

711-B-315 STEEL STRUCTURES

(Revised 01-21-21)

The Standard Specifications are revised as follows:

SECTION 711, BEGIN LINE 451, DELETE AND INSERT AS FOLLOWS:

Paint removal shall be in accordance with 619.08(~~ba~~) and 619.08(~~hi~~). ~~However, pressure washing will not be required.~~ Painting shall be in accordance with 619.09 and 619.10.

SECTION 711, BEGIN LINE 779, DELETE AND INSERT AS FOLLOWS:

(a) Hot Rolled Products

The entire length and perimeter of each fascia beam or girder shall be cleaned in accordance with 619.08(~~ee~~). The entire length and perimeter of each interior beam or girder shall be cleaned in accordance with 619.08(d). Unless otherwise specified, all components such as, but not limited to, diaphragms, cross frames, stiffeners, bearing assemblies, and sway bracing that are permanently incorporated into the structure shall be cleaned in accordance with 619.08(d). Contamination from grease, oil, or shop marking shall be avoided. If such contamination is unavoidable, such surfaces shall be cleaned in accordance with 619.08(~~ba~~).

(b) Welded Area

All exposed welds on fascia surfaces shall be prepared by means of power grinding in accordance with 619.08(~~hi~~) or blast cleaning in accordance with 619.08(~~ee~~) to remove welding flux, slag, scale, or spatter.

SECTION 711, BEGIN LINE 1117, INSERT AS FOLLOWS:

711.68 Structural Steel Cutting, Rivet and Bolt Removal, and Drilled Bolt Holes in Repair Projects

Field cutting of structural steel shall be done as shown on the plans or as directed. *Flame cutting shall not be performed unless approved by the Engineer in coordination with the Department's Bridge Engineering section at Bridgedesignoffice@indot.IN.gov. Approval will be based on a review of the Contractor's proposed flame cutting methods, which shall include written descriptions of the specific methods to be used and measures to be taken to ensure there are no heat affected zones or rough edges.*

Rivets or bolts connecting steel at locations shown on the plans or as directed shall be removed. This work shall be done in a manner that does not damage the surrounding steel. If necessary, such work shall be done by drilling.

Bolt holes shall be drilled as directed in the field. A bolt hole is a hole required for one bolt drilled through any number and thicknesses of metal plates.

SECTION 711, BEGIN LINE 1133, DELETE AND INSERT AS FOLLOWS:

711.70 Field Cleaning and Storage of Weathering Steel

Cleaning of structural steel specified to be left unpainted shall be in accordance with 619.08(~~ba~~) or 619.08(~~fc~~) or as determined by the Engineer, depending on the severity of the soilage. Foreign matter which adheres to the steel after it has been blasted, and which

inhibits formation of the oxide film shall be removed as soon as practical. The use of acids to remove scale and stains will not be allowed.

Storage shall be such to enable free drainage to avoid moisture pockets.
