



Florida Department of Transportation

RICK SCOTT
GOVERNOR

605 Suwannee Street
Tallahassee, FL 32399-0450

ANANTH PRASAD, P.E.
SECRETARY

December 30, 2013

Chad Thompson
Programs Operations Engineer
Federal Highway Administration
545 John Knox Road, Suite 200
Tallahassee, Florida 32303

Re: State Specifications and Estimates Office
Section **460**
Proposed Specification: **4600501 Structural Steel and Miscellaneous Metals.**

Dear Mr. Thompson:

We are submitting, for your approval, two copies of the above referenced Supplemental Specification.

This change is proposed to correct a typographical error.

Please review and transmit your comments, if any, within two weeks. Comments should be sent via email to SP965DS or daniel.scheer@dot.state.fl.us.

If you have any questions relating to this specification change, please call me at 414-4130.

Sincerely,

Signature on file

Daniel Scheer, P.E.
State Specifications Engineer

DS/dt

Attachment

cc: Florida Transportation Builders' Assoc.
State Construction Engineer

STRUCTURAL STEEL AND MISCELLANEOUS METALS.**(REV 11-22-13)**

SUBARTICLE 461-5.1 is deleted and the following substituted:

460-5.1 General: Use bolts as follows:

1. Use galvanized ASTM A325 Type 1 bolts in all field installed bolted structural steel connections for painted steel.
2. Use either black or galvanized ASTM A 325 Type 1 bolts in all shop installed bolted structural steel connections that will be shop painted.
3. Use black ASTM A325 Type 3 bolts in all bolted structural steel connections for weathering steel that is to remain unpainted.
4. Use the bolts as specified for connected assemblies or parts that are designated as miscellaneous components where the fastener type is specified elsewhere in the Contract Documents.

Tighten ASTM A325 bolts in accordance with the procedures specified below for turn-of-nut or direct-tension-indicator (DTI) tightening.

Lubricate and maintain consistency in lubrication of fastener assembly during Rotational Capacity (RC) testing and installation. Assemblies that exhibit a loss of lubrication, as determined by the Engineer, may be re-lubricated and retested prior to installation.

Use ASTM A490 bolts only with the approval of the Engineer. Provide procedures in accordance with for the handling, lubrication, installation, tightening and testing of ASTM A490 bolts. Do not install ASTM A490 bolts without prior approval of the procedures by the Engineer.

When the Engineer approves ASTM A307 bolts for use in miscellaneous components, tighten them such that the plies of the joint are in firm contact. Use three to five impacts of an impact wrench or the full effort of a person using an ordinary spud wrench to obtain a snug connection.

Fasten aluminum, other materials or assemblies of dissimilar materials in accordance with the Contract Documents.

Install ordinary rough or machine bolts and nuts in accordance with the Contract Documents.

STRUCTURAL STEEL AND MISCELLANEOUS METALS.
(REV 11-22-13)

SUBARTICLE 461-5.1 is deleted and the following substituted:

460-5.1 General: Use bolts as follows:

1. Use galvanized ASTM A325 Type 1 bolts in all field installed bolted structural steel connections for painted steel.
2. Use either black or galvanized ASTM A 325 Type 1 bolts in all shop installed bolted structural steel connections that will be shop painted.
3. Use black ASTM A325 Type 3 bolts in all bolted structural steel connections for weathering steel that is to remain unpainted.
4. Use the bolts as specified for connected assemblies or parts that are designated as miscellaneous components where the fastener type is specified elsewhere in the Contract Documents.

Tighten ASTM A325 bolts in accordance with the procedures specified below for turn-of-nut or direct-tension-indicator (DTI) tightening.

Lubricate and maintain consistency in lubrication of fastener assembly during Rotational Capacity (RC) testing and installation. Assemblies that exhibit a loss of lubrication, as determined by the Engineer, may be re-lubricated and retested prior to installation.

Use ASTM A490 bolts only with the approval of the Engineer. Provide procedures in accordance with for the handling, lubrication, installation, tightening and testing of ASTM A490 bolts. Do not install ASTM A490 bolts without prior approval of the procedures by the Engineer.

When the Engineer approves ASTM A307 bolts for use in miscellaneous components, tighten them such that the plies of the joint are in firm contact. Use three to five impacts of an impact wrench or the full effort of a person using an ordinary spud wrench to obtain a snug connection.

Fasten aluminum, other materials or assemblies of dissimilar materials in accordance with the Contract Documents.

Install ordinary rough or machine bolts and nuts in accordance with the Contract Documents.