

ENGINEERING DIRECTIVE

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CHIEF ENGINEER

Pre-Blast Cleaning Requirements for Fabricated Steel Products

The purpose of this Engineering Directive is to clarify the pre-blast cleaning requirements for all structural steel and miscellaneous steel products used on MassDOT projects.

In accordance with subsection 960: Structural Steel and Miscellaneous Metal Products, of the *Standard Specifications for Highways and Bridges*, steel shall be blast cleaned prior to starting fabrication (pre-blast). The blast cleaning shall be in accordance with SSPC-SP10/NACE No. 2 – Near White Blast Cleaning. Fabrication includes, but is not limited to cutting, drilling, welding, etc.

The requirement for blast cleaning prior to starting fabrication applies to material greater than 3/16 inch in thickness. All welding preparation shall conform to the applicable AWS welding code.

The pre-blast requirement does not apply to tubular sections, manufactured or fabricated, used in traffic signal structures, highway lighting structures or sign support structures (M8.18.0). However, the pre-blast requirement does apply to all attachments and weldments to the tubular sections, including but not limited to base plates. All welding preparation shall conform to the AWS D1.1: Structural Welding Code – Steel requirements.

This Engineering Directive is effective immediately and applies to all projects, including active construction projects.