

910-R-592 CASTINGS

(Adopted 11-16-11)

The Standard Specifications are revised as follows:

SECTION 910, BEGIN LINE 376, DELETE AND INSERT AS FOLLOWS:

910.05 Castings

The casting design shall be proof loaded to 40,000 *lbs* (178 kN) in accordance with ~~Federal Specifications FF-F-621A~~ *AASHTO M 306*. Castings shall be in accordance with the plan dimensions and to the following requirements for the designated materials. A certified inspection report shall be submitted by the manufacturer with each shipment of castings, except as otherwise provided herein. Inspection and testing shall be done by the manufacturer. The certified inspection report shall list the casting date, casting number, and the type of material, such as gray iron, ductile iron, etc. It shall state that inspection and testing has been performed, that all parts shipped meet the pertinent specification requirements, and that all component parts fit. The supporting test results, including proof load data, shall be retained and be available on request for a period of 7 years. All castings shall have the manufacturer's identification and the date of manufacture cast on an exposed surface. Acceptance of castings will be based on the certified inspection report, visual inspection, and check measurements.

SECTION 910, BEGIN LINE 400, DELETE AND INSERT AS FOLLOWS:

Castings shall be true to pattern in form and dimensions. A tolerance of $\pm 1/8$ in. (± 3 mm) in general dimensions as shown on the plans will be permitted with the exception that the tolerance in the dimensions of grates or covers and the openings into which they fit shall be limited to $\pm 1/16$ in. (2 mm). ~~All~~ *Each* castings shall weigh at least 95% of the *manufacturer's* specified weight (mass) of ~~that~~ *the type specified and shall be* cast to the ~~exact~~ dimensions shown on the plans. They shall be free from sponginess, cracks, blowholes, warping, sand inclusions, cold shots, cold shuts, chilled iron shrinks, or any defects which would affect the strength and value for the intended purpose. The castings shall completely fill the molds and shall not be removed until properly cooled. The casting date and a casting code number shall be cast on each casting.
