

## SECTION 6: STEEL STRUCTURES

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## 6.1 SCOPE

This section contains guidelines to supplement provisions of Section 6 of the AASHTO LRFD Bridge Design Specifications for the analysis and design of steel components, splices and connections for beam and girder structures, frames, trusses and arches, as applicable. Metal deck systems in relation to steel stay-in-place formwork are covered in Section 9 of these guidelines.

Design level load ratings of all bridges shall be performed per the Manual for Bridge Evaluation (MBE )latest edition. For new bridges the design Operating Load Rating (using HL93 live load) shall be 1.8 or more. For widening of bridges the minimum design Operating Load Rating (using HL93 live load) shall be either the Operating Load Rating (using HL93 live load) of the existing bridge or 1.5, whichever is greater. If these provisions cannot be met, coordination and approval from the ADOT Bridge Group will be required.

## 6.4 MATERIALS

### 6.4.1 Structural Steels

Structural steel shall conform to the requirements specified in AASHTO LRFD Table 6.4.1-1, with the selection based on strength, serviceability and overall economy. All structural steel shall be ASTM A709 Grade 50 or 50W (AASHTO M270 Grade 50 or 50W). Higher strength steel grades will not be allowed, unless approved by ADOT Bridge Group.

ASTM A709 Grade 36 (AASHTO M270 Grade 36) steel may be used for miscellaneous applications, such as, bearing assemblies, expansion joints, rods, etc.

All miscellaneous steel hardware (such as bearing assemblies, deck joint assemblies, handrails, steel railings, steel fences) exposed to weathering action shall be galvanized or match the paint system specified for the main structure. Bearing assemblies for weathering steel bridges shall be galvanized.

### 6.4.3 Bolts, Nuts and Washers

All structural fasteners shall be high-strength bolts, ASTM F3125 Grade A325. Type 1 bolts should be used with steels other than weathering steel. Type 3 bolts conforming to either ASTM A325 or ASTM A490 shall be used with weathering steel. All washers, nuts, and bolts for bolted connections on steel girder bridges are not required to be galvanized for both painted and weathering steel bridges. Galvanizing bolts, washers, and nuts requires hand-wire brushing of all surfaces to increase the friction needed for a bolted connection and to ensure paint adhesion. Type 1 bolts may be either hot-dip galvanized in accordance with ASTM A153 Class C or mechanically galvanized in accordance with ASTM B695 Class 50 with prior approval from ADOT Bridge Group.

All Anchor bolts shall be ASTM F1554 and shall be galvanized.

## **6.6 FATIGUE AND FRACTURE CONSIDERATIONS**

### 6.6.1 Fatigue

#### 6.6.1.2 Load-Induced Fatigue

Structural members including splices, stiffeners, bracings, shear connectors, and fasteners, subjected to stress reversal due to applied live loads shall be designed, to limit stress due to fatigue, using welding detail categories A through C (refer to AASHTO LRFD Table 6.6.1.2.3-1). Welding detail category D and E shall not be used.

### 6.6.2 Fracture

Charpy V-notch testing, shall meet requirements of temperature zone 2.

## **6.7 GENERAL DIMENSION AND DETAILING REQUIREMENTS**

### 6.7.2 Dead Load Camber

Steel structures shall be cambered during fabrication to compensate for non-composite and composite dead load deflections, and for vertical profile. Non-composite loads include weight of steel members and deck slab. Composite loads include weight of barrier, median, sidewalk etc. The future wearing surface shall not be included in the camber calculation. Camber information shall be provided on structural plans.

### 6.7.3 Minimum Thickness of Steel

Minimum thickness of steel shall conform to AASHTO LRFD 6.7.3 with the following exceptions:

- Structural steel including bracing, cross-frames, gusset plates, closed ribs in orthotropic decks, and fillers, shall not be less than 3/8 inch in thickness. The web thickness of rolled shape sections are exempted.
- Welded plate girder webs shall not be less than 1/2 inch in thickness.

### 6.7.4 Diaphragms and Cross-Frames

Rolled beams and plate girders shall be provided with cross-frames or diaphragms at each support and with intermediate cross-frames or diaphragms placed in all bays, at intervals not to exceed 25-feet. Other design criteria and provisions for diaphragm and cross-frames shall conform to AASHTO LRFD Article 6.7.4. Flexibility of the bracing system should be evaluated to assure ductility of the diaphragms and cross frames. The stiffener plates, which also serve as

connection plates, shall be placed parallel to the skew, for skew less than or equal to 20 degrees. Stiffener plates shall be placed normal to the web for skew greater than 20 degrees. Transverse intermediate stiffeners that are not connection plates shall be placed normal to the web.

## **6.10 I-SECTION FLEXURAL MEMBERS**

### 6.10.1 General

#### 6.10.1.3 Hybrid Sections

Hybrid I-Section members shall not be used without the prior approval of ADOT Bridge Group.

#### 6.10.10 Shear Connectors

Welded stud shear connectors shall be used and shall conform to AASHTO LRFD Article 6.4.4. Channel shear connectors shall not be used.

#### 6.10.11 Stiffeners

##### 6.10.11.1 Transverse Intermediate Stiffeners

For exterior girders, transverse stiffeners shall be placed on the inside face only.

##### 6.10.11.2 Bearing Stiffeners

Each stiffener plate shall be attached to the compression flange by full penetration groove welds.

##### 6.10.11.3 Longitudinal Stiffeners

Longitudinal stiffeners shall not be used without prior approval of ADOT Bridge Group. Webs shall be sized to eliminate the need for longitudinal stiffeners.

#### 6.10.12 Cover Plates

##### 6.10.12.1 General

Welded cover plates shall be a minimum 1/2 inch narrower than the flange to which they are attached in order to accommodate a 1/4 inch fillet weld. Welded cover plates wider than the flange can contribute to a reduction in fatigue strength and shall not be used.

**6.11 BOX SECTION FLEXURAL MEMBERS**

Selection of these members requires ADOT Bridge Group approval.

**6.13 CONNECTIONS AND SPLICES****6.13.3 Welded Connections****6.13.3.1 General**

In addition to AASHTO LRFD Article 6.13.3, all welding except for stud shear connectors and those connections necessary to facilitate bearing assembly installation shall be performed in the fabrication shop. With the exception of retrofit or repair work, no welding shall be performed in the field without prior approval of ADOT Bridge Group.

Provisions in AASHTO/AWS D1.5M/D1.5 Bridge Welding Code shall be followed to ensure appropriate information is provided in the contract documents to facilitate proper fabrication and quality control.