

NOTE: THE WELDING SYMBOLS SHOWN ABOVE ARE TYPICAL FOR ALL SIMILAR LOCATIONS OF THIS END CROSSFRAME. ALSO, THE WELDED ATTACHMENT DETAILS AND TYPICAL DIMENSIONS SHOWN ARE TYPICAL FOR THE CROSSFRAMES DETAILED BELOW.

10 THICK PLATE IS A PART OF THE EXPANSION JOINT SYSTEM. SEE EXPANSION JOINT STANDARD DRAWINGS FOR DETAILS.

**NOTES:**

1. PROVIDE 6 mm WELD WHEN THE THICKER PLATE IS 19 mm OR LESS OR 8 mm WELD WHEN THE THICKER PLATE IS GREATER THAN 19 mm, UNLESS DESIGN REQUIRES LARGER WELDS (SEE CMS 513.17).
2. INTERMEDIATE STIFFENERS REQUIRE FILLET WELDS TO THE COMPRESSION FLANGE ONLY PER CMS 513.08.
3. STIFFENERS TO WHICH CROSS FRAMES CONNECT REQUIRE FILLET WELDS TO BOTH FLANGES PER CMS 513.08

**BEARING STIFFENER:** BEARING STIFFENER SHALL BE VERTICAL AFTER ERECTION.

**WELDS:** STIFFENER TO STRINGER WELDS SHALL BE TERMINATED AS GIVEN BELOW:

- A. STIFFENER TO STRINGER FLANGE WELDS 6 mm ± 3 mm AT BOTH ENDS OF THE STIFFENER.
- B. STIFFENER TO STRINGER WEB WELDS 13 mm ± 6 mm AT BOTH ENDS OF THE STIFFENER.

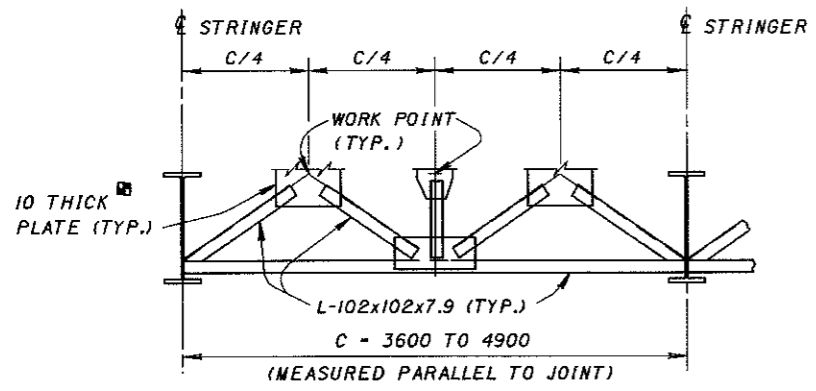
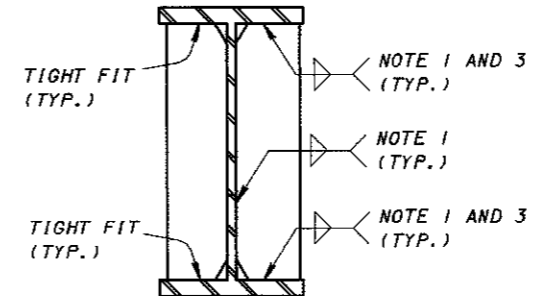
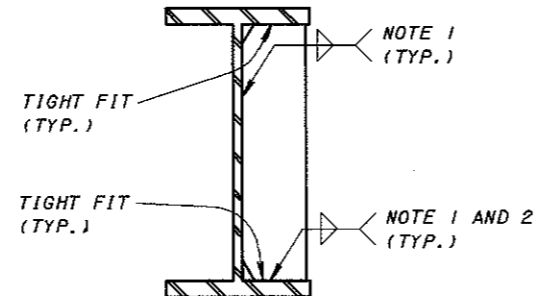
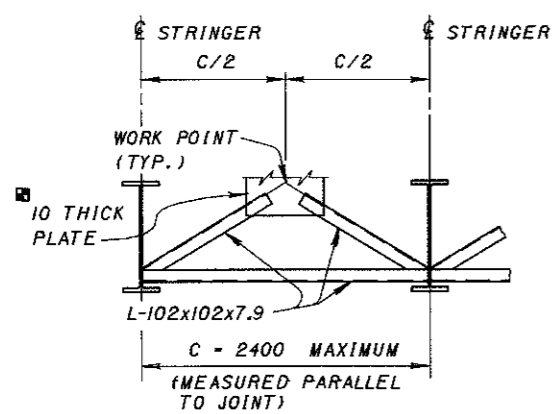
**MILL FIT:** THE BEARING ENDS OF THE BEARING STIFFENER SHALL BE FLUSH AND SQUARE WITH THE WEB AND SHALL HAVE AT LEAST 75 PERCENT OF THIS AREA IN CONTACT WITH THE INNER SURFACE OF THE FLANGE.

**TIGHT FIT:** A TIGHT FIT IS DEFINED AS ONE IN WHICH THE STIFFENER AND FLANGE ARE IN PHYSICAL CONTACT OVER SOME PORTION OF THE END OF THE STIFFENER AND HAVING NO GAP IN EXCESS OF 1.6 mm.

**BEAM OR GIRDER ENDS:** FOR STRUCTURES ON GRADE THE BEAM OR GIRDER ENDS SHALL BE CUT IN A MANNER THAT THEY ARE VERTICAL AFTER ERECTION. A 75 mm MINIMUM CLEARANCE AT 16°C SHALL BE MAINTAINED BETWEEN THE VERTICAL ENDS OF THE BEAMS OR GIRDERS AND THE VERTICAL FACE OF THE BACKWALL.

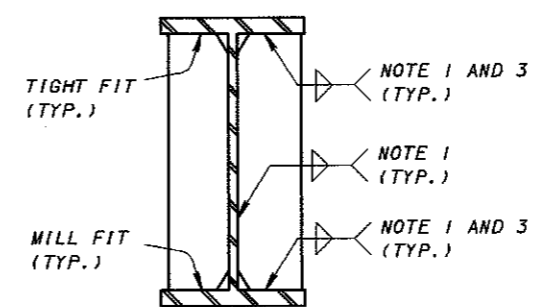
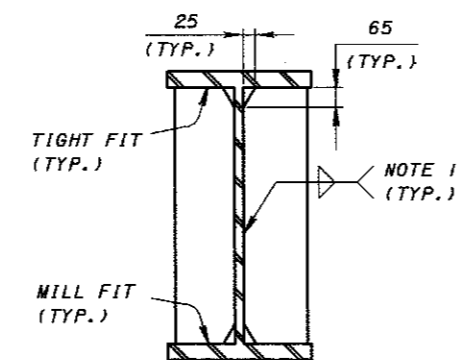
**WORK POINTS:** WORK POINTS SHALL BE COORDINATED BETWEEN EXPANSION JOINT AND STRUCTURAL STEEL SUPPLIERS TO ASSURE FIT UP AT ALL DESIGN LOCATIONS.

**TRANSITION OF THICKNESS OR WIDTH AT BUTT JOINTS:** REFER TO SECTION 9.20 OF THE AMERICAN WELDING SOCIETY (AWS) BRIDGE WELDING CODE AS AMENDED BY SUPPLEMENTAL SPECIFICATION 1011 WHICH PROVIDES TRANSITION DETAILS OF THICKNESSES AND WIDTHS AT COMPLETE PENETRATION BUTT JOINTS.



**INTERMEDIATE STIFFENER**

**INTERMEDIATE STIFFENER WITH CROSSFRAMES**



**BEARING STIFFENER**

**BEARING STIFFENER WITH CROSSFRAMES**