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INTEROFFICE MEMORANDUM

DATE: February 13, 2001

TO: Bridge Division Personnel

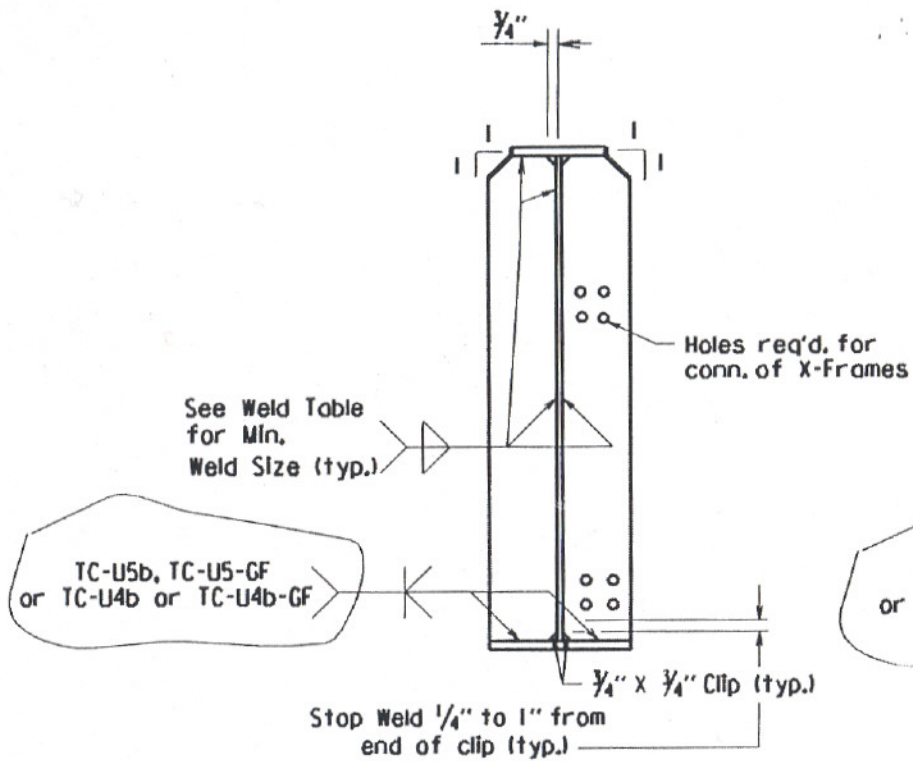
FROM: Jim Tribo, Staff Bridge Design Engineer

SUBJECT: Bearing Stiffener Weld Designation

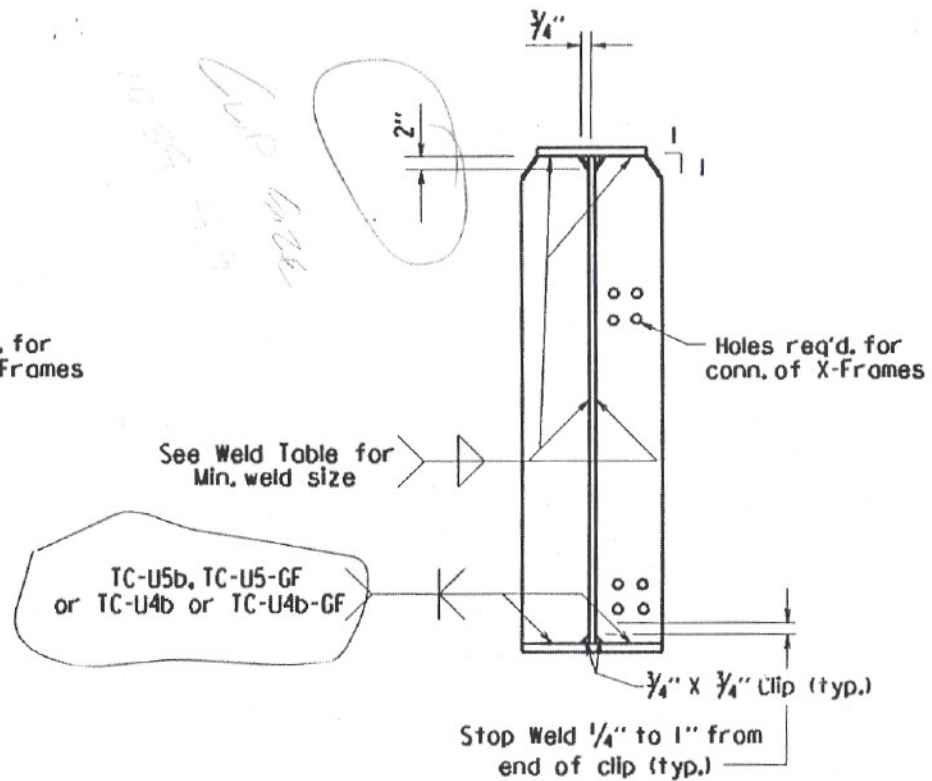
Our Standard Bearing Stiffener Detail designates the weld at the stiffener to bottom flange connection to be TC-U5-S; however, the steel fabricator has, for the last few years, been calling for a joint designated as TC-U4b. The main difference between these welds is that TC-U5-S is a double-bevel-groove weld using the SAW Process and TC-U4b is a single-bevel-groove weld using the SMAW Process. The Fabricator tends to use the single-bevel-groove weld on stiffener plates less than 1" thick. It should be noted that the SAW Process is permitted only in a flat position making it inappropriate for this type joint; and that there is an increased use of automatic welding machines that use the FCAW process.

Since the proper weld is not shown in our detail, and in order to clarify what is an acceptable weld, our standard detail has been amended. Both the double-bevel-groove weld and single-bevel-groove weld are permitted when using either the SMAW or the FCAW process. When reviewing the shop drawings, it is important that one of the following designations: TC-U5b, TC-U5-GF, TC-U4b or TC-U4b-GF is specifically called for at this connection. (See Attachments)

jgt: JGT
Attachments



END BEARING STIFFENER DETAIL



INT. BEARING STIFFENER DETAIL