

GENERAL NOTES - STRUCTURES

ITEM SPECIAL - SHOP PAINTING AND FIELD TOUCHUP OF STRUCTURAL STEEL (CONT.)

The oldest paint of each kind shall be used first. No paint shall be used which has surpassed its shelf life.

Paint may be considered as eligible for payment for material on hand as specified in 109.07. However, only paint which the contractor can prove to the Engineer will be used during the construction season shall be eligible for payment. The Contractor shall provide the Engineer calculations indicating the total square feet of steel to be painted during the construction season. He shall also provide calculations showing the total number of gallons required. The Contractor shall be responsible to store the paint on the project in such manner to prevent theft and adverse temperatures. He shall provide thermometers capable of monitoring the maximum high and low temperatures within the storage facility. The Contractor is responsible for properly disposing of all unused paint and paint containers.

The Contractor shall furnish shipping invoices for all materials used on the project to the Engineer, prior to use.

MIXING AND THINNING

All ingredients in any container of paint shall be thoroughly mixed immediately before use and shall be agitated often enough during application to maintain a uniform composition; however, the primer shall be continuously mixed by an automated agitation system (Hand held mixers not allowed). Paint shall be carefully examined after mixing for uniformity and to verify that no unmixed pigment remains on the bottom of the container. The paint shall be mixed with a high shear mixer (such as a Jiffy Mixer). Paddle mixers or paint shakers are not allowed. Paint shall not be mixed or kept in suspension by means of an air stream bubbling under the paint surface.

All paint shall be strained after mixing. Strainers shall be of a type to remove only skins and undesirable matter, but not the pigment.

No thinner shall be added to the paint without the Engineer's approval, and only if necessary for proper application as recommended by the manufacturer. When the use of thinner is permissible, thinner shall be added slowly to the paint during the mixing process. All thinning shall be done under supervision of the Engineer. In no case shall more thinner be added than that recommended by the manufacturer's printed instructions. Only thinners recommended and supplied by the paint manufacturer may be added to the paint. No other additives shall be added to the paint.

Catalysts, curing agents, or hardeners which are in separate packages shall be added to the base paint only after the base paint has been thoroughly mixed. The proper volume of the catalyst shall then be slowly poured into the required volume of base with constant agitation. Liquid which has separated

from the pigment shall not be poured off prior to the mixing. The mixture shall be used within the pot life specified by the manufacturer. Therefore only enough paint shall be catalyzed for prompt use. Most mixed, catalyzed paints cannot be stored, and unused portions of these shall be discarded at the end of each working day.

COATING APPLICATION

General

All structural steel, scuppers, bulb angles, expansion joints, steel railing, exposed steel piling, drain troughs, galvanized surfaces and other areas indicated on the plans shall be painted unless otherwise noted in the plans.

Galvanized surfaces to be embedded in concrete and surfaces in contact with seals, shall be masked and receive no paint.

All areas where field welding is required shall be masked prior to shop coating and receive no paint.

The top of flanges shall receive the prime coat only.

Areas to receive studs shall not be masked but paint shall be removed before studs are applied.

Treatment of Faying Surfaces

Surfaces indicated below shall be treated according to Method A or Method B as described in this specification:

1. Faying surfaces of main beam or girder bolted field splices.
2. All internal contact surfaces of filler and splice plates.
3. Other surfaces indicated in the plans.

Bolted crossframes on straight beams or girders do not need to meet the requirements of Method A or Method B unless indicated otherwise in the plans.

Method A

The faying surfaces shall be coated with inorganic zinc primer.

The coating of these faying surfaces with the inorganic zinc-rich primer shall be done by using a double masking technique. First, the areas adjacent to the faying surfaces shall be tightly masked and the inorganic zinc primer applied. After this primer has dried sufficiently enough to avoid damage, the faying surfaces shall be masked and the remainder of the girder shall be coated with the organic zinc-rich primer and subsequent coats.

All bolted shop connections and bolted cross frames shall be removed and disassembled prior to the blasting and coating of the girders or beams. The parts shall be blasted separately and primed, then reassembled and the bolts fully tightened using the turn of the nut method.

Method B

The faying surfaces shall be coated with organic zinc primer only per this specification. In order to use Method B, the primer shall be tested in accordance with the methods described in "Allowable Stress Design Specification for Structural Joints Using ASTM A325 or A490 Bolts". Testing shall include slip tests and tension creep tests. A minimum slip coefficient of 0.33 shall be attained.

Testing shall be performed by an accredited laboratory at the Contractor's expense. Certified test results shall be furnished to the Engineer. Documentation shall also include certification that the essential variables (defined in section 1.2, Appendix A, of the Structural Joints Specification) used in the testing are the same as those used in the paint provided for the structure.

All galvanized components, including galvanized nuts, bolts, and washers, shall be solvent cleaned after installation. The epoxy tiecoat, epoxy coat and the urethane protective coat shall then be applied.

Temporary erection marks added by the fabricator to highlight or enhance the required steel stamped erection marks shall be made without damaging the paint system. Temporary erection marks shall be applied only after the finish coat is cured and shall be removed at the end of the project.

Unless otherwise specified, all coats shall be applied by spray.

The Contractor for field application and the Fabricator for shop application, shall supply the Engineer with the product data sheets before any coating is done. The product data sheets shall indicate the mixing and thinning directions, the recommended spray nozzles and pressures and the minimum drying time for shop applied coats.

PLOT SUBMITTED: 27-OCT-1998 07:17

SHOP.DGN

PLOTTED BY: coop2
PLOT FILE: C:\Users\jkruse\OneDrive\Documents\12035\Bldg\Structure\johnshop.dgn

DESIGN AGENCY
O. D. O. T.
DISTRICT TWELVE
L&D DEPARTMENT



DATE
08/20/98
REVIEWED
MJM
STRUCTURE FILE NUMBER
4305019

DRAWN
JMB
REVISED

DESIGNED
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SHOP PAINTING AND FIELD TOUCH-UP
OF STRUCTURAL STEEL NOTES

LAKE COUNTY
LAK-90-26.87

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