

MICHIGAN
DEPARTMENT OF TRANSPORTATION

SPECIAL PROVISION
FOR
PERMANENT TRAFFIC SIGNS AND SUPPORTS MATERIALS REVISIONS

STR:MLO

1 of 4

APPR:MJF:REL:05-14-24
FHWA:APPR:06-04-24

Delete subsection 919.07.A shown on pages 9-164 of the Standard Specifications for Construction, in its entirety and replace with the following:

A. Upright Column.

1. Provide steel pipe for the upright column of Type E cantilevers meeting the requirements of:
 - a. ASTM A500/A500M Grade B
 - b. ASTM A1085/A1085M
 - c. ASTM A53/A53M Grade B, Type E or Type S. Hydrostatic testing is not required.
 - d. API-5L Grades X42, X46, or X52. Hydrostatic testing is not required.
 - e. ASTM A572/A572M Grades 42, 50, or 55
 - f. ASTM A709/A709M Grades 36T or 50T
2. Provide steel pipe for the upright column of Type J cantilevers meeting the requirements of:
 - a. A500/A500M Grade B
 - b. ASTM A1085/A1085M
 - c. ASTM A53/A53M Grade B, Type E or Type S. Hydrostatic testing is not required.
 - d. API-5L Grades X42, X46, or X52. Hydrostatic testing is not required.

Upright column with a steel wall thickness greater than 0.5 inch in thickness (nominal) must meet Charpy V-Notch impact requirements (15 foot-pounds at 40 °F) in accordance with AASHTO T243M/T243.

Delete subsections 919.07.B, shown on page 9-165 of the Standard Specifications for Construction, in its entirety and replace with the following:

B. Horizontal Arm.

1. Provide steel pipe for the horizontal arms of Type E cantilevers meeting the requirements of:
 - a. ASTM A500/A500M Grade B
 - b. ASTM A1085/A1085M
 - c. ASTM A53/A53M for Grade B, Type E or Type S. Hydrostatic testing is not required.
 - d. API-5L Grades X42, X46, or X52. Hydrostatic testing is not required.
 - e. ASTM A572/A572M Grades 42, 50, or 55
 - f. ASTM A709/A709M Grades 36 or 50
2. Provide steel pipe for the horizontal arms of Type J cantilevers meeting the requirements of:
 - a. ASTM A500/A500M for Grade B
 - b. ASTM A1085/A0185M
 - c. ASTM A53/A53M for Grade B, Type E or Type S. Hydrostatic testing is not required.
 - d. API-5L Grades X42, X46, or X52. Hydrostatic testing is not required.
 - e. ASTM A519/A519M Grade 4140 annealed

Delete subsections 919.07.I shown on page 9-165 of the Standard Specifications for Construction, in its entirety and replace with the following:

- I. **Galvanizing.** Galvanize cantilever sign supports galvanized in accordance with ASTM A123/A123M. Blast clean fabricated components with a nominal thickness greater than 1/2 inch to remove mill scale and welding slag before galvanizing. For components with a nominal thickness of 1/2 inch or less, blast cleaning can be waived if the galvanizer inspects the material and provides a written statement to the fabricator that blast cleaning is not required. Otherwise blast cleaning is required.

Provide safeguards meeting the requirements of ASTM A384/A384M and ASTM A385/A385M to obtain high-quality galvanized coatings and to minimize distortion and warpage during galvanizing.

Interconnect sections of fabricated pipe work or tube assemblies with open tee or miter joints and provide each enclosed section with a vent hole at each end to provide drainage for the molten zinc and to prevent a hazard to personnel engaged in the galvanizing process.

Delete subsection 919.08.A shown on page 9-166 of the Standard Specifications for Construction, in its entirety and replace with the following:

A. Upright Column.

1. Provide steel pipe for the upright columns of Type C and D trusses meeting the requirements of:
 - a. ASTM A500/A500M Grade B
 - b. ASTM A1085/A1085M
 - c. ASTM A53/A53M for Grade B, Type E or Type S. Hydrostatic testing is not required.
 - d. API-5L Grade X42, X46, or X52. Hydrostatic testing is not required.
2. Provide steel pipe for the upright columns of Type E trusses meeting the requirements of:
 - a. ASTM A500/A500M Grade B
 - b. ASTM A1085/A1085M
 - c. ASTM A53/A53M Grade B, Type E or Type S. Hydrostatic testing is not required.
 - d. API-5L Grade X42, X46, or X52. Hydrostatic testing is not required.

Upright column with a steel wall thickness greater than 0.5 inch in thickness (nominal) must meet Charpy V-Notch impact requirements (15 foot-pounds at 40 °F) in accordance with AASHTO T243M/T243.

Delete subsections 919.08.B shown on page 9-166 of the Standard Specifications for Construction, in its entirety and replace with the following:

B. Horizontal Truss Box.

1. Provide steel pipe for the horizontal truss boxes of Type C and D trusses meeting the requirements of:
 - a. ASTM A500/A500M Grade B
 - b. ASTM A1085/A1085M
 - c. ASTM A53/A53M Grade B, Type E or Type S. Hydrostatic testing is not required.
 - d. API-5L Grade X42, X46, or X52. Hydrostatic testing is not required.
2. Provide steel pipe for the horizontal arms of Type E trusses meeting the requirements of:
 - a. ASTM A500/A500M Grade B

- b. ASTM A1085/A1085M
- c. ASTM A519/A519M Grade 4140 annealed

Delete subsection 919.08.J shown on page 9-167 of the Standard Specifications for Construction, in its entirety and replace with the following:

- J. **Galvanizing.** Galvanize cantilever sign supports galvanized in accordance with ASTM A123/A123M. Blast clean fabricated components with a nominal thickness greater than 1/2 inch to remove mill scale and welding slag before galvanizing. For components with a nominal thickness of 1/2 inch or less, blast cleaning can be waived if the galvanizer inspects the material and provides a written statement to the fabricator that blast cleaning is not required. Otherwise blast cleaning is required.

Provide safeguards meeting the requirements of ASTM A384/A384M and ASTM A385/A385M to obtain high-quality galvanized coatings and to minimize distortion and warpage during galvanizing.

Interconnect sections of fabricated pipe work or tube assemblies with open tee or miter joints and provide each enclosed section with a vent hole at each end to provide drainage for the molten zinc and to prevent a hazard to personnel engaged in the galvanizing process.