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**Revision of Section 509
Welding**

Permanent Changes to Project Dated Special Provisions

Revision of Section 509 Welding - Existing Steel

Date	Author	Description of Change
9/19/90	SHAMU	Minor Changes To Format
12/18/91	MAL	Revised subsection references to conform with 1991 Specifications Book. This Special Provision is for the welding of existing steel. The Staff Materials Branch should be contacted to review the 509 Special Provisions on projects utilizing existing structural steel.
9/29/1999	M. Nord	Verified the specification references for conformance with the <i>1999 Colorado DOT Standard Specifications for Road and Bridge Construction</i> . No exceptions were found. Converted to Microsoft Word 97 SR-2
04.11.2023	M. Kayen	Revisions to make spec online accessibility-compliant. 5.22.23 Additional accessibility work.

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**Revision of Section 509
Welding**

Revise Section 509 of the Standard Specification for this project as follows:

Subsection 509.20 shall include the following:

For field welding A7 steel, electrodes used shall be E7015, 16, 18, or 28.

For welding A7 steel with low-hydrogen electrodes by any process, the minimum preheat and interpass temperature shall be 150°F for thicknesses of metal up to 1-1/2 inches.

Subsection 509.26 shall include the following:

The Contractor shall not commence any field welding on the girders until the Division's Materials Branch has been notified and their inspector is on the site. The preheating process shall be approved by the Division's inspector.

Subsection 509.20(h) shall include the following:

Base metal shall be preheated to 150°F on the surface prior to welding studs.