Instructions for Pile Plating:

- Only one pile shall be repaired at a time.
- Field connections shall be made with 3/4" diameter high strength bolts and 13/16" diameter holes.
- High-strength tightening shall begin after all bolts are installed per flange or web.

Fabricated structural steel shall be ASTM A709 Grade 36 or 50.

Steel Pile Repair:

- New steel pile section shall be coated in accordance with Sec 702.
- Minimum of two coats of inorganic zinc primer (5 mils minimum).
- Contact surfaces shall be in accordance with Sec 1081 for surface preparation.

Aluminum Epoxy-Mastic Primer:

- Gray epoxy-mastic primer shall be applied over an SSPC-SP3 inspection.
- All exposed surfaces of the existing structural steel piles and steel coatings and any other incidental material or labor to be considered. Minimizing or eliminating traffic loading, overall symmetry of the section shall be maintained.

Cost of all excavation will be considered completely covered by the variations and cannot be used for an adjustment in the contract unit price. Variations may be encountered in the estimated quantities but the variations cannot be used for an adjustment in the contract lump sum price for Class 2 Excavation. The cost of the aluminum gray epoxy-mastic primer applied over an SSPC-SP3 inspection or Epoxy-Mastic Primer. The cost of the aluminum gray epoxy-mastic primer applied over an SSPC-SP3 inspection or Epoxy-Mastic Primer is considered. The cost of the aluminum gray epoxy-mastic primer applied over an SSPC-SP3 inspection or Epoxy-Mastic Primer is considered. The cost of the aluminum gray epoxy-mastic primer applied over an SSPC-SP3 inspection or Epoxy-Mastic Primer is considered.