



Florida Department of Transportation

RICK SCOTT
GOVERNOR

605 Suwannee Street
Tallahassee, FL 32399-0450

JIM BOXOLD
SECRETARY

MEMORANDUM

DATE: November 9, 2016

TO: Specification Review Distribution List

FROM: Dan Hurtado, P.E., State Specifications Engineer

SUBJECT: Proposed Specification: **9650300 General Provisions for Aluminum Items (Including Welding).**

In accordance with Specification Development Procedures, we are sending you a copy of a proposed specification change.

These changes are proposed by Cheryl Hudson of the State Structures Design Office to update an industry reference.

Please share this proposal with others within your responsibility. Review comments are due within four weeks and should be sent to Mail Station 75 or online at <http://www2.dot.state.fl.us/ProgramManagement/Development/IndustryReview.aspx> . Comments received after **December 7, 2016**, may not be considered. Your input is encouraged.

DH/dt
Attachment

**GENERAL PROVISIONS FOR ALUMINUM ITEMS (INCLUDING WELDING).
(REV 9-19-16)**

ARTICLE 965-3 is deleted and the following substituted:

965-3 Welding Aluminum Sign Structures.

~~The proportioning of Welding and~~ weld details ~~and the operation of welding, for aluminum sign structure,~~ shall be in accordance with Section 514 of the AASHTO ~~Standard~~ LRFD Specifications for Structural Supports for Highway Signs, Luminaries and Traffic Signals; ANSI and AWS D1.2 “Structural Welding Code - Aluminum”, including the requirements for qualifications of procedures and welders, as specified therein.

1. Alloys: The aluminum alloys to welded under these specifications may be any of the following alloys:

Wrought Nonheat-treatable Alloys:

- Alloy 3003
- Alloy Alclad 3004
- Alloy 5052
- Alloy 5083
- Alloy 5086
- Alloy 5456

Wrought Heat-treatable Alloys:

- Alloy 6061
- Alloy 6063
- Cast Heat-treated Alloy
- Alloy SG-70A (ASTM Designation)

2. Filler Metals: The filler metals to be used with particular base metals shall be as shown in the table below except that other filler metals may be used if approved by the Engineer.

Base Metal	Filler Metal
3003 to 3003	ER1100
Alclad 3004 to Alclad 3004	ER4043
5052 to 5052	ER5356*
5083 to 5083	ER5183
5086 to 5086	ER5356*
5456 to 5456	ER5556
6061 to 6061	ER5356*
6063 to 6063	ER5356*
SG-70A to 6061	ER4043
SG-70A to 6063	ER4043

*ER5183, ER5356, and ER5556 may be used interchangeably for these base metals.