

**KANSAS DEPARTMENT OF TRANSPORTATION
SPECIAL PROVISION TO THE
STANDARD SPECIFICATIONS, EDITION 2015**

SECTION 744

STRUCTURAL METALS FABRICATION

Page 700-153. Delete the title and replace with the following:

STRUCTURAL METALS FABRICATION

Page 700-153, subsection 744.1, first sentence. Delete this sentence and replace with the following:

Shop fabricate the structural metal according to the Contract Documents.

Page 700-155, subsection 744.2d.(9). Deleted this subsection and replace with the following:

(9) Overhead Sign Structures, Cantilever Sign Structures, Bridge Mounted Sign Attachments, High Mast Light Poles, Lighting and Traffic Signal Poles.

(9.1) Except as noted in (9.2), nondestructively test 100% of all complete joint penetration (CJP) groove welds.

(9.1.1) Use Radiography Testing (RT) or Ultrasonic Testing (UT) when the thickness of the thinnest connecting material is 1/4 inches or more.

(9.1.2) Except as noted in (9.1.3), use Magnetic Particle Testing (MT) when the thickness of the thinnest connecting material is less than 1/4 inches.

(9.1.3) Use RT for all CJP welds in High Mast Light Poles when the thickness of the thinnest connecting material is less than 1/4 inches.

(9.2) For mast arms having an OD of less than 6 inches (measured anywhere along its length), MT 100% of the mast arm to pole connection CJP welds on a random 1 out of 4 structures, or fraction thereof.

(9.3) Except as noted in (9.5), inspect partial penetration groove welds and fillet welds on a random 1 out of 4 structures, or fraction thereof. For each structure selected, inspect:

(9.3.1) a minimum of 4 inches out of every 48 inches of all partial penetration groove welds, including the 4 inches nearest a connection. Use MT.

(9.3.2) 100% of all tube-to-transverse plate (i.e. flanges, base plates, connection plate, etc.) welds. Use MT.

(9.3.3) 100% of the perimeter hand hole welds. Use MT.

(9.3.4) 100% of all welds connecting a device or accessory to the tube wall. Use MT.

(9.3.5) 100% of the mast arm-to-pole connection welds when the OD of the mast arm is less than 6 inches (measured anywhere along its length). Use Visible Liquid Penetrant Testing (PT).

(9.4) After galvanizing, UT only those tube-to-transverse plate CJP groove welds noted on the shop drawings as needing this additional inspection.

(9.5) For all aluminum alloy structures or structural components, use PT to inspect partial penetration groove welds and fillet welds as follows:

(9.5.1) 100% of all tube-to-transverse plate (i.e. – base plate, flange plate, etc.) welds.

(9.5.2) 100% of all stiffener/connection plate welds at base plate. Inspect welds to base plate and to main member.

(9.5.3) 100% of all connection/stiffener/gusset plate welds at flanged connections in truss or end supports. Inspect welds to flange and to main member.