
Special Provision to Item 650

Overhead Sign Supports



Item 650, "Overhead Sign Supports" of the Standard Specifications is amended with respect to the clauses cited below. No other clauses or requirements of this Item are waived or changed.

Section 650.3.3., "Fabrication," is voided and replaced with the following:

Fabrication. Fabricate and weld in accordance with Item 441, "Steel Structures," AWS D1.1, *Structural Welding Code—Steel*, and the requirements of this Item.

Fabrication plants that produce overhead sign support structures must be approved in accordance with [DMS-7380](#), "Steel Non-Bridge Member Fabrication Plant Qualification." The Materials and Tests Division maintains a [Material Producer List \(MPL\)](#) of approved overhead sign support structure fabrication plants.

For monotube type overhead sign supports fabricated with seam-welded pipe, locate the longitudinal seam weld at the neutral axis during the bending process of the post.

For cantilevered-truss type overhead sign support columns with diameters exceeding 30 in., one circumferential complete joint penetration weld splice is permitted per column. Locate the splice at a minimum height of half the column length. Provide mounting channels for the installation of traffic control devices unless otherwise shown on the plans.

Provide 100% ultrasonic testing (UT) in accordance with the AWS D1.1, *Structural Welding Code - Steel*, on all circumferential butt joint weld splices of:

- monotube type posts, and
- cantilevered-truss type columns.

UT acceptance and rejection criteria must be in accordance with AWS D1.1, for cyclically loaded nontubular connections in tension.

For alternate design cantilevered-truss type overhead sign support columns, perform at least 10% UT on longitudinal seam welds with a Department approved procedure to ensure minimum specified penetration. Perform testing at a minimum of three locations on each column (top, middle, and bottom). The minimum length of each test area must be 10 in. If minimum specified penetration is not achieved in any of the tested areas, test an additional 24 in. beyond the originally selected test areas requiring the specified minimum penetration. Test the entire column seam weld if any locations within the additional 24 in. test areas does not achieve the specified minimum penetration. Repair the deficient areas with a Department approved repair procedure and retest.

Measure required dimensions of truss type overhead sign support structures including the following:

- camber of overhead sign bridge trusses (in vertical position), and
- rise of cantilever overhead sign support trusses (in horizontal position).

Shop assemble monotube type overhead sign supports in the horizontal position to ensure specification compliance for all required dimensions, alignment, geometry, and fit.

Permanently mark sign support base plates with the fabrication plant's insignia. For monotube type supports, place the mark on the base plate adjacent to the hand hole access compartment.

Conformance to plans and other approved drawings does not relieve the Contractor of responsibility for proper fit of components.

Section 650.34., "Galvanizing," is voided and replaced with the following:

Galvanizing. Provide punched, drilled, or mechanically guided thermal-cut holes in steel parts or members, when allowed, before galvanizing. Mechanically guided thermal-cut hole quality should be per Item 445, "Galvanizing." Hot-dip galvanize all fabricated parts in accordance with Item 445, "Galvanizing."