION 514.04A, IS RESPONSIBLE FOR ALL QUALITY CONTROL REQUIREMENTS OF THIS SPECIFICATION. THE QCPS SHALL HAVE THE TESTING EQUIPMENT SPECIFIED IN CMS SECTION 514.05.

**1.1.3.2 QUALITY CONTROL POINTS (QCP)**

QUALITY CONTROL POINTS (QCP) ARE POINTS IN TIME WHEN ONE PHASE OF THE WORK IS COMPLETE AND READY FOR INSPECTION BY THE FABRICATOR'S QCPS AND THE DEPARTMENT'S QA REPRESENTATIVE. THE NEXT OPERATIONAL STEP MUST NOT PROCEED UNLESS THE QCP HAS BEEN ACCEPTED OR QA INSPECTION WAIVED BY THE DEPARTMENT'S QA REPRESENTATIVE. AT THESE POINTS THE FABRICATOR MUST AFFORD ACCESS TO INSPECT ALL AFFECTED SURFACES. IF INSPECTION INDICATES A DEFICIENCY, THAT PHASE OF THE WORK MUST BE CORRECTED IN ACCORDANCE WITH THESE SPECIFICATIONS PRIOR TO BEGINNING THE NEXT PHASE OF WORK. DISCOVERY OF DEFECTIVE WORK OR MATERIAL AFTER A QUALITY CONTROL POINT IS PAST OR FAILURE OF THE FINAL PRODUCT BEFORE FINAL ACCEPTANCE, MUST NOT IN ANY WAY PREVENT REJECTION OR OBLIGATE THE DEPARTMENT TO FINAL ACCEPTANCE.

**1.1.3.2.1 SOLVENT CLEANING (QCP #1)**

THE STEEL MUST BE SOLVENT CLEANED WERE NECESSARY TO REMOVE ALL TRACES OF ASPHALTIC CEMENT, OIL, GREASE, DIESEL FUEL DEPOSITS, AND OTHER SOLUBLE CONTAMINANTS PER SSPC-SP 1 SOLVENT CLEANING. UNDER NO CIRCUMSTANCES MUST ANY ABRASIVE BLASTING BE DONE TO AREAS WITH ASPHALTIC CEMENT, OIL, GREASE, OR DIESEL FUEL DEPOSITS. STEEL MUST BE ALLOWED TO DRY BEFORE BLAST CLEANING BEGINS. THE QCPS SHALL INSPECT AND DOCUMENT THAT THE CLEANING CONFORMS TO SSPC-SPI AND PROVIDE A COVER LETTER LISTING EACH MAIN MEMBER INSPECTED.

**1.1.3.2.2 GRINDING EDGES (QCP #2)**

ALL CORNERS OF THERMALLY CUT OR SHEARED EDGES MUST HAVE A 1/16 INCH [1.6 MM] RADIUS OR EQUIVALENT FLAT SURFACE AT A SUITABLE ANGLE. THERMALLY CUT MATERIAL THICKER THAN 1 1/2 INCH [40 MM] MUST HAVE THE SIDES GROUND TO REMOVE THE HEAT EFFECTED ZONE, AS NECESSARY TO ACHIEVE THE SPECIFIED SURFACE CLEANING. THE QCPS MUST VISUALLY INSPECT AND DOCUMENT THAT THE GRINDING CONFORMS TO THIS SPECIFICATION AND PROVIDE A COVER LETTER LISTING EACH MAIN MEMBER INSPECTED.

**1.1.3.2.3 ABRASIVE BLASTING (QCP #3)**

BEAMS AND GIRDERS MUST BE PREPARED BY THE FABRICATOR TO STEEL STRUCTURES PAINTING COUNCIL (SSPC) GRADE SIX (6) COMMERCIAL BLAST CLEANING PRIOR TO GALVANIZING. ALL MATERIAL MUST BE FREE OF PAINT MARKS. SECONDARY ANGLE, PLATES, BARS AND SHAPES NEED NOT BE BLAST CLEANED.

ABRASIVES MUST ALSO BE CHECKED FOR OIL CONTAMINATION BEFORE USE. A SMALL SAMPLE OF ABRASIVES MUST BE ADDED TO ORDINARY TAP WATER. ANY DETECTION OF AN OIL FILM ON THE SURFACE OF THE WATER MUST BE CAUSE FOR REJECTION. THE QCPS MUST PERFORM AND RECORD THIS TEST AT THE START OF EACH SHIFT.

ALL FINS, TEARS, SLIVERS AND BURRED OR SHARP EDGES THAT ARE PRESENT ON ANY STEEL MEMBER OR THAT APPEAR AFTER THE BLASTING OPERATION MUST BE CONDITIONED PER ASTM A6. WELDING REPAIRS MUST ONLY BE PERFORMED BY THE ITEM 513 FABRICATOR.

THE QCPS MUST VISUALLY INSPECT AND DOCUMENT THAT THE BLAST CONFORMS TO SSPC-SP6, THAT ALL CONDITIONING IS PERFORMED PER ASTM A6, AND PROVIDE A COVER LETTER LISTING EACH MAIN MEMBER INSPECTED.

**1.1.3.2.4 GALVANIZING (QCP #4)**

GALVANIZED PER 711.02 AND THIS SPECIFICATION. COATING THICKNESS MUST BE A MINIMUM OF 4 MILS [100 µm] MEASURED AS SPECIFIED. MATERIAL MUST BE FREE OF IMPERFECTIONS OR DEPRESSIONS CAUSED BY MATERIAL HANDLING. THE FABRICATOR, GALVANIZER AND ERECTOR MUST USE LIFTING CLAMPS OR SOFTENERS FOR HANDLING. PRIOR TO GALVANIZING, SURFACE IMPERFECTIONS MAY BE REPAIRED BY THE FABRICATOR IN CONFORMANCE WITH ASTM A6. IMPERFECTIONS GREATER THAN THE LIMITS ALLOWED BY ASTM A6 MUST BE DOCUMENTED. REPAIR OR REPLACEMENT OF THIS MEMBER WILL BE AT THE DISCRETION OF THE DEPARTMENT.

ALL DAMAGED GALVANIZING MUST BE REPAIRED IN ACCORDANCE WITH ASTM A780, METHOD A1 OR A3.

DOCUMENTATION OF COATING THICKNESS MUST BE PERFORMED BY THE QCPS. THE QCPS MUST RECORD THE GAGE READINGS AND PROVIDE A COVER LETTER LISTING EACH MAIN MEMBER INSPECTED.

**1.1.3.2.5 FAYING SURFACE CLEANING (QCP #5)**

AREAS OF FIELD CONNECTIONS MUST HAVE A UNIFORM GALVANIZED COATING THICKNESS FREE OF LOCAL EXCESSIVE ROUGHNESS WHICH WOULD PREVENT SPLICE PLATES, BEARINGS OR OTHER FIELD CONNECTIONS FROM MAKING INTIMATE CONTACT.

FAYING SURFACES OF THE BOLTED SPLICES MUST BE ROUGHENED IN THE SHOP AFTER GALVANIZING BY HAND WIRE BRUSHING. POWER WIRE BRUSHING IS NOT PERMITTED. ALL FIELD SPLICE BOLT HOLES MUST BE FREE OF ZINC BUILD UP. AFTER GALVANIZING, EACH HOLE MUST BE CHECKED IN THE SHOP BY USING A DRIFT PIN WITH A DIAMETER 1/16 INCH [1.6 MM] GREATER THAN THE DIAMETER OF THE BOLT TO BE USED IN THAT HOLE. CONSIDERATION WILL BE GIVEN TO OTHER METHODS OF TREATING THE FAYING SURFACES IF A WRITTEN REQUEST IS SUBMITTED TO THE OFFICE OF STRUCTURAL ENGINEERING (OSE) IN ACCORDANCE WITH CMS 108.05.

INSPECTION OF THE ROUGHENING OF THE FAYING SURFACES AND CHECKING OF HOLES WITH DRIFT PINS MUST BE PERFORMED BY THE QCPS. ACCEPTANCE OF THE FAYING SURFACES AND HOLES SHALL BE DOCUMENTED BY THE QCPS.

**1.1.3.2.6 SECOND LAY DOWN (QCP # 6)**

AFTER GALVANIZING, MATERIALS MUST BE PLACED IN A SECOND SHOP ASSEMBLY PER CMS SECTION 513.24 TO CHECK ALIGNMENT OF HOLES, SWEEP AND CAMBER AGAINST THE FABRICATORS ORIGINAL RECORDED LAY DOWN DIMENSIONS. THIS SHOP ASSEMBLY MAY BE PERFORMED AT THE GALVANIZERS FACILITY, BY THE FABRICATORS PERSONNEL, IF APPROVED BY THE OSE. THE SECOND LAY DOWN MAY BE WAIVED BY THE OSE IF THE FABRICATOR RECORDS INDIVIDUAL BEAM CAMBERS AND SWEEPS DURING THE FIRST LAY DOWN, AND THE NEW INDIVIDUAL BEAM CAMBERS AND SWEEPS, AFTER GALVANIZING, COMPARED TO THE FIRST LAY DOWN ARE WITHIN THE FOLLOWING TOLERANCES:

BEARING POINTS AFTER GALVANIZING MUST BE WITHIN ± 1/8 INCH [3.2 MM] OF THE APPROVED SHOP DRAWING LAY DOWN.

CAMBER POINTS AFTER GALVANIZING MUST BE + 1/4 INCH [6 MM] OR - 0 INCHES FROM THE FIRST LAY DOWN.

SWEEP POINTS AFTER GALVANIZING MUST BE +/- 3/8 INCH [9 MM] FROM THE FIRST LAY DOWN.

INDIVIDUAL BEAMS THAT EXCEED THE LISTED TOLERANCES MUST BE PLACED WITH AT LEAST TWO ADJACENT BEAMS IN LAY DOWN FOR CHECKING AGAINST THE RECORDED SHOP ASSEMBLY RECORDS PER CMS SECTION 513.04. DOCUMENTATION OF THE SECOND LAY DOWN OR INDIVIDUAL MEMBER CAMBERS MUST BE RECORDED BY THE QCPS PER CMS SECTION 513.24.

**1.1.3.2.7 FIELD REPAIR OF DAMAGED AREAS (QCP #7)**

MATERIAL MUST BE FREE OF IMPERFECTIONS OR DEPRESSIONS CAUSED BY MATERIAL HANDLING. THE CONTRACTOR MUST USE LIFTING CLAMPS OR SOFTENERS FOR HANDLING. IMPERFECTIONS MAY BE REPAIRED BY GRINDING AS ALLOWED BY ASTM A6 BY THE CONTRACTOR. IMPERFECTIONS THAT ARE GREATER THAN THE GRINDING LIMITS ALLOWED BY ASTM A6, MUST BE DOCUMENTED. REPAIR OR REPLACEMENT OF THIS MEMBER WILL BE AT THE DISCRETION OF THE OSE.

ALL DAMAGED GALVANIZING MUST BE REPAIRED IN ACCORDANCE WITH ASTM A780, METHOD A1 OR A3.

DAMAGED GALVANIZING WHICH WILL BE INACCESSIBLE FOR REPAIR AFTER ERECTION MUST BE REPAIRED PRIOR TO ERECTION.

IN ORDER TO MINIMIZE DAMAGE TO THE GALVANIZED STEEL, CONCRETE SPLATTER AND FORM LEAKAGE MUST BE WASHED FROM THE SURFACE OF THE STEEL SHORTLY AFTER THE CONCRETE IS PLACED AND BEFORE IT IS DRY. IF THE CONCRETE DRIES, IT MUST BE REMOVED.

TEMPORARY ATTACHMENTS, SUPPORTS FOR SCAFFOLDING AND FINISHING MACHINE OR FORMS MUST NOT DAMAGE THE COATING SYSTEM. IN PARTICULAR, SUFFICIENT SIZE SUPPORT PADS MUST BE USED ON THE FASCIA WHERE BRACING IS USED.

DOCUMENTATION OF GALVANIZING REPAIRS MUST BE PERFORMED BY THE QCPS BY A COVER LETTER LISTING EACH MAIN MEMBER INSPECTED.

**1.1.3.2.8 FINAL REVIEW (QCP # 8)**

AFTER THE ERECTION WORK HAS BEEN COMPLETED, INCLUDING ALL CONNECTIONS AND THE APPROVED REPAIR OF ANY DAMAGED BEAMS, GIRDERS OR OTHER STEEL MEMBERS, AND THE DECK HAS BEEN PLACED, THE CONTRACTOR AND ENGINEER MUST INSPECT THE STRUCTURE FOR DAMAGED COATING. (QCP #8). DAMAGED AREAS MUST BE REPAIRED BY QCPS #7. AT THE COMPLETION OF CONSTRUCTION, THE GALVANIZING MUST BE UNDAMAGED AND THE SURFACES FREE FROM GREASE, OIL, CHALK MARKS, PAINT, CONCRETE SPLATTER OR OTHER SILAGE. SUCH SILAGE WILL BE REMOVED BY SOLVENT CLEANING PER SSPC-SPI (QCP #1)

DOCUMENTATION OF FINAL REVIEW MUST BE PERFORMED BY THE QCPS BY A COVER LETTER LISTING EACH MAIN MEMBER INSPECTED.

**1.1.4 TESTING EQUIPMENT**

THE FABRICATOR MUST PROVIDE THE QCPS INSPECTOR THE FOLLOWING TESTING EQUIPMENT IN GOOD WORKING ORDER FOR THE DURATION OF THE PROJECT.

ONE (POSITECTOR 2000 OR 6000, QUANIX 2200, OR ELCOMETER A345FB11) AND THE CALIBRATION PLATES, 38-200 MM AND 250-625 MM [1.5 - 8 MILS AND 10-25 MILS] AS PER THE NBS CALIBRATION STANDARDS IN ACCORDANCE WITH ASTM D-1186.



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**BRIDGE GENERAL NOTES**  
BRIDGE NO. MUS-CR66A-0000  
OVER MUSKINGUM RIVER

**MUS - CR66A - 0000**  
PID No. 101730