

INCH-POUND

MIL-B-11844D(ME)
 6 March 1990
AMENDMENT 2
 SUPERSEDING
 AMENDMENT 1
 26 September 1980

MILITARY SPECIFICATION

BRIDGE, FIXED: STEEL, PORTABLE PANEL,

BAILEY TYPE M2 (WIDENED ROADWAY)

This amendment forms a part of MIL-B-11844D, dated 26 August 1976, and is approved for use by all Departments and Agencies of the Department of Defense.

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* 2.1, under SPECIFICATION, FEDERAL add:

"TT-E-527 - Enamel, Alkyd, Lusterless, Low Voc Content.
 TT-P-645 - Primer, Paint, Zinc-Chromate, Alkyd Type."

* 2.1, under SPECIFICATIONS, MILITARY add:

"DOD-P-15328 - Primer (Wash), Pretreatment (Formula No. 117 for
 Metals) (Metric)."

2.1, under STANDARDS, FEDERAL delete:

"FED.STD. No. 356 - Commercial Packaging of Supplies and Equipment."

* 2.1, under STANDARDS, FEDERAL add:

"FED-STD-595 - Colors."

2.1, under STANDARDS, MILITARY delete:

"MIL-STD-1188 - Commercial Packaging of Supplies and Equipment."

* 2.1, under STANDARDS, MILITARY add:

"MIL-STD-889 - Dissimilar Metals.
 MIL-STD-1186 - Cushioning, Anchoring, Bracing, Blocking and Watering,
 With Appropriate Test Methods."

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* 2.2, under AMERICAN SOCIETY FOR TESTING AND MATERIALS ASTM), correct titles of the following standards:

AMSC N/A

FSC 5420

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"A27	- Steel Castings, Carbon, for General Applications
A108	- Steel Bars, Carbon, Cold-Finished, Standard Quality
A183	- Carbon Steel Track Bolts and Nuts
A322	- Steel Bars, Alloy, Standard Grades."

* 2.2, under AMERICAN SOCIETY OF MECHANICAL ENGINEERS (ASME), correct title of code:

"Boiler and Pressure Vessel Code, Section IX, Welding and Brazing Qualifications."

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* 2.2, under AMERICAN WELDING SOCIETY, INC. (AWS), correct title of the following standard:

"D1.1 - Structural Welding Code, - Steel."

* 2.2, correct address of the American Welding Society, Inc., to:

"550 N.W. LeJeune Road, P.O. Box 351040, Miami, Fl 33135"

* 2.2, add "AMERICAN WOOD PRESERVERS BUREAU (AWPB)

LP-2	- Softwood Lumber, Timber and Plywood Pressure Treated With Waterborne Preservatives for Above Ground Use.
LP-22	- Softwood Lumber, Timber and Plywood Pressure Treated With Waterborne Preservatives for Ground Contact Use.

(Application for copies should be addressed to the American Wood Preservers Bureau, 7962 Conell Court, Lorton, Virginia 22079.)"

* 3.2, line 1, delete "(preproduction model)."

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* 3.3.4, line 2, delete "Grade Designation 1020.", replace with "UNS G 10200."

* 3.3.6.1, delete and replace with:

"3.3.6.1 Softwood. The lumber for the chess shall conform to MM-L-751 and the grade of lumber shall be Southern Pine No. 1 Dense or Longleaf No. 1 Dense or Douglass Fir No. 1 or Dense, S4S. Lumber shall be preservative treated after all cutting and drilling has been completed with ammoniacal copper arsenate, ACA, or chromated copper arsenate, CCA, in accordance with TT-W-571, minimum net retention 0.50 pounds per cubic foot. Marking shall be in conformance with AWPB LP-2 for above ground, or AWPB LP-22 for ground contact Quality Control and Inspection Procedures."

* Add, "3.3.7 Dissimilar metals. Dissimilar metals shall not be used in intimate contact with each other unless protected against galvanic corrosion. Dissimilar metals and methods of protection are defined and detailed in MIL-STD-889."

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* 3.11.4, line 2, after ASTM A183, add ", Grade 2."

3.15, delete and replace with:

"3.15 Treatment and painting. Bridge components except as specified herein shall be treated and painted in accordance with MIL-T-704, using DOD-P-15328 (Primer Wash, Pretreatment, Formula No. 117 for Metals), 1 coat of TT-P-645 (Primer, Paint, Zinc-Chromate, Alkyd type), and 1 coat of TT-E-527 (Enamel, Alkyd, Lusterless) to color number 34083 of FED-STD-595. Rollers and threaded surfaces of transom clamps, sway braces, bracing bolts, chord bolts and ribband bolts shall not be painted but shall be coated with preservatives as specified in 5.1".

3.16, delete line 6 and substitute "The letters "US" shall be stenciled on the bridge components in an inconspicuous location. The height of the letters shall not exceed 3/4-inch or be less than 1/4-inch. The color of all stenciling shall be lusterless camouflage black."

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* 3.18.2.1, line 1, delete "to manual or automatic" and replace with "or welding operator to".

* 3.18.2.1, line 3, between "welder" and "has" add "or welding operator".

* 3.18.2.1, line 7, delete "Section 5, Qualification." add "Steel."

* 3.18.2.1, line 8, between "Welding" and "Qualifications" insert "and Brazing".

* 3.18.2.1, line 10, delete paragraph starting with "Contractors who..." and substitute "Contractors who make only horizontal welds need not qualify welders for "all position welding". In the event of evidence of poor welds, the Government reserves the right to require retesting of any welder or welding operator. All test results, welding procedures and procedure qualification records shall be made available to the contracting officer or his representatives upon request.

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* 4.2 (a), delete "Preproduction" replace with "First article".

* 4.3, delete "Preproduction" replace with "First article".

* 4.4.1, delete in its entirety and replace with:

"4.4.1 Sampling. Sample size shall be determined by using MIL-STD-105, table I and table IIa. A lot shall be accepted when 0 defects are found and rejected when 1 or more defects are found."

* 4.4.2.2, line 2, delete "AQL shall be 2.5 percent defective."

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* 4.5.2, after 107, add:

- "108. Welder or welding operator qualification not as specified.
- 109. Welding not as specified.
- 110. Dissimilar metals not in accordance with MIL-STD-889."

* 4.6.1.2, delete in its entirety and replace with:

"4.6.1.2 Sampling. Sample size shall be determined by using MIL-STD-105, table I and table IIIa. A lot shall be accepted when 0 defects are found and rejected when 1 or more defects are found."

* 4.6.1.3, line 2, delete "AQL shall be 2.5 percent defective."

* 4.6.1.3, line 4, delete "108" in its entirety.

* 4.6.1.3, line 7, change "109" to "111" and on line 9, change "the" to "as" and delete "preservative for level A or B or commercial."

* 4.6.1.3, line 10, change "110" to "112" and on line 11, change "B" to "C".

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* 4.6.1.3, line 1, change "111" to "113" and on line 2, change "B" to "C".

* 4.6.1.3, line 3, change "112" to "114" and delete "or B."

* 4.6.1.3, line 4, change "113" to "115" and on line 5, change "B, or commercial." to "C."

* 5.2, line 1, change "B, or commercial" to "C".

* 5.2.1, line 5, change "required" to "specified by MIL-STD-1186,".

* 5.2.1, line 8, after "type I or IV," insert "finish B" and delete remainder after "applicable."

* 5.2.2, line 1, change "Level B" to "Level C." and on line 3, add "and strapping may be finish A." after "applicable."

* 5.2.3 delete entire paragraph.

* 5.3, 5.3.1 and 5.3.2 - delete in their entirety and substitute:

"5.3 Marking. In addition to any special marking specified in the contract or purchase order (see 6.2), marking shall be in accordance with MIL-STD-129."

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* 6.2 (c), delete in its entirety.

* 6.2 (d), change to "6.2 (c)" and add:

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"6.2 (d) Any special marking required (see 5.3)."

* 6.3, lines 1,2, and 4, change "Preproduction" to "first article".

The margins of the amendment are marked with an asterisk to indicate where changes (additions, modification, corrections, deletion) from the previous amendment were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous amendment.

Custodian:

Army - ME

Preparing Activity:

Army - ME

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