



# Wisconsin Department of Transportation

June 28, 2018

## Division of Transportation Systems Development

Bureau of Project Development  
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Madison, WI 53705

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### NOTICE TO ALL CONTRACTORS:

**Proposal #11: 2984-27-71**  
**Various Locations**  
**Heat Straightening Bridge Girders**  
**Var Hwy**  
**Milwaukee County**

### Letting of July 10, 2018

This is Addendum No. 01, which provides for the following:

#### Special Provisions:

Revised Special Provisions	
Article No.	Description
10	Structure Overcoating Cleaning and Priming B-40-208, Item 517.3000.S.01; B-40-271, Item 517.3000.S.02; B-40-939, Item 517.3000.S.03; B-40-360, Item 517.3000.S.04; B-64-039, Item 517.3000.S.05; B-64-019, Item 517.3000.S.06.
15	Heat Straightening of Damaged Girders B-40-208, Item SPV.0105.01; B-40-271, Item SPV.0105.02; B-40-939, Item SPV.0105.03; B-40-360, Item SPV.0105.04; B-64-039, Item SPV.0105.05; B-64-019, Item SPV.0105.06.

#### Schedule of Items:

Revised Bid Item Quantities					
Bid Item	Item Description	Unit	Old Quantity	Revised Quantity	Proposal Total
SPV.0060.02	Steel Crack Repair B-40-271	EA	3	2	5

**Plan Sheets:**

<b>Revised Plan Sheets</b>	
<b>Plan Sheet</b>	<b>Plan Sheet Title (brief description of changes to sheet)</b>
50	Structural Plan – Added Repair work to B-40-271.

The responsibility for notifying potential subcontractors and suppliers of these changes remains with the prime contractor.

Sincerely,

*Mike Coleman*

Proposal Development Specialist  
Proposal Management Section

**ADDENDUM NO.01**

**2984-27-71**

**June 28,2018**

**Special Provisions**

10. **Structure Overcoating Cleaning and Priming B-40-208, Item 517.3000.S.01; B-40-271, Item 517.3000.S.02; B-40-939, Item 517.3000.S.03; B-40-360, Item 517.3000.S.04; B-64-039, Item 517.3000.S.05; B-64-019, Item 517.3000.S.06.**

*Replace entire section titled **A.1 Areas to be Cleaned and Painted** with the following:*

**A.1 Areas to be Cleaned and Painted**

Structure B-40-208

Two Coat Area: 21 SF with SP 11 cleaning.

Structure B-40-271

Two Coat Area: 200 SF with SP 11 cleaning.

Structure B-40-360

Two Coat Area: 428 SF with SP 11 cleaning.

Structure B-40-939

Two Coat Area: 200 SF with SP 11 cleaning.

Structure B-64-019

Two Coat Area: 265 SF with SP 11 cleaning.

Structure B-64-039

Two Coat Area: 70 SF with SP 11 cleaning.

15. **Heat Straightening of Damaged Girders B-40-208, Item SPV.0105.01; B-40-271, Item SPV.0105.02; B-40-939, Item SPV.0105.03; B-40-360, Item SPV.0105.04; B-64-039, Item SPV.0105.05; B-64-019, Item SPV.0105.06.**

*Replace entire section titled **C.11 Final Inspection** with the following:*

**C.11 Final Inspection**

Perform a final arms-length inspection of all surfaces that were repaired or heated. Perform the inspection after the work is complete and cooled to 160 °F or less. Perform non-destructive testing at locations of detected or suspected hairline cracking as part of this inspection. Test these areas using magnetic particle testing. Immediately notify the engineer of any cracking found.

All diaphragm connections adjacent to the areas receiving heat straightening shall be visually and MT inspected for cracks that may have occurred during heat straightening or the cool down process.

**Schedule of Items**

Attached, dated June 28, 2018, are the revised Schedule of Items Page 3.

**Plan Sheets**

The following 8½ x 11-inch sheets are attached and made part of the plans for this proposal:

Revised: 50

END OF ADDENDUM

**GENERAL NOTES**

DRAWINGS SHALL NOT BE SCALED.  
DIMENSIONS SHOWN ARE BASED ON THE ORIGINAL STRUCTURE PLANS AND EXISTING INSPECTION REPORTS. MEASUREMENT DISCREPANCIES SHALL BE INCIDENTAL TO BID ITEMS.  
EXISTING PROTECTIVE SURFACE TREATMENTS AND/OR SURFACE CORROSION AND DEBRIS SHALL BE REMOVED AT LOCATIONS NOTED REQUIRING HEAT STRAIGHTENING. STEEL SURFACE SHALL BE POWER CLEANED BY MECHANICAL MEANS REMOVING ALL PROTECTIVE COATING, RUST, SCALE, DEBRIS OR OTHER DELETERIOUS MATTER IN CONFORMANCE WITH SSPC-SP15.  
BARE STEEL FROM PAINT REMOVALS OF WELDS OF ADJACENT INTERMEDIATE DIAPHRAGM PLATES AND COVER PLATES SHALL BE MAG PARTICLE TESTED (MT) PRIOR TO THE FIELD APPLICATION OF NON-ORGANIC ZINC-RICH PRIMER. DEFICIENCIES SHALL BE REPAIRED PRIOR TO PAINT APPLICATION.  
FIELD PAINTING OF STEEL DUE TO REMOVALS FOR HEAT STRAIGHTENING SHALL BE PAID FOR UNDER BID ITEM "STRUCTURE OVERCOATING CLEANING AND PRIMING".  
THE COLOR OF THE FINISH TOP COAT SHALL MATCH EXISTING GIRDER TOP COAT AS APPROVED BY THE ENGINEER.  
EXTENTS OF REPAIRS ARE ESTIMATED BASED ON FIELD OBSERVATIONS. EXTENT AND AREAS SHALL BE DETERMINED BY FIELD ENGINEER. SEE SPECIAL PROVISIONS FOR REQUIREMENTS.

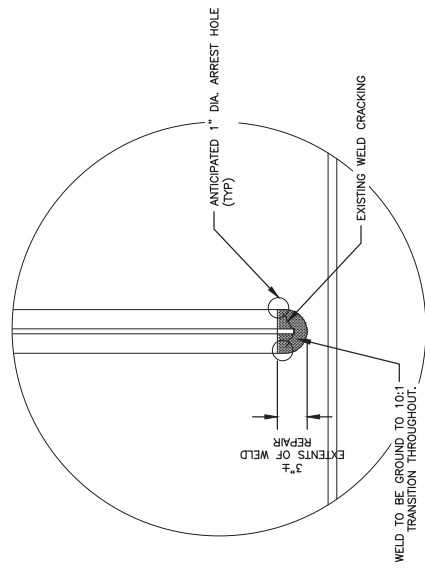
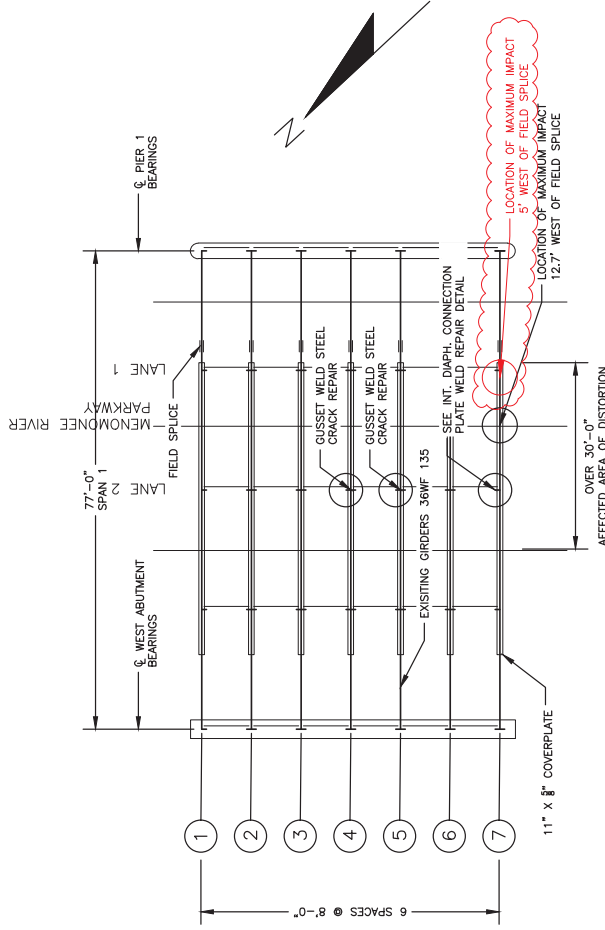
**WORK TO BE PERFORMED**

- REMOVE PROTECTIVE COATING AND ALL DELETERIOUS MATERIAL FROM STEEL SURFACE AT LOCATIONS REQUIRING HEAT APPLICATION.
- HEAT STRAIGHTEN ADJACENT WEB AND BOTTOM FLANGE OF FOLLOWING IMPACTED LOCATIONS AND ANTICIPATED LENGTHS:
  - GIRDER 7 - 1' 8" OUT OF PLANE NORTHEAST; BOTTOM FLANGE DISTORTED  $\frac{3}{8}$ " OVER 2'-0" AND 1' OVER 2'-0"
  - MT CENTER DIAPHRAGM CONNECTION BOTTOM GUSSET WELD AND DELINEATE ENDS OF CRACKING.
  - CRACKS THROUGH WEB WITH CRACKS THROUGH TOP AND BOTTOM FLANGES. BASE METAL LOCATE ENDS OF CRACK AND DRILL 1" DIA. ARREST HOLES THROUGH WEB AT CRACK TIPS. BURR GRINDING SHALL BE SUFFICIENT IF THE CRACK HAS NOT PROPAGATED INTO THE BASE METAL.
  - GRIND OUT UNDERCUT AND WELD REINFORCEMENT TO 10:1 MINIMUM SLOPE. REFER TO DETAIL FOR REPAIR EXTENS.
  - BURR GRIND ADDITIONAL GUSSET WELD CRACK NOTED ON PLAN SHEET.
  - CRACKS THROUGH TOP AND BOTTOM FLANGES TO WEB WELD.
  - GIRDER 5 - CENTER DIAPHRAGM, NORTH FACE, TOP GUSSET TO WEB WELD.
  - GIRDER 5 - CENTER DIAPHRAGM, NORTH FACE, BOTTOM GUSSET TO WEB WELD.
  - MT ALL INTERMEDIATE DIAPHRAGM GUSSET WELDS IMMEDIATELY ADJACENT TO AREAS RECEIVING HEAT STRAIGHTENING REPAIRS. NOTIFY ENGINEER OF REGIONAL DEFICIENCIES. GUSSET WELD REPAIR SHALL CONSIST OF BURR GRINDING OUT THE TIP OF THE CRACK. REPAIRED AREA SHALL BE MT TO VERIFY CRACK TIP HAS BEEN ELIMINATED. WELD REPAIRS SHALL BE INCIDENTAL TO THE BID-ITEM HEAT STRAIGHTENING OF DAMAGED GIRDERS.
  - APPLY PRIMER AND TOP COAT TO REMAINING SURFACES WITH REMOVED PAINT FOR HEAT STRAIGHTENING REPAIR.

SEE SPECIAL PROVISIONS FOR STRAIGHTENING TOLERANCES RELATIVE TO DISTORTIONS.

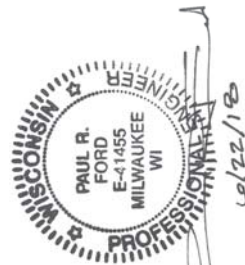
**DESIGN DATA**

MATERIAL PROPERTIES:  
EXISTING SUPERSTRUCTURE STEEL (A.S.T.M. A-36)  $f_y = 36,000$  P.S.I.



*William C. Decker*  
06/26/18

**Addendum No. 01  
ID 2984-27-71  
Revised Sheet 50  
June 28, 2018**



**TOTAL ESTIMATED QUANTITIES**

BID ITEM NUMBER	BID ITEMS	UNIT	TOTALS
517.3000.S	STRUCTURE OVERCOATING CLEANING AND PRIMING (B-40-271).02	LS	1
517.4000.S	CONTAMINANT AND COLLECTION OF WASTE MATERIALS (B-40-271).02	LS	1
517.6001.S	PORTABLE DECONTAMINATION FACILITY (B-40-271).02	EACH	1
SPV.0105	SPECIAL 02. HEAT STRAIGHTENING OF DAMAGED GIRDERS (B-40-271)	LS	1
SPV.0060	SPECIAL 02. STEEL CRACK REPAIR (B-40-271)	EACH	5

**INTERMEDIATE DIAPHRAGM GUSSET WELD REPAIR DETAIL**

ACCEPTED:	CHIEF STRUCTURES DESIGN ENGINEER	DATE
HWY 145 SB OVER LITTLE MEMONONEE PKWY		
COUNTY	MILWAUKEE	TOWNSHIP/VILLAGE
DESIGN SPEC.	MILWAUKEE	MILWAUKEE
DESIGNED BY	REHAB/DIVISION S/A	PLANS
CHECKED BY	DESIGN	REVISION
DATE	DATE	DATE
DAMAGE REPAIR		
SHEET 1 OF 1		
50		



Proposal Schedule of Items

Proposal ID: 20180710011 Project(s): 2984-27-71

Federal ID(s): N/A

SECTION: 0001

Contract Items

Alt Set ID:

Alt Mbr ID:

Proposal Line Number	Item ID Description	Approximate Quantity and Units	Unit Price	Bid Amount
0058	SPV.0060 Special 02. Steel Crack Repair B-40-271	5.000 EACH	_____.	_____.
0060	SPV.0060 Special 04. Steel Crack Repair B-40-360	7.000 EACH	_____.	_____.
0062	SPV.0060 Special 05. Steel Crack Repair B-64-039	2.000 EACH	_____.	_____.
0064	SPV.0060 Special 06. Steel Crack Repair B-64-019	4.000 EACH	_____.	_____.
0066	SPV.0105 Special 01. Heat Straightening of Damaged Girders B-40-208	LS	LUMP SUM	_____.
0068	SPV.0105 Special 02. Heat Straightening of Damaged Girders B-40-271	LS	LUMP SUM	_____.
0070	SPV.0105 Special 03. Heat Straightening of Damaged Girders B-40-939	LS	LUMP SUM	_____.
0072	SPV.0105 Special 04. Heat Straightening of Damaged Girders B-40-360	LS	LUMP SUM	_____.
0074	SPV.0105 Special 05. Heat Straightening of Damaged Girders B-64-039	LS	LUMP SUM	_____.
0076	SPV.0105 Special 06. Heat Straightening of Damaged Girders B-64-019	LS	LUMP SUM	_____.
Section: 0001			Total:	_____.
			Total Bid:	_____.

