

**LOUISIANA
DEPARTMENT OF TRANSPORTATION AND DEVELOPMENT
SPECIFICATIONS**

SQUARE STEEL TUBULAR SIGN POSTS

DESCRIPTION:

This specification covers the minimum requirements for square steel tubular sign posts. Posts shall be perforated, telescopic, and meeting the requirements of this specification.

MATERIAL REQUIREMENTS:

Posts shall conform to ASTM A1011, Structural Quality, Grade 50 Class 1 for hot rolled carbon steel and shall be hot-dipped galvanized, inside and out, in accordance with ASTM A653, G90.

Steel shall be coated with a chromate conversion coating and a clear organic polymer topcoat. Post shall be welded by high frequency resistance welding and externally scarfed. Welds shall be hot zinc coated after scarfing.

The average minimum yield strength after cold-forming shall be 60,000 psi.

Posts shall be perforated with 7/16 inch holes with a variance of +/- 1/32 of an inch on 1 inch centers. Holes shall be on the centerline of all four (4) sides for the full length of the post and must be in true alignment both directly opposite each other and diagonally. When telescoping, the holes must line-up on all four (4) sides.

Posts shall be able to freely telescope with all consecutive sizes for a minimum of 10 feet of their length without the necessity to match any particular face to any other face.

Finished posts must be straight with a variation of +/- 1/16 inch in 3 feet. Posts shall have a smooth, uniform finished with the holes and ends free of burrs. Ends shall be cut square.

Posts shall meet the requirements of the chart below as indicated for each Product ID.

| Product ID | Size (Inch) | Length (Foot) | Length Tolerance (Inch) | Specified Thickness (Inch/Gauge) | Thickness Tolerance (Inch) | Min. Weight (LB/Foot) |
|------------|-------------|---------------|-------------------------|----------------------------------|----------------------------|-----------------------|
| 50500 | 2 x 2 | 6 ft. | ±0.25 | 0.083 / 14 | ±0.011 | 1.90 |
| 50501 | 2 x 2 | 7 ft. | ±0.25 | 0.083 / 14 | ±0.011 | 1.90 |

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|-------|---------|--------|-------|------------|--------|------|
| 50502 | 2 x 2 | 8 ft. | ±0.25 | 0.083 / 14 | ±0.011 | 1.90 |
| 50503 | 2 x 2 | 9 ft. | ±0.25 | 0.083 / 14 | ±0.011 | 1.90 |
| 50504 | 2 x 2 | 10 ft. | ±0.25 | 0.083 / 14 | ±0.011 | 1.90 |
| 50505 | 2 x 2 | 11 ft. | ±0.25 | 0.083 / 14 | ±0.011 | 1.90 |
| 50506 | 2 x 2 | 12 ft. | ±0.25 | 0.083 / 14 | ±0.011 | 1.90 |
| 50507 | 2 x 2 | 13 ft. | ±0.25 | 0.083 / 14 | ±0.011 | 1.90 |
| 50508 | 2 x 2 | 14 ft. | ±0.25 | 0.083 / 14 | ±0.011 | 1.90 |
| 53266 | 2 x 2 | 12 ft. | ±0.25 | 0.105 / 12 | ±0.011 | 2.70 |
| 53267 | 2 x 2 | 14 ft. | ±0.25 | 0.105 / 12 | ±0.011 | 2.70 |
| 50509 | 2¼ x 2¼ | 3 ft. | ±0.25 | 0.105 / 12 | ±0.011 | 2.70 |

CERTIFICATION:

A Certificate of Compliance stating the material supplied conforms to the requirements of this specification must be provided with each shipment. Certificate will be kept on file by the Department.

ACCEPTANCE & NON-CONFORMANCE:

Prior to acceptance, each shipment shall be visual inspected by DOTD. Any material that fails to conform to any part of this specification shall result in rejection of material supplied. In the event the material is rejected, the vendor must remove the insufficient material and replace it with acceptable material at the vendor's expense.