

**KANSAS DEPARTMENT OF TRANSPORTATION
SPECIAL PROVISION TO THE
STANDARD SPECIFICATIONS, EDITION 2007**

SECTION 705

STRUCTURAL STEEL FABRICATION

Page 700-16, subsection 705.2b.(4), 2nd to the last paragraph. Replace reference to 2002 edition with 2008 edition.

Page 700-16, subsection 705.2b. (4), last paragraph. Insert the following prior to the last sentence:

When T3 steel (any grade) is being welded, perform weld metal Charpy V-Notch testing for Weld Procedure Specification (WPS) qualification at the T3 temperature. Reference T3 following the grade in the material specification section of the WPS for those welds intended for use on T3 base metals and tested accordingly.

Page 700-17, subsection 705.2d. (3). Replace reference to 2002 edition with 2008 edition.

Page 700-17, subsection 705.2d.(11), insert the following after the second paragraph ("For bearings to):

The bearing stiffeners shall be tight fit at the top flange and milled (or ground) to bear at the bottom flange meeting the requirements of the *ANSI/AASHTO/AWS D1.5 Bridge Welding Code*.

This means 75% of the end area of the stiffener shall be "in contact" with the flange. "In contact" is defined as refusing 0.010 inch for 75% of the projected area with no gap more than 1/32 inch for the remaining 25% of the projected area. Fillet weld bearing stiffeners to the web and to both the top and bottom flange.

Page 700-19, subsection 705.2d.(18). Change "addition" to "edition".

Page 700-20, subsection 705.2e., 1st sentence. Replace reference to 2002 edition with 2008 edition.

**Page 700-20, subsection 705.2e. Add a new Section 3.4 as follows:
SECTION 3.4 CONTROL OF DISTORTION AND SHRINKAGE**

Add the following to paragraph 3.4.8:

Do not use mechanical straightening methods without the approval of the Engineer, even when used in conjunction with the application of heat.

Page 700-21, subsection 705.2e., SECTION 6. INSPECTION, PART A. Insert the following at the beginning of this section:

Add the following to paragraph 6.1.1.1:

Within a KDOT project, QC shall not be performed by an inspector or their assistants who are, or were previously, engaged in the welding, the general assembly, or the application of coatings. This requirement also applies to work done under other AWS welding codes.