

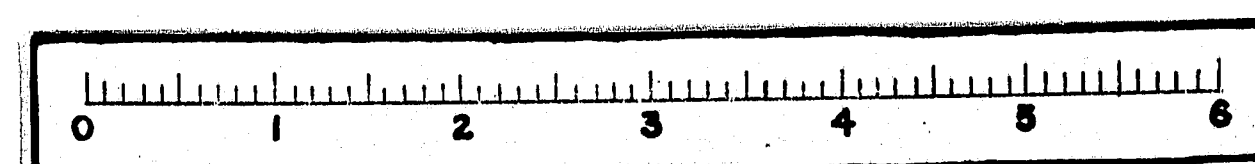
#### GENERAL NOTES:

STEEL ASTM: A572 (GR. 50) @ FLANGES, WEBS AND BRG. STIFFS  
ALL OTHER STEEL IS A36, UNLESS NOTED.  
ERECTION BOLTS TO BE 3/4" M. BOLTS (A307).  
FORM BRACKET HOLES ARE TO BE PLUGGED WITH  
3/4" x 12" CARRIAGE BOLTS, HEADS TO BE ON OUTSIDE.  
HOLES TO BE COMPLETELY COVERED, TACK WELD  
NUTS TO GIRDER WEB.

APP. AS NOTED 3-12-71

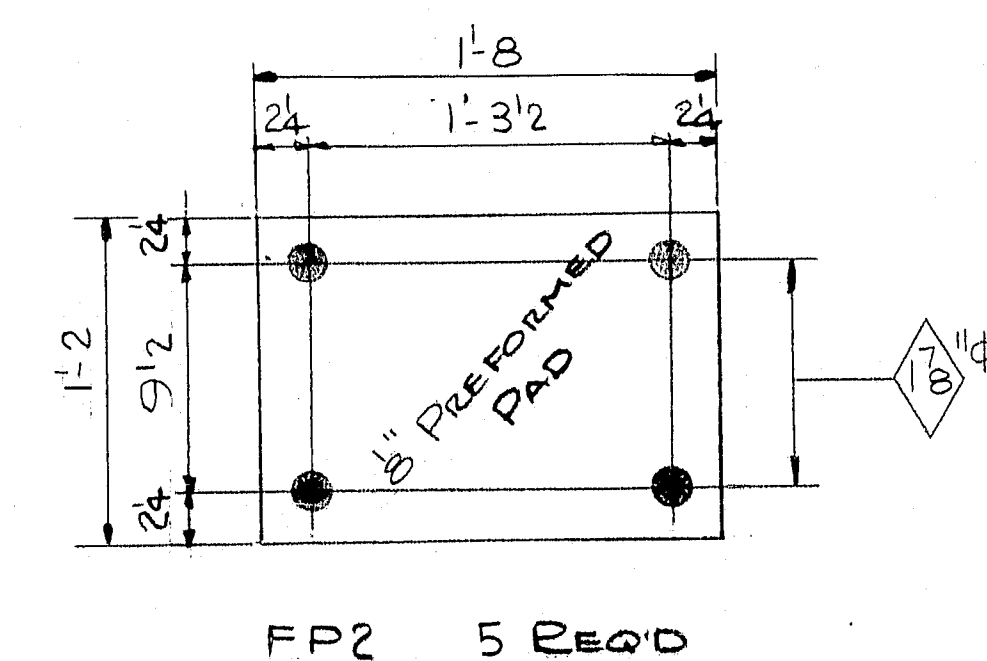
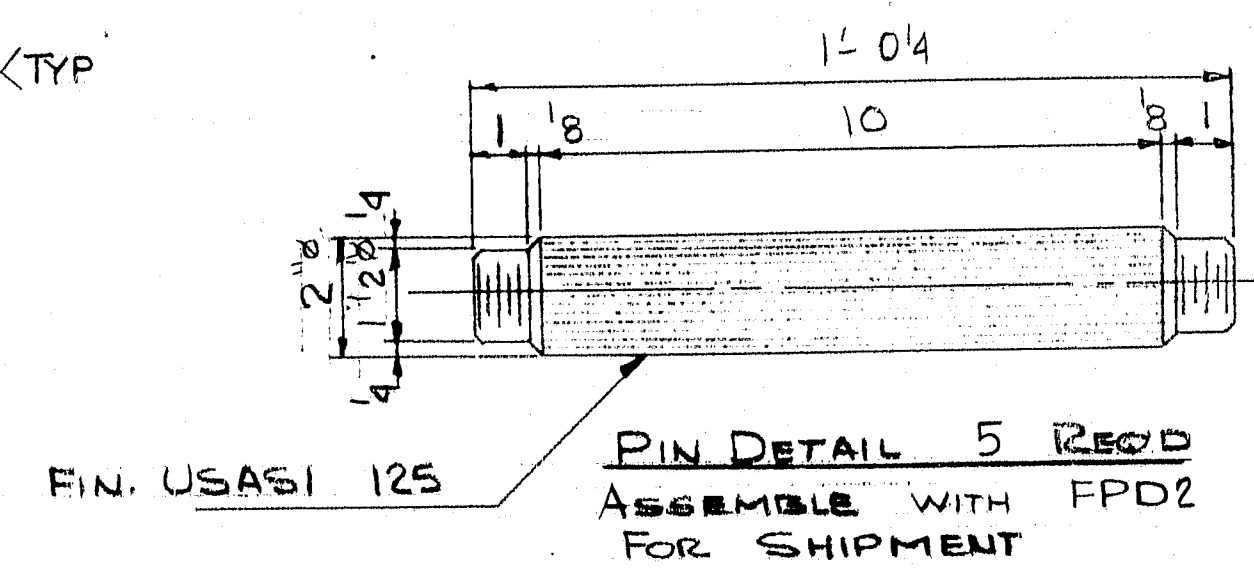
ITEM NO. 504.70	FED. PROJ. NO. I-95-S(37)
FRAMING PLAN & CROSS FRAME DETAILS	
PRINT DIST.	
FA 2-11-71 2	Bancroft & Martin Inc.
BRIDGE 3-18-71 1 SEP.	South Portland, Maine 04106
STATE 3-18-71 6	
CUST. 3-18-71 2	JOB: BIRCH STREAM BRIDGE
	ARGYLE, MAINE
	CUSTOMER: CIAMBRO CORR.
	DESIGNER: ME. STATE H.C. - BRIDGE DIV.
REV.	ORDER NO.
CHECKED 2-8-71 JFF	JOB NO.
DRAWN 11-4-70 ESS	DRAWING NO.
	B70-424 A1

117-138







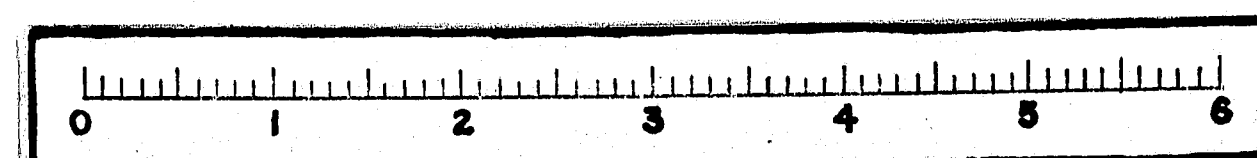


Paint Note :

Technical drawing of a swaged pipe joint. The drawing shows a cross-section of a pipe with a swaged end. The pipe has a diameter of 1 1/2" and a length of 1' 9 1/2". The swaged end is labeled "SWAGED" and has a length of 1' 3". The pipe is labeled "NO PAINT - OIL THREADS". The joint is secured with a nut and washer, labeled "2-HEX STD. NUTS WASHER". The thread is labeled "5" and "THREAD".

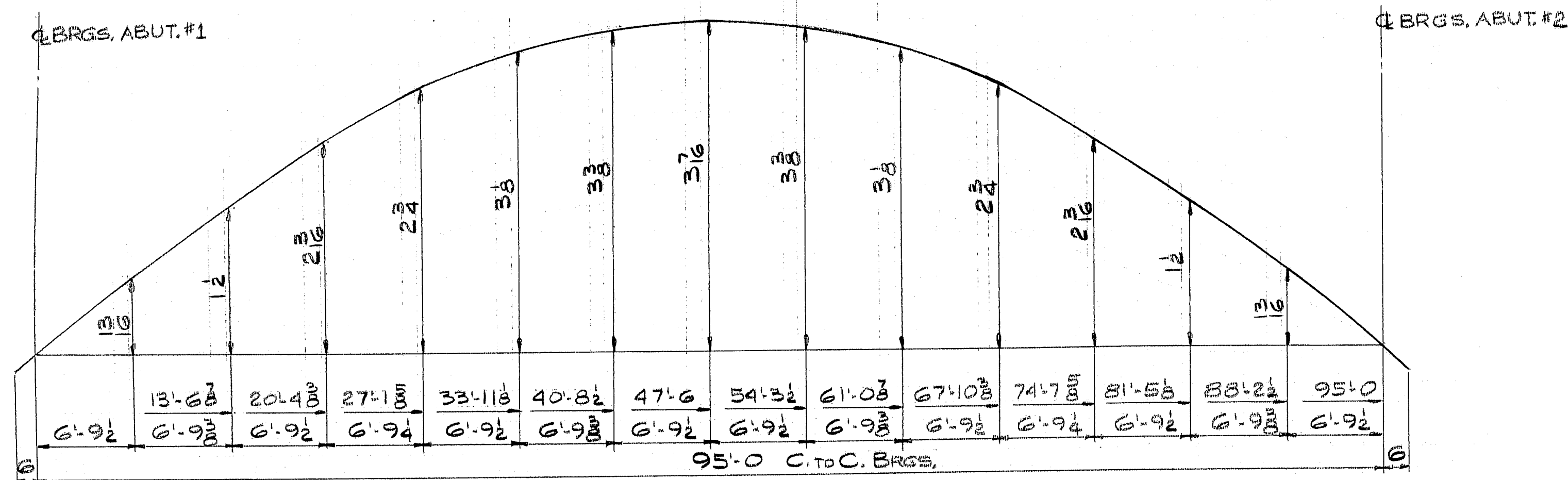
AB2 20 REQ'D

117-140

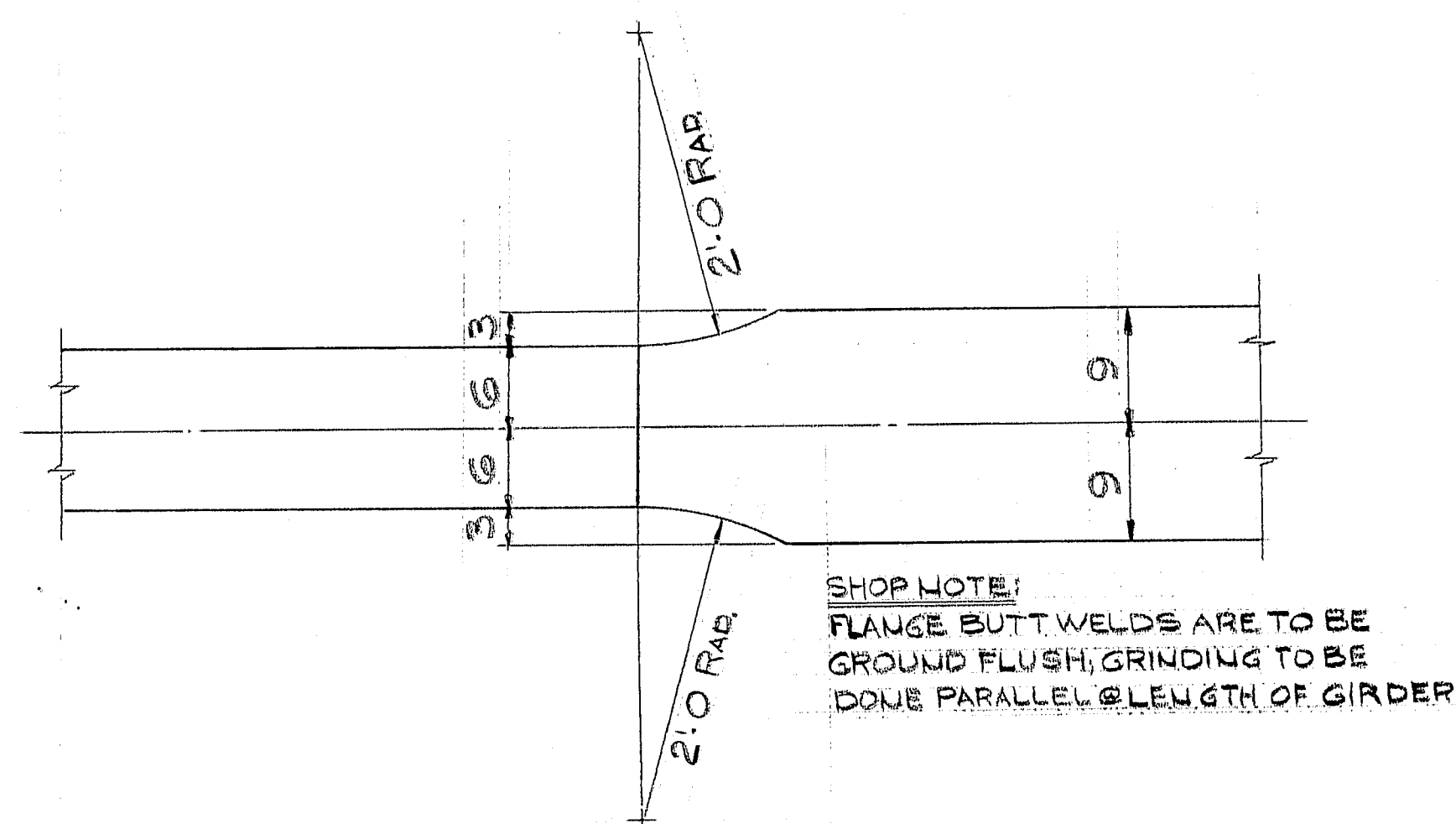




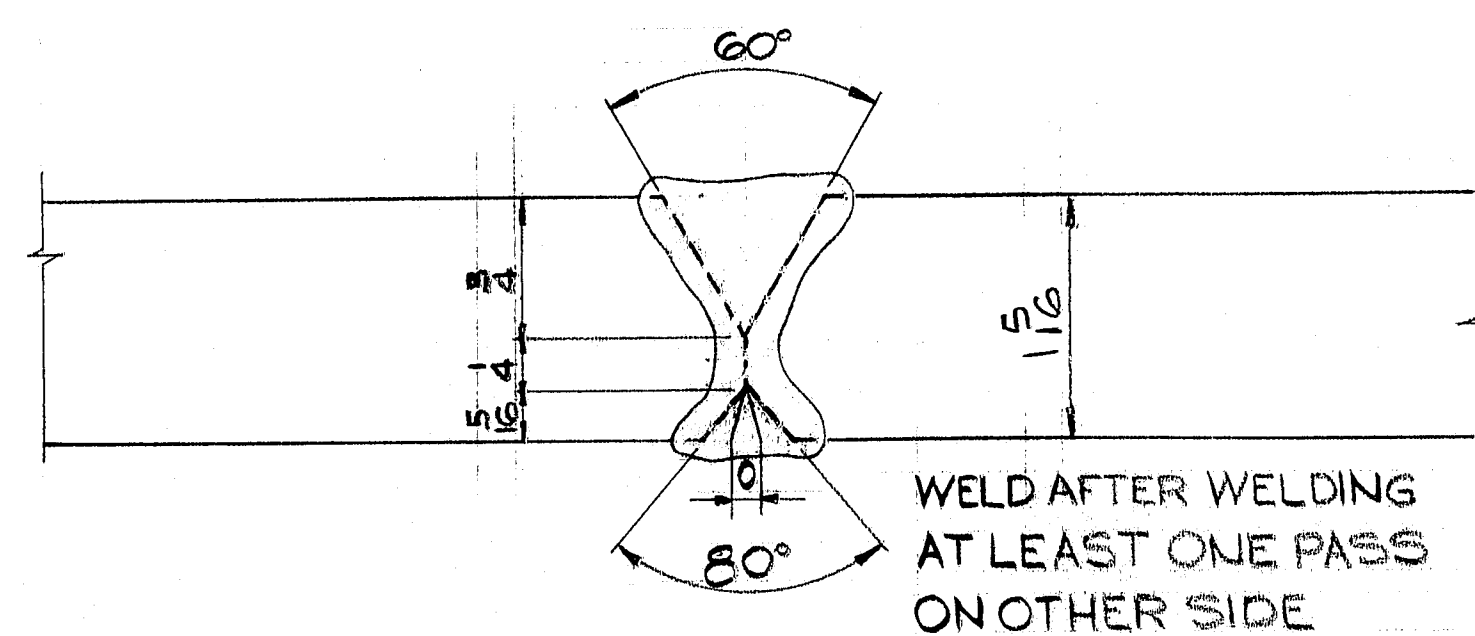




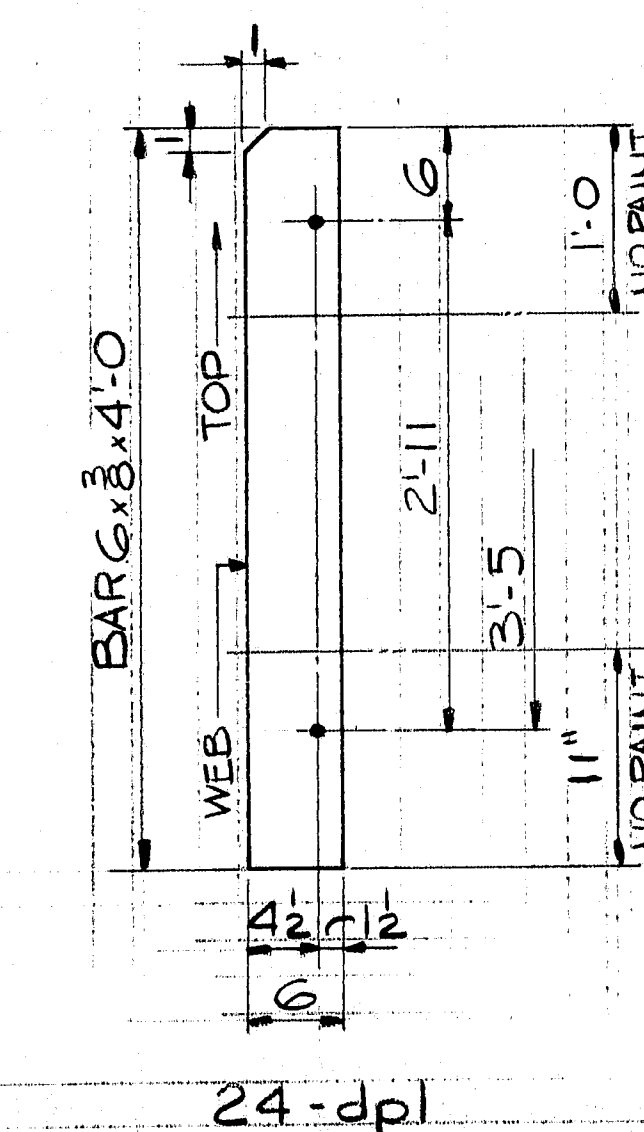
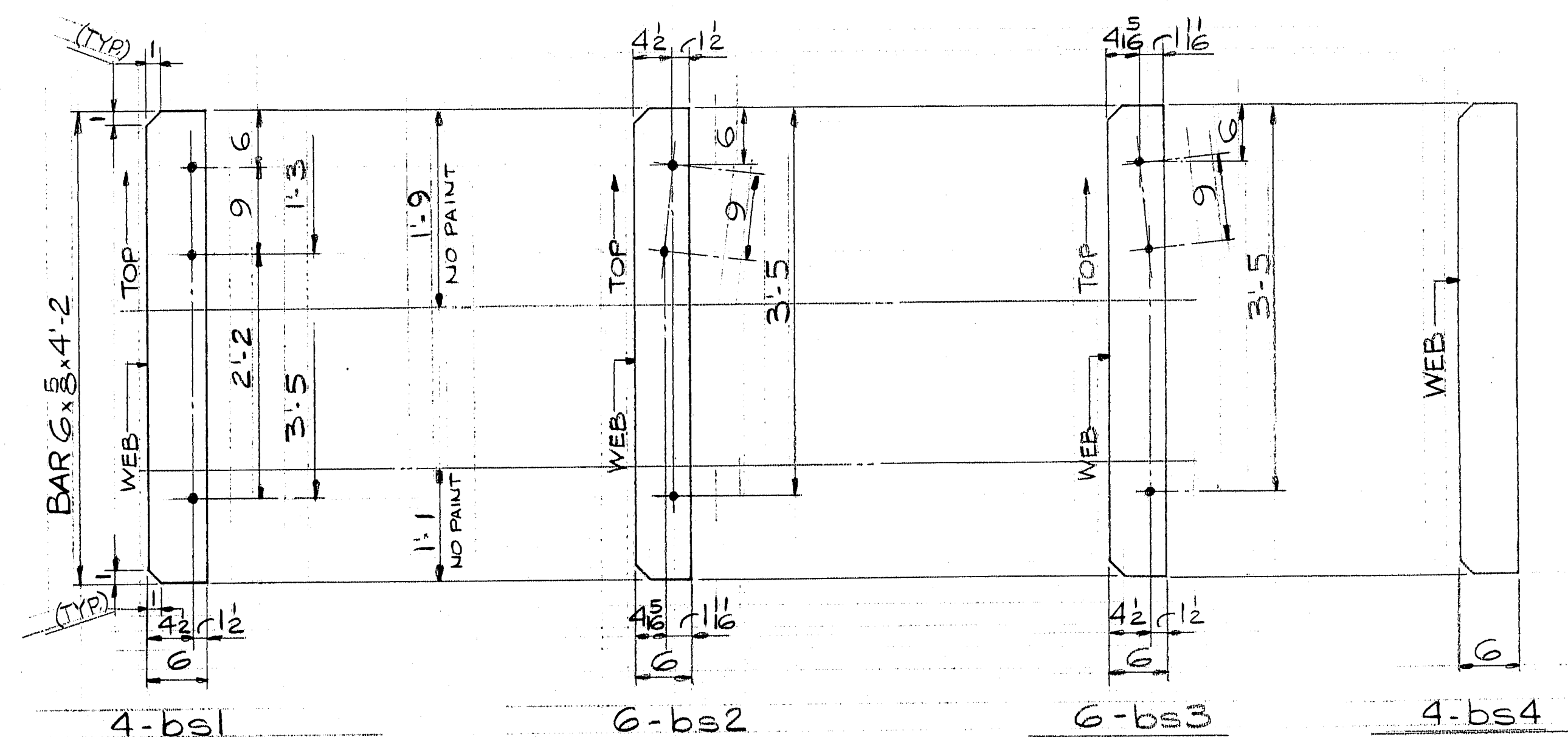
CAMBER DIAGRAM  
TYPICAL ALL GIRDERS



BOTTOM FLG. WIDTH TRANSITION



WA  
B-L3-S



NOTE:

THE FOLLOWING WELDS SHALL BE MADE BY THE AUTOMATIC OR THE SEMI-AUTOMATIC SUBMERGED ARC WELDING PROCESS:

- FLANGE PLATE BUTT JOINTS
- WEB PLATE BUTT JOINTS
- WEB TO FLANGE WELDS
- BEARING STIFFENER TO WEB WELDS

ALL OTHER WELDS MAY BE MADE BY ANY PROCESS APPROVED BY AWS D2.0 - 69 FOR THE PARTICULAR TYPE OF JOINT AND BASE METAL.

WELDING ELECTRODES:

THE FLUX-ELECTRODE COMBINATION FOR AUTOMATIC OR SEMI-AUTOMATIC SUBMERGED ARC WELDING SHALL CONFORM TO THE REQUIREMENTS FOR AWS FLUX DESIGNATION F71-XXXX, (FOR A50-A514 & A572 STEEL) F110 (FOR A514).

ELECTRODES FOR MANUAL SHIELDED METAL ARC WELDING SHALL BE AWS CLASSIFICATION E70 LOW HYDROGEN ELECTRODES, (FOR A50-A572 STEEL & E11018-M FOR A514 - STEEL).

MINIMUM WELDING PREHEAT TEMPERATURES:

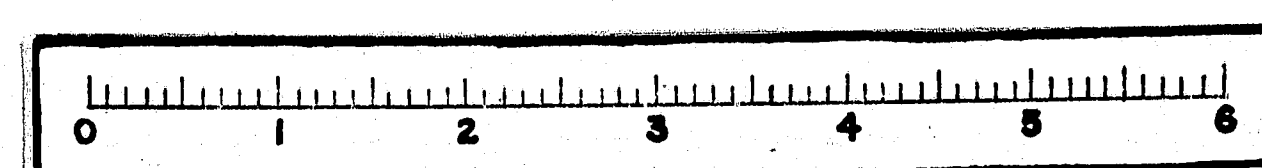
A50-A572 STEEL	THICKNESS	PREHEAT
50° F	FOR THICKNESS OF THICKEST PART TO 3/4" INCLUSIVE.	
150° F	" " " " " OVER 3/4" TO 1-1/2" INCLUSIVE.	
175° F	" " " " " OVER 1-1/2" TO 2-1/2" INCLUSIVE.	

WELDING AND INSPECTION SHALL CONFORM TO THE SPECIFICATIONS FOR WELDED HIGHWAY AND RAILWAY BRIDGES, AWS D2.0-69 AND ADDENDA AND THE SPECIAL PROVISIONS AND SUPPLEMENTAL SPECIFICATIONS FOR THIS PROJECT.

APP: 3-12-71

ITEM NO. 504.70	PROJ. NO. I-95-8(87)
CAMBER DIAG., FLG. WELD & WIDTH TRANS. & DIAP. BS	
PRINT DIST.	
FA 2-11-71 2	Bancroft & Martin Inc.
DRAWN 3-18-71 1 SEP.	South Portland, Maine 04106
STATE 3-18-71 6	
CUST. 3-18-71 2	JOB: BIRCH STREAM BRIDGE
	ARGYLE, MAINE
	CUSTOMER: CIAMBRO INC.
	DESIGNER: M.S.H.C. - BRIDGE DIV.
REV.	ORDER NO. JOB NO. DRAWING NO.
CHECKED 2-8-71 JPF	
DRAWN 11-11-70 ESS	B70-424 C2

117-142





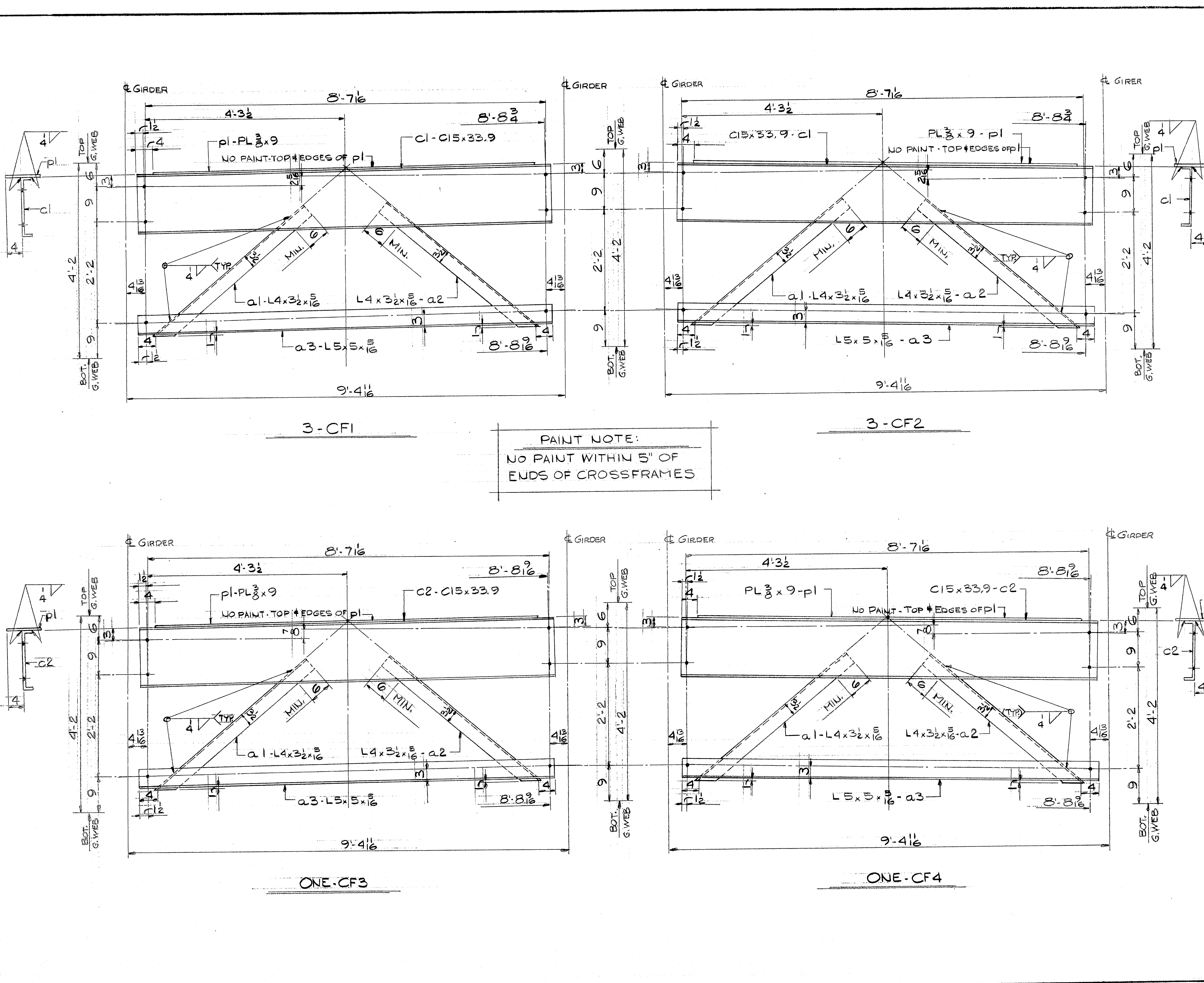






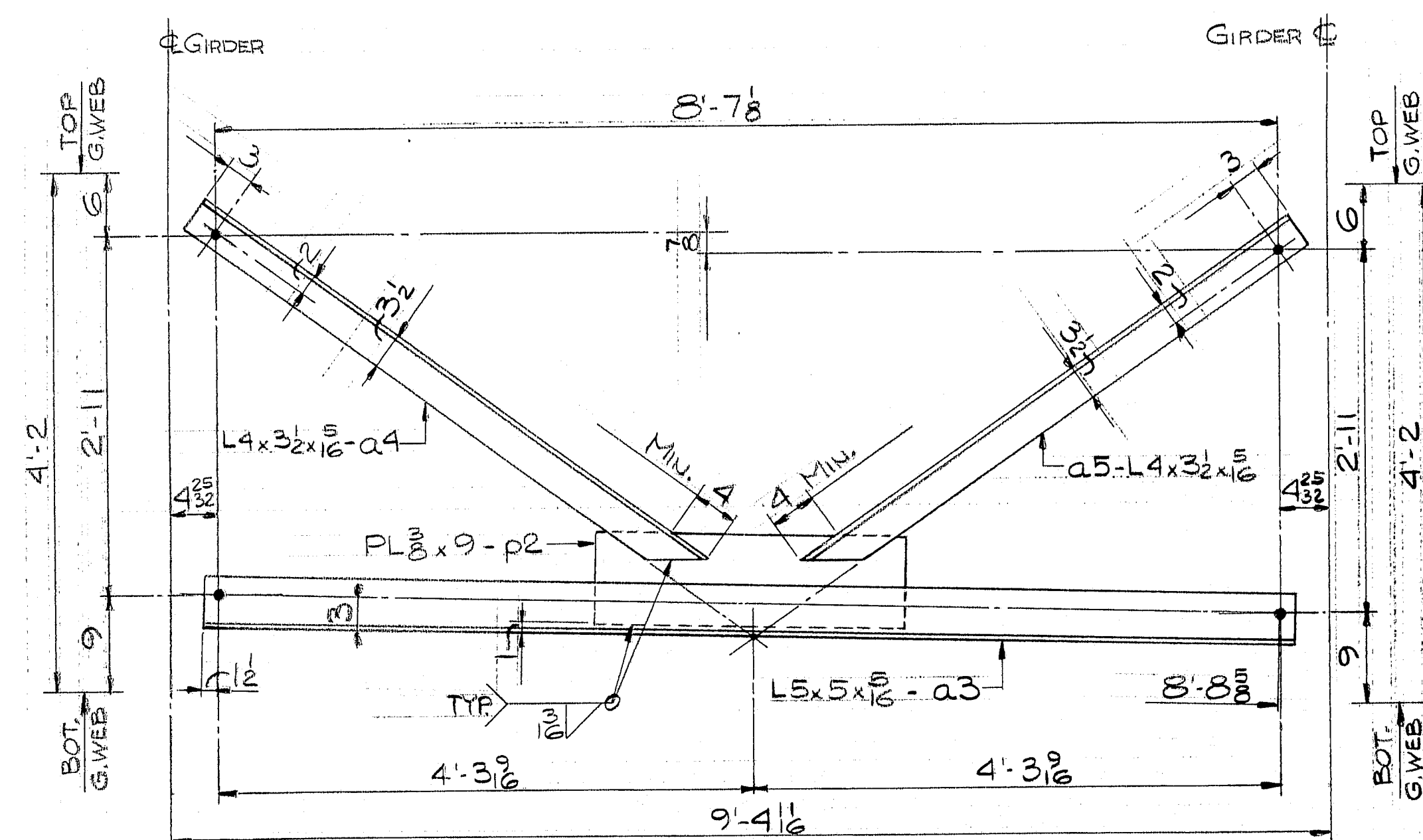
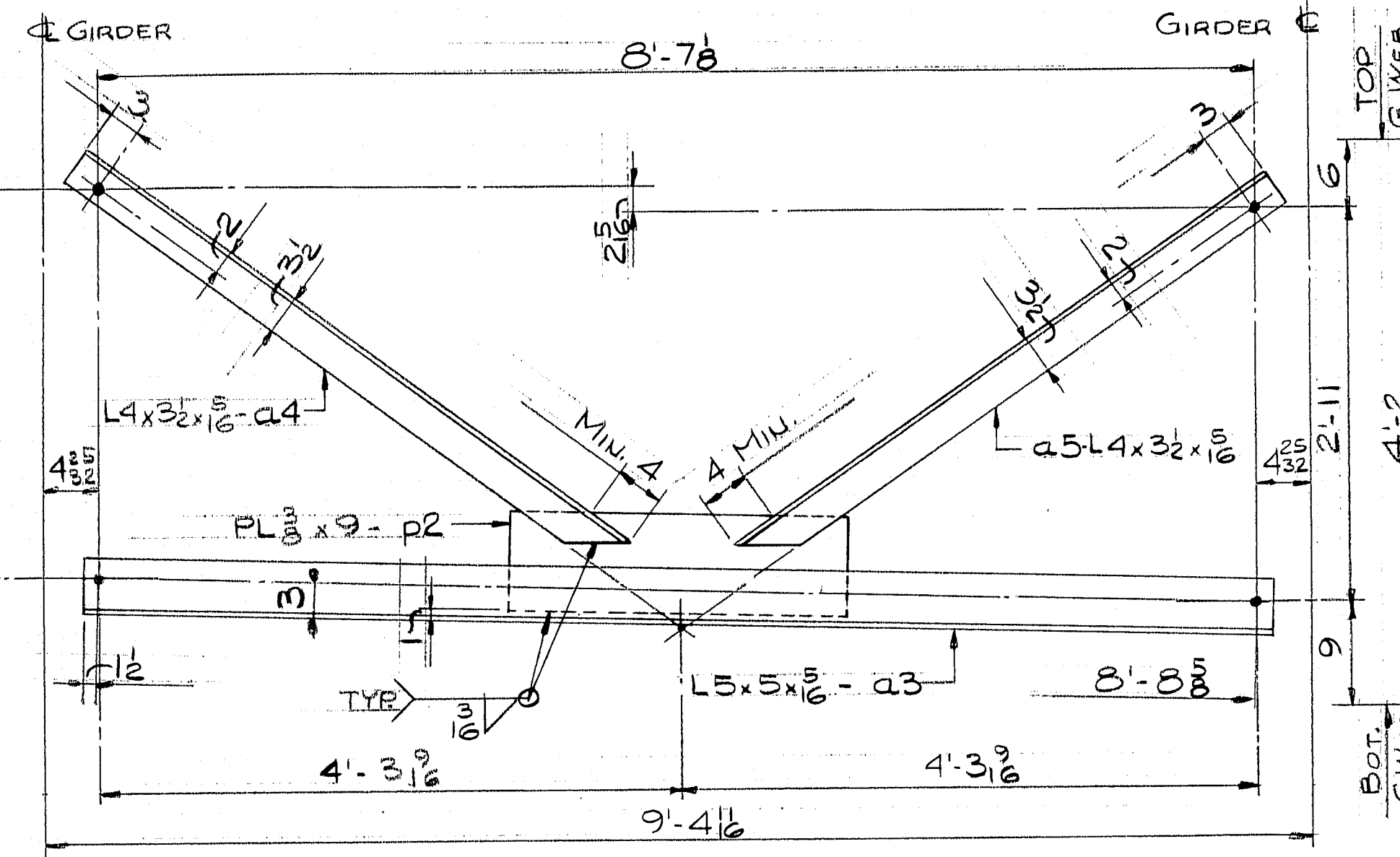
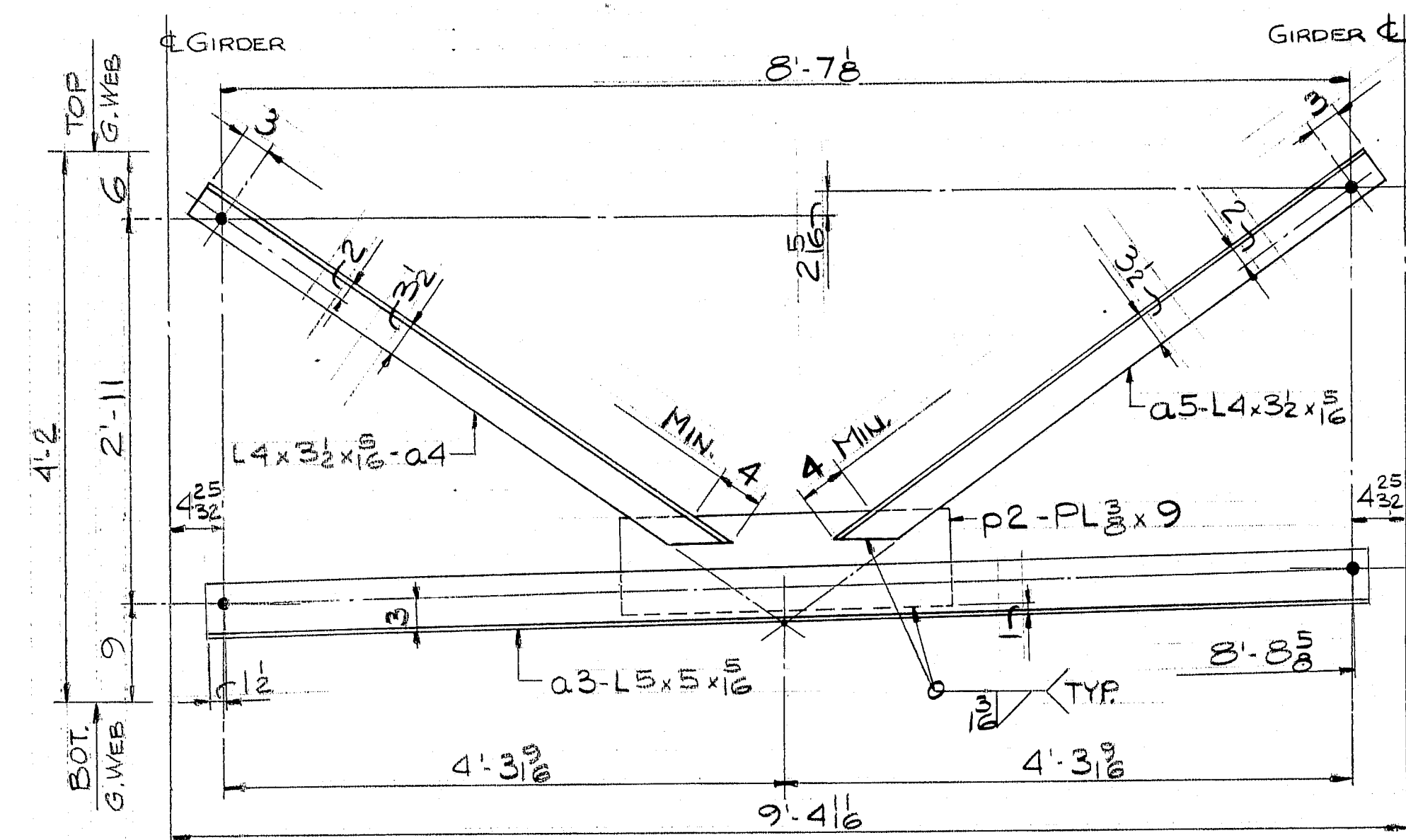






SHIP		BILL OF MATERIAL			JOB NO. B70-424		DWG. NO. P1	
MARK	NO.	MARK	SHAPE	LENGTH	WT.	ITEM NO.	REMARKS	
CF1	3		CROSS FRAME	-	-	-		
CF2	3		do	-	-	-		
CF3	1		do	-	-	-		
CF4	1		do	-	-	-		
		6	C1	C15 x 33.9	8	104	7	
		2	C2	do	8	104	7	
		8	a1	L4 x 3 1/2 x 5/16	4	4	10	
		8	a2	do	4	4	10	
		8	a3	L5 x 5 x 5/16	8	104	12	
		8	P1	PL 3/8 x 9	8	2	9	
FIELD	76		5/8" CARRIAGE BOLTS	0	1 1/2			@ FOAM BRACKETS
FIELD	50		3/4" M. BOLTS	0	2			@ CF1, CF2, CF3, CF4
do	50		do	0	1 1/4			@ CF5, CF6, CF7





PAINT NOTE:  
NO PAINT WITHIN 5" OF  
ENDS OF CROSSFRAMES

[illegible]