Chapter 4
Engineering Critical Assessment Procedures

4-1. Overview

When inspections reveal cracks, it is necessary to establish acceptance levels to determine if immediate repairs are needed to prevent fracture. The critical crack size may be determined through a fracture mechanic's evaluation for a given set of loads, environmental factors, geometry, and material properties. If the crack size is less than the critical dimension, the expected remaining life and rate of crack propagation may be determined by a fatigue analysis. The engineering decision on appropriate repair or planned maintenance is based on the concept of fitness-for-service of the distressed bridge (International Institute of Welding 1990). These analysis procedures are called Engineering Critical Assessment (ECA) procedures.

4-2. Fracture Behavior of Steels

a. The service temperature under which a steel bridge operates has a significant effect on the fracture behavior of the steel. The critical fracture stress remains unchanged by temperature for a given crack size if the service temperature is below a transition temperature, called nil ductility transition temperature. The critical stress decreases as the crack size increases and is inversely proportional to the square root of the crack size. Above the transition temperature, fracture stress of steels becomes less dependent on the crack size. As the material temperature increases, the fracture stress eventually reaches the yield strength, and then the ultimate strength, regardless of the crack size.

b. As the service temperature decreases, for low and intermediate strength steels, the material changes from ductile fracture behavior to brittle fracture behavior at the nil ductility transition temperature. Considering constraint, the appropriate fracture parameter, K_{Ic} (critical stress intensity factor under plane strain condition) or crack tip opening displacement (CTOD) can be selected for evaluating the fracture behavior of the bridge material. Those fracture parameters are defined and discussed in detail by Barsom and Rolfe (1987).

4-3. Fracture Analysis Procedure

a. For bridges containing cracks and operating below the nil ductility transition temperature, linear elastic fracture mechanics analysis can be used to assess the cracks revealed from inspections. For bridges with cracks operating at temperatures above the transition temperature, elastic-plastic fracture analysis must be conducted. Fatigue growth rates must also be considered when developing the inspection and maintenance scheduling for distressed bridges. This section presents a procedure for fracture analysis of FCMs.

(1) For brittle fracture analysis, the stress intensity factor (K_I) shall always be less than the critical stress intensity factor (K_{Ic}). The critical crack size (a_{cr}) is related to material fracture toughness (K_{Ic}) for a given applied load and loading rate at the minimum service temperature as follows:

$$a_{cr} = [K_{Ic} \;/\; (F.S.\;\beta\;\sigma)]^2 \tag{4-1}$$

where

a_{cr} = critical crack size in inches

K_{Ic} = fracture toughness of the bridge material in ksi times square root of inches

$F.S.$ = appropriate factor of safety (e.g., 2)

β = constant which is a function of crack and joint geometry, loading type, and welding-induced residual stress

σ = applied nominal stress in ksi

(2) For ductile fracture analysis, CTOD is usually used to calculate crack criticality. An effective crack parameter, equivalent to the through thickness dimension of the joint which would yield the same stress intensity factor as the actual crack under the same load, is used to compare with the critical CTOD values of the bridge material. This effective crack parameter shall not be greater than the critical CTOD.

b. The procedure for fracture assessment of cracks is discussed by Tsai and Shim (1992) and is summarized below:

(1) Determine the actual shape, location, and size of the discontinuity by NDT inspection.

(2) Determine the effective crack dimensions to be used for analysis. Cracks are classified as through thickness (may be detected from both surfaces), embedded (not visible from either surface), or surface (may be observed on one surface). Through thickness cracks may be detected and defined by visual, dye penetrant, magnetic particle, or ultrasonic methods. Embedded cracks may be detected by ultrasonic and possibly radiographic methods. To determine the effective dimensions of a single crack or multiple cracks:

(a) Resolve the crack(s) into a plane normal to the principle stresses.

(b) Determine the effective dimensions for various isolated cracks. Check interaction with neighboring cracks to obtain the idealized crack dimensions.

(c) For surface or embedded cracks (idealized or actual), check their interaction with surfaces by recategorization.

(d) Determine final idealized effective dimensions for fracture analysis.

(3) Determine material properties including yield stress, Young's Modulus and K_{Ic} or CTOD. K_{Ic} may be estimated from Charpy V-Notch test (CVN) by Barsom's two-stage transition method (Barsom and Rolfe 1987) if direct K_{Ic} test data is not available.

(4) Idealize the total stresses by dividing them into primary stress, σ_p, and secondary stress, σ_s. The primary stress consists of membrane stresses, σ_m, and bending stress, σ_b, which include the effect of stress concentration imposed by geometry of the detail under consideration. Examples of the secondary stress include stress increase at re-entry angles in the joint, thermal, and residual stress. For cracks in welds, the residual tensile stress should be taken as yield stress. An estimate of the residual stress should be appropriate for post heat-treated weldments.

(5) Perform fracture assessment to determine the critical crack size. If applied stress is greater than the yield stress, CTOD must be employed. If applied stress is less than the yield stress and the plane strain factor $\beta_{Ic} < 0.4$ (Irwin's plane strain condition for brittle fracture), analysis must be based on K_{Ic}. When applied stress is less than the yield stress and $\beta_{Ic} > 0.4$, K_c should be used instead of K_{Ic}.

(6) If the crack is subcritical, determine the remaining life using a fatigue analysis procedure. The upper limit for the brittle fracture behavior (plane strain behavior) is:

$$K_{Ic}/\sigma_{ys} = (t/2.5)^{0.5} \tag{4-2}$$

c. When this upper limit is exceeded, extensive plastic deformation occurs at the crack tip (crack tip blunting), and a nonlinear elastic plastic analysis must be used to assess the crack. CTOD is appropriate for this type of fracture analysis. The CTOD analysis procedure can be summarized as follows:

(1) Determine the effective crack parameter ($\bar{a}$).

(a) For through thickness crack (= ι/2) where ι is the crack size.

(b) For surface crack, $\bar{a}$ is determined from Figure 4-1.

(c) For embedded crack, $\bar{a}$ is determined from Figure 4-2.

(2) Determine allowable crack parameter a_m, which can be calculated by

$$\bar{a}\ \bar{a}_m = c\left(\frac{\delta_{crit}}{\varepsilon_y}\right) \tag{4-3}$$

where

δ_{crit} = critical CTOD

ϵ_y = material yield strain

The constant c is determined from Figure 4-3. In determining c, if the sum of the primary and secondary stresses, excluding residual stress, is less than $2\sigma_{ys}$, the stress ratio $(\sigma_p + \sigma_s)/\sigma_{ys}$ is used as the abscissa in Figure 4-3. If this sum exceeds $2\sigma_{ys}$, an elastic plastic stress analysis should be carried out to determine the maximum equivalent plastic strain which would occur in the region containing the crack if the crack was not present. The value of c may then be determined using the strain ratio, $\varepsilon/\varepsilon_y$, as the abscissa in Figure 4-3.

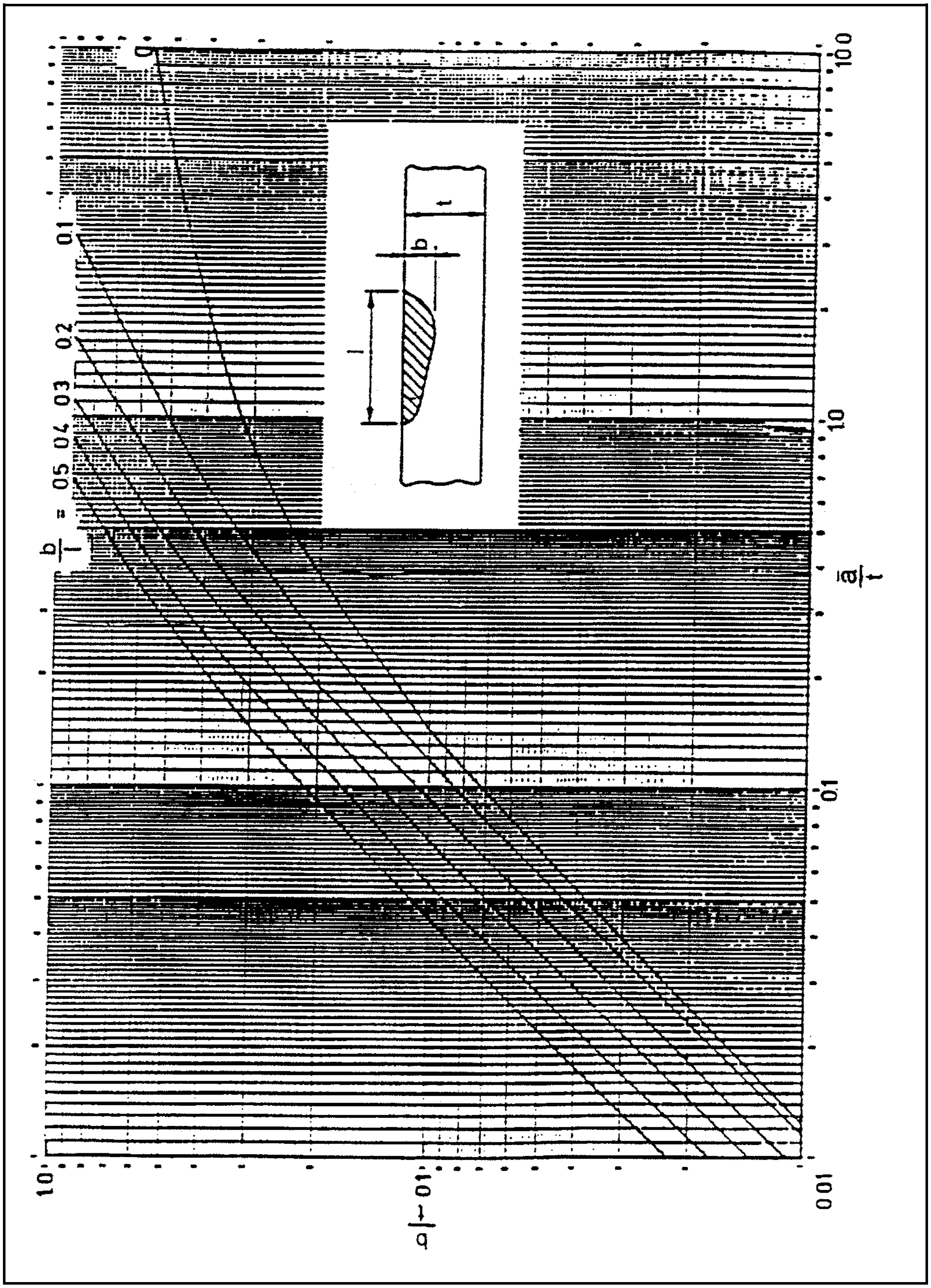


Figure 4-1. Relation between dimensions of a discontinuity and the parameter *a* for surface discontinuities

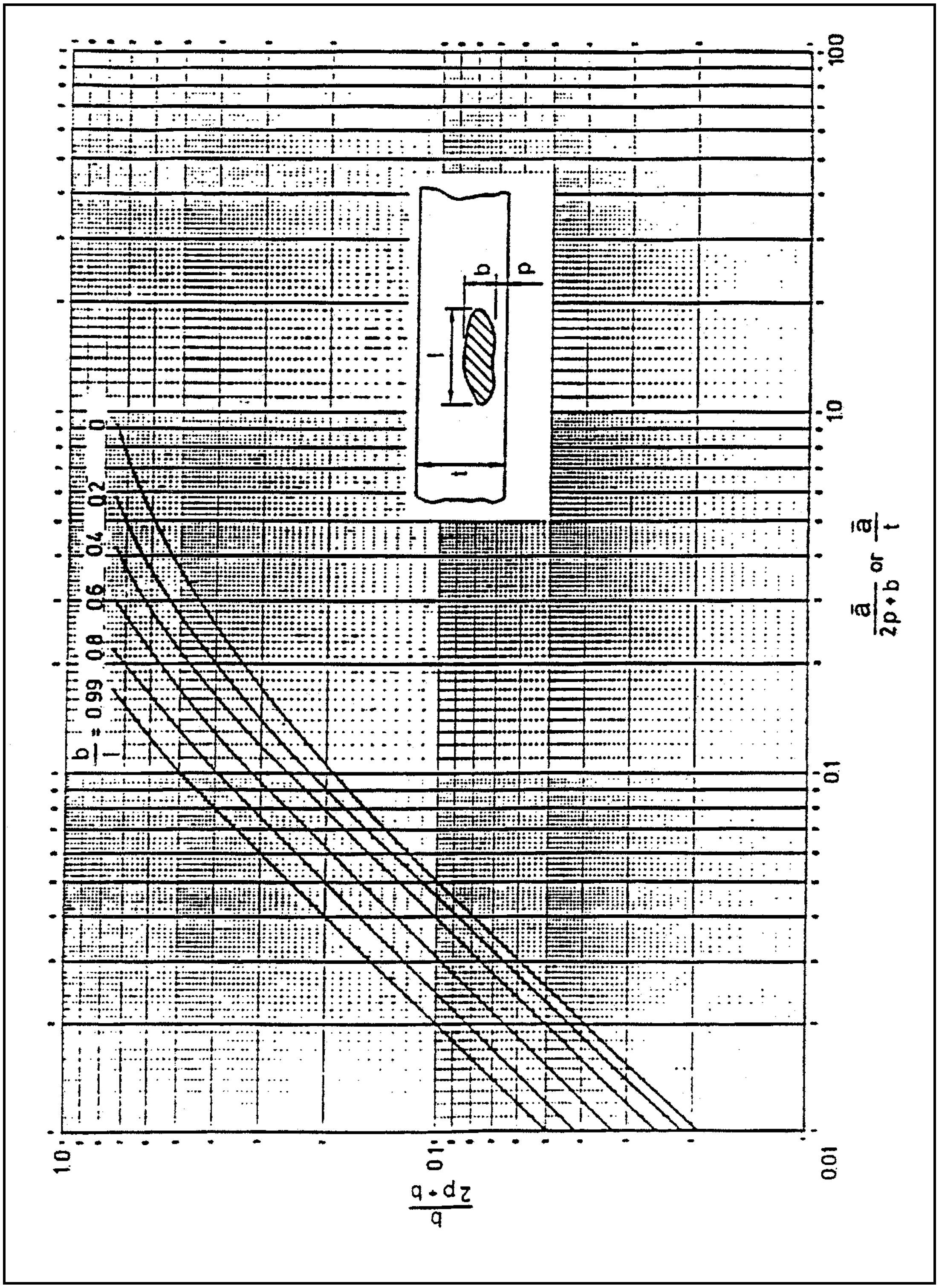


Figure 4-2. Relation between dimensions of a discontinuity and the parameter for embedded discontinuities

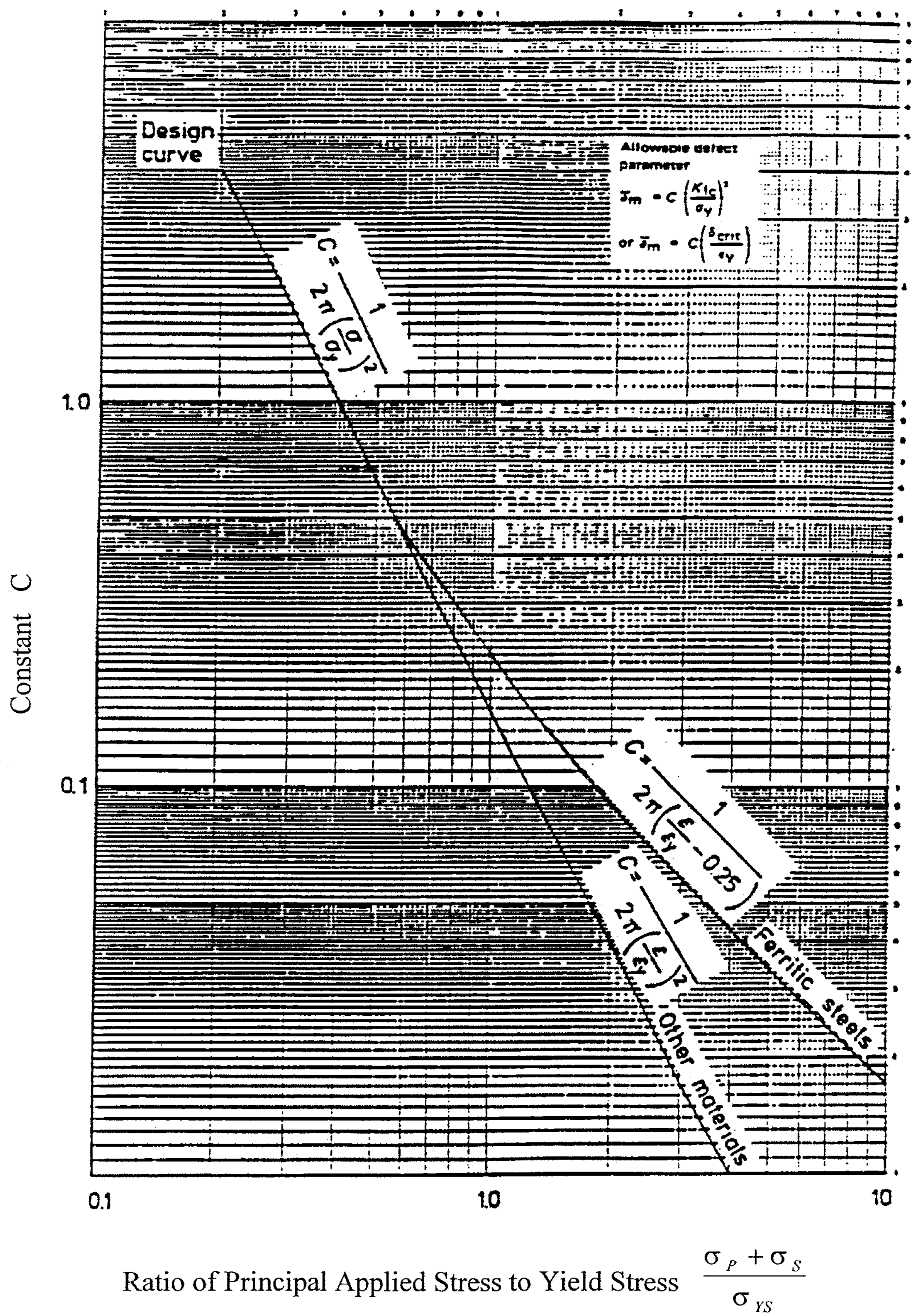


Figure 4-3. Values of constant *c* for different loading conditions

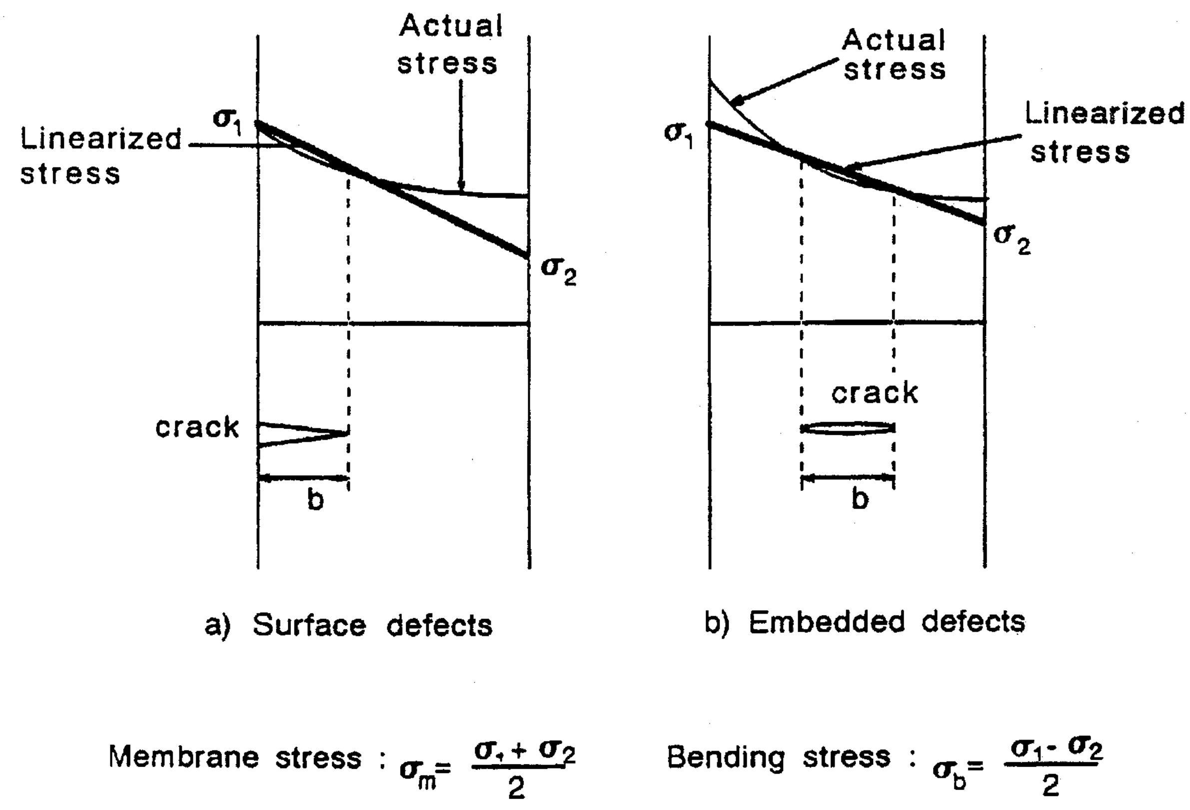


Figure 4-4. Linearization of stresses

(3) If the effective crack parameter, a, is smaller than the allowable crack parameter, $\bar{a}_m$, then the crack is considered stable under static loading. Using the procedure described in the second step above results in a safety factor of approximately 2.5 in determining $\bar{a}_m$. Therefore, the calculated critical crack size would be equal to 2.5 $\bar{a}_m$.

4-4. Fatigue Analysis Procedure

a. Dependent on the nature and fabrication of the joint detail, the joint fatigue characteristics are represented by the S-N curve of the appropriate category. While S-N curves are referenced to constant amplitude stress cycles, the stress cycles experienced by actual bridge structural details vary insignificantly in normal bridge operations. An equivalent constant stress range would cause the same damage and fatigue life as the actual stress range spectrum experienced in the field.

b. To evaluate the fatigue safety of an existing bridge structure, the maximum stress range should first be compared with the fatigue limit for the detail in question. Fatigue limit is defined as the constant amplitude stress range with which the detail can endure an unlimited number of cycles without developing fatigue cracks. If the maximum stress range is greater than the fatigue limit, fatigue cracking is expected after a number of stress cycles. The total fatigue life of the detail may be tens of millions of stress cycles, but not unlimited. Further application of loading after crack initiation would cause the crack to extend. Only after significant crack growth is the situation likely to become critical to the extent that the crack would become unstable and failure would occur. In general, fatigue cracks usually exist in structural members adjacent to weld toes.

c. The design S-N curves for various steel joint details are specified in the AWS D1.1 Structural Welding Code (American Welding Society 1992). Figure 4-5 shows a summary of fatigue categorization for various details of nonredundant structures used by the AWS welding code. To ensure conservative fatigue assessments, the code uses a mean minus 2 standard deviations (i.e., 97.7 percent survival probability) as the lower bound S-N curves for design purpose. The design S-N curves can be expressed as

$$\log N = \log A + m \log S \qquad (4\text{-}4)$$

or

$$N = A\,S^{m} \qquad (4\text{-}5)$$

where

m = inverse negative slope of the S-N curve

$\log A$ = intercept of the $\log N$ axis

S = full stress range in ksi (i.e., applied maximum nominal stress minus applied minimum nominal stress)

N = fatigue life in number of cycles

d. Redundant structures are those structures using redundant structural members. Failure of these members will not cause catastrophic structural failure. Therefore, the S-N design curves use a mean minus one standard deviation (i.e., 84.1 percent survival probability) as the lower bound for design purpose. Secondary bridge members, such as stiffeners, may apply the redundant structure S-N curves to assess the connection fatigue categories. However, fatigue cracks do not usually occur in these secondary stiffening members. For application simplicity, the nonredundant structure S-N curves are used for assessing the entire bridge structures.

e. Six fatigue categories are defined by the AWS D1.1-Structural Welding Code (American Welding Society 1992) for different joint details and stress types. Category F is for shear stress only and in most cases is used to categorize fillet welds. The AWS fatigue categories for redundant and nonredundant structures are shown in Figure 4-6 and the constants are summarized in Table 4-1.

f. The S-N curve design procedure is relatively simple to apply. However, this approach has some disadvantages. For example, S-N curves do not separate the stages of crack initiation and crack growth, the plasticity effects cannot be quantified, although they are included in the test data; and the local stress-strains at the weld toe are unknown where fatigue crack will inevitably initiate. Therefore, the S-N curve design procedure is used to plan a strategy for scheduled inspection and evaluation only. For those members found with cracks during the scheduled inspection, fracture mechanics and fatigue theory must be applied to estimate the remaining life of the distressed bridge members.

g. An accurate estimation of the number of stress cycles experienced to-date by a bridge structure requires knowledge of the operating history of the bridge. An average daily operation (ADO) curve may be established based on the bridge operating history. A possible source for historical operating information is an onsite operational control device, if one exists. The area under the ADO represents the total number of stress cycles experienced by the bridge within a specified period of time. Dependent on the operational characteristics of the bridge, each event may cause one or more stress cycles at a given detail. For example, vibration of the bridge may occur if it is harmonic with the vehicle crossing frequency. This vibration may induce more than one stress cycle at joint details. The natural frequency of the bridge should also be considered when estimating the number of stress cycles.

h. Occasionally, due to collision, (e.g., barge impact, falling ice or debris) during bridge operation, overload may occur in the bridge. This occasional overload may cause brittle fracture of cracked members. Therefore, brittle fracture should be considered when infrequent overload is possible. For frequent overload occurrence, the cumulative damage must be considered in the fatigue analysis. The root-mean-cube effective stress range may be used to estimate the total fatigue life using the constant-amplitude S-N design curves. To estimate the effect of known overloading history, Barsom's root-mean-square crack propagation model (Barsom and Rolfe 1987) may be used to estimate the remaining life of the cracked members.

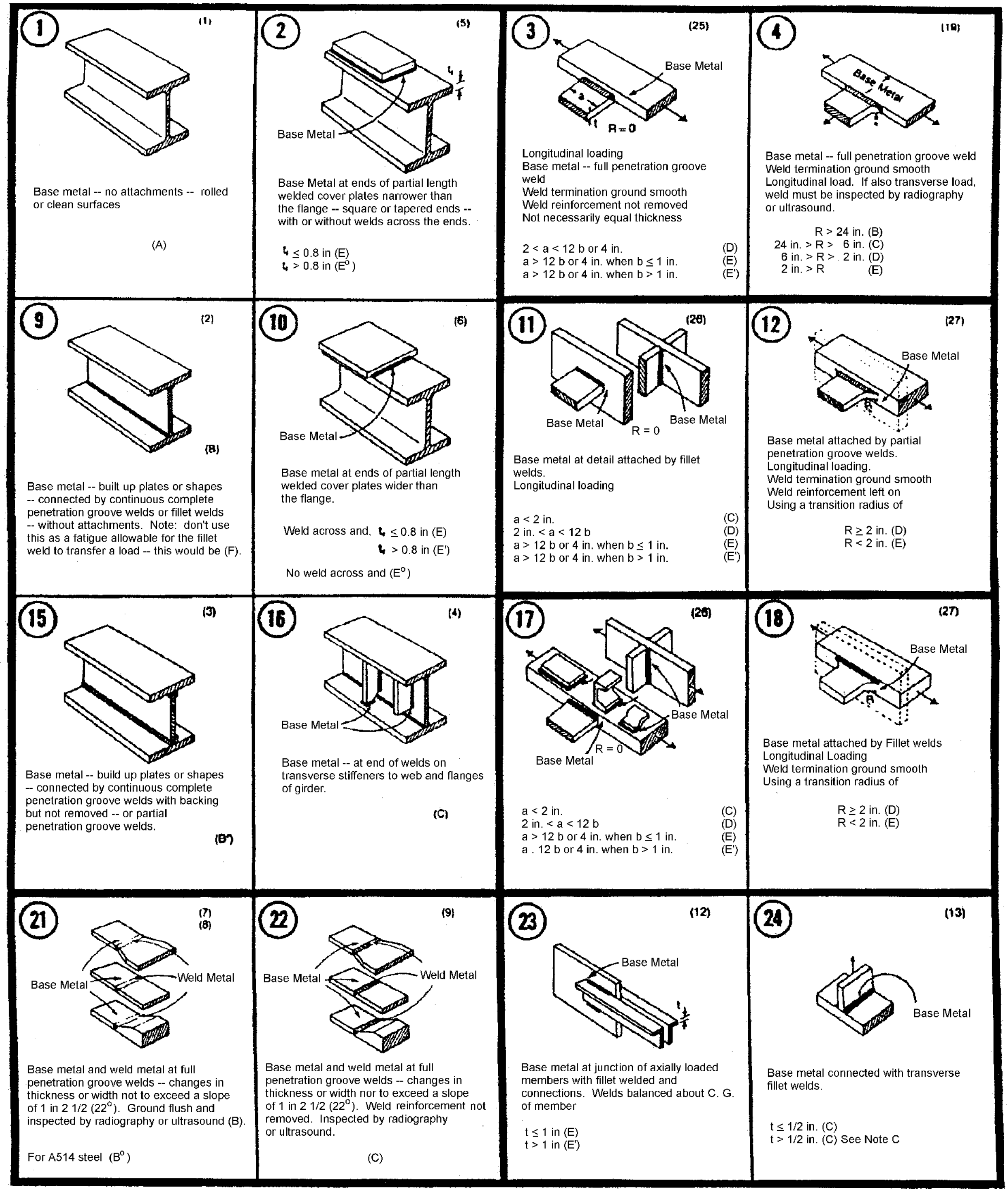
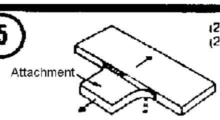


Figure 4-5. Summary of fatigue categorization for nonredundant structure details. Personal Communication from Omer W. Blodgett to Dr. Chon Tsai, Ohio State University, Columbus, OH (continued)

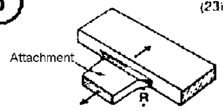
5 (20) (21)



Transverse loading
Attachment -- Full penetration groove weld
Weld termination ground smooth
Equal Thickness

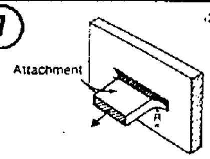
	Weld Reinforcement Removed	Weld Reinforcement Not Removed
R < 24 in.	B	C
24 in. < R < 6 in.	C	C
6 in. < R < 2 in.	D	D
2 in. < R	E	E

6 (22) (23)



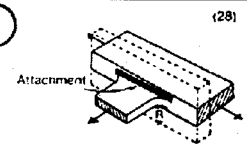
Transverse loading
Attachment -- full penetration groove weld.
Weld termination ground smooth
Unequal thickness
Weld reinforcement removed
R > 2 in. (D)
R ≤ 2 in. (E)
Weld reinforcement not removed
any R (E)

7 (24)



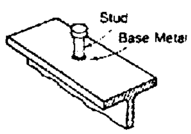
Transverse loading
Attachment — full penetration groove weld
Weld termination ground smooth
Weld reinforcement not removed
R > 6 in (C)
6 in > R > 2 in (D)
R < 2 in (E)

8 (28)



Attachment — Transverse load
Fillet welds
Weld termination ground smooth
Main material longitudinal loaded
Using a transition radius of
R > 2 in (D)
R ≤ 2 in. (E)

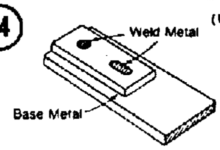
13 (29) (30)



Base metal at stud — type shear connector — fillet weld attachment or automatic end weld (C)

Shear stress on nominal area of stud-type shear connectors (F)

14 (15)



Base metal at plug or slot welds
(E)

Shear on plug or slot welds
(F)

Allowable Stress Range, Ksi

Category (from Table A-K4.2)	20,000 to 100,000 ~	100,000 to 500,000 ~	500,000 to 2×10^6 ~	Over 2×10^6 ~
A	63	37	24	24
B	49	29	18	16
B'	39	23	15	12
C	35	21	13	10[a]
D	28	16	10	7
E	22	13	8	5
E'	16	9	6	3
F	15	12	9	8

[a] Flexural stress range of 12 ksi permitted at toe of stiffener welds on flanges.

allowable fatigue stress $\boxed{\sigma_{max} = \frac{\sigma}{1 - K}}$ for normal stress

$\boxed{\tau_{max} = \frac{\tau}{1 - K}}$ for shear stress

but shall not exceed steady allowables

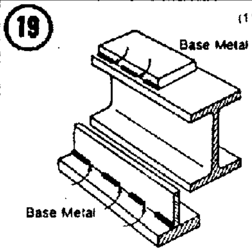
σ_{max} or τ_{max} = maximum allowable fatigue stress

σ_{sr} or τ_{sr} = allowable range of stress from table

$$K = \frac{\sigma_{min}}{\sigma_{max}} = \frac{M_{min}}{M_{max}} = \frac{F_{min}}{F_{max}} = \frac{\tau_{min}}{\tau_{max}} = \frac{V_{min}}{V_{max}}$$

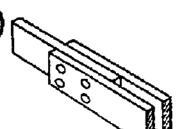
S = shear
T = tension
R = reversal
M = stress in metal
W = stress in weld

19 (11)



Base metal at intermittent fillet welds
(E)

20 (16) (17) (18)

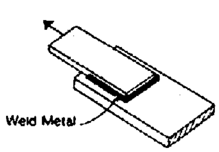


Base metal at *gross section* of high strength bolted *slip-critical* connections — No out of plane bending (B)

Base metal at *net section* of fully tensioned high strength bolted *bearing* connections (B)

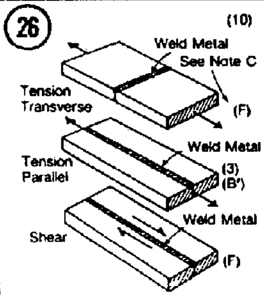
Base metal at net section of other mechanical fastened joints (D)

25 (14)



Weld metal of continuous or intermittent longitudinal or transverse fillet welds
(F)

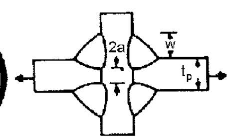
26 (10)



Partial penetration groove welds

NOTE C

$$\sigma_{sr} = \tau_{sr}^{c} \left(\frac{0.71 - 0.65 \frac{2a}{t_p} + 0.79 \frac{W}{t_p}}{1.10\, t_p^{1/6}} \right)$$



for fillet welds $\frac{2a}{t_p} = 1.0$

$$\left(\frac{0.06 + 0.79 \frac{W}{t_p}}{1.10\, t_p^{1/6}} \right)$$

but $\sigma_{xr} \le \tau_{xr}^{c}$

σ_{sr} = stress range for this condition
τ_{sr}^{c} = stress range for category (C)
W = leg size of fillet weld
2a = lack of penetration into joint
t_p = plate thickness

Figure 4-5. (Concluded)

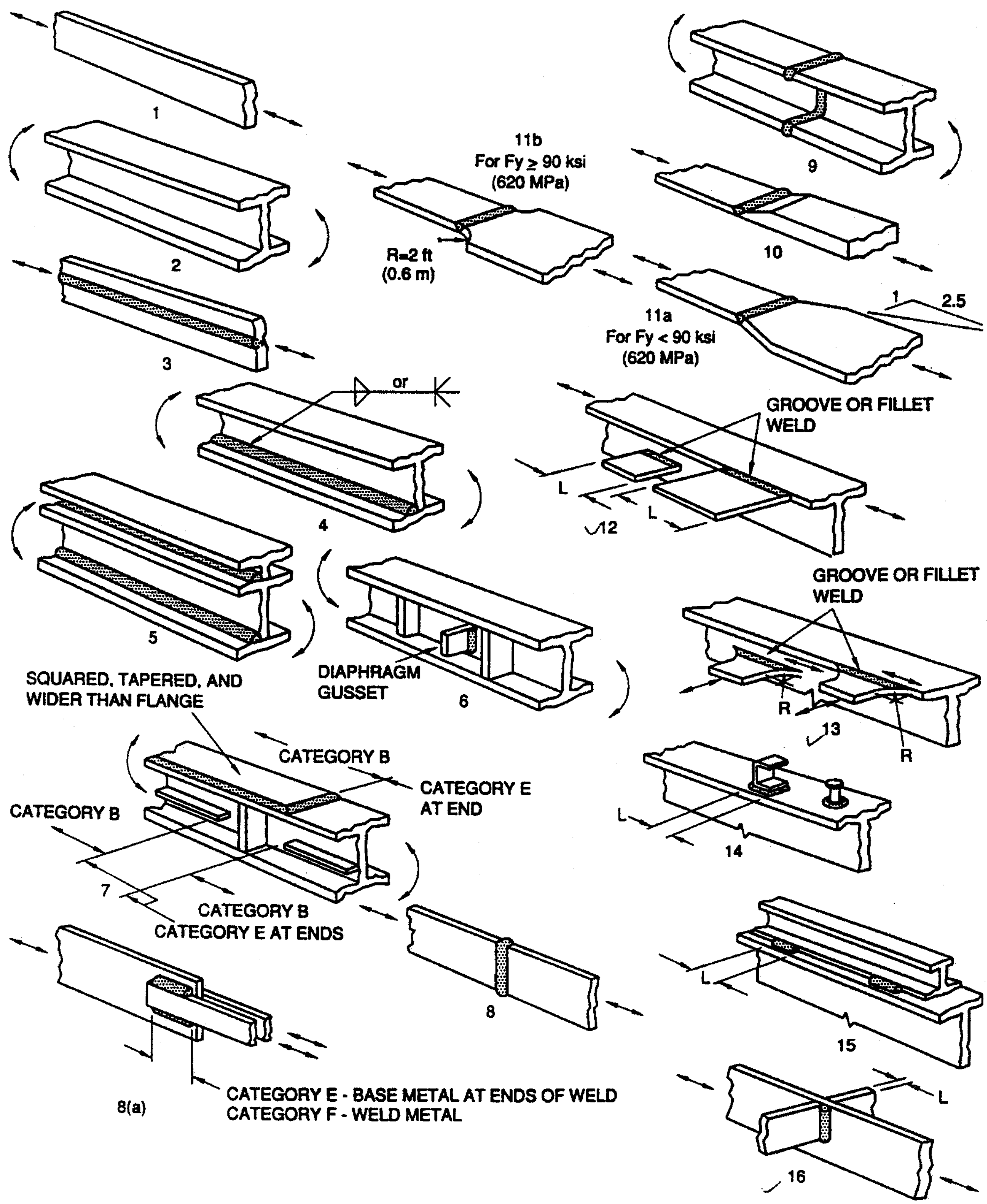


Figure 4-6. Fatigue categorization for nonredundant and redundant structure detail

Table 4-1
Fatigue Categories for Redundant and Nonredundant Structures

Category	Constant m	Constant A, cycles	Fatigue Limit, ksi
		Nonredundant Structures	
A	-4.76	1.800×10^{12}	22.0
B	-3.73	2.044×10^{10}	15.8
C (stiffeners)			
12.5 > S > 10.9	-18.18	3.666×10^{25}	10.9
19.0 > S > 12.5	-5.93	1.706×10^{12}	10.9
C (other attachments)	-5.93	1.706×10^{12}	9.0
D	-3.75	2.945×10^{9}	4.7
E	-3.85	1.392×10^{9}	2.4
F 9.0 > S > 7.0	-9.88	1.359×10^{15}	7.0
F S > 9	-6.74	1.359×10^{12}	7.0
		Redundant Structures	
A	-3.32	8.070×10^{10}	21.7
B	-3.11	1.466×10^{10}	15.5
C (stiffeners)	-3.29	7.729×10^{9}	11.3
C (other attachments)	-3.29	7.729×10^{9}	10.0
D	-2.98	1.914×10^{9}	7.0
E	-2.99	9.817×10^{8}	5.0
F	-5.68	4.840×10^{11}	8.0

i. The cumulated fatigue damage degree (i.e., without crack found in the member) is estimated by comparing the cycles to date with the total fatigue life. The difference between these two values is the remaining fatigue life. The remaining fatigue life converted into a length of time is dependent upon the projected ADO curve. A scheduled inspection and evaluation plan for the bridge can be developed based on the projected remaining fatigue life.

j. A practical procedure for the estimation of fatigue life can be summarized as follows:

(1) Examine the structural detail in question and determine its fatigue category.

(2) Estimate the maximum full stress range, which must reflect the extreme stress values caused by overloads.

(3) If the maximum full stress range does not exceed the fatigue limit of the structural detail in question, fatigue cracking is unlikely to occur. The fatigue life is taken as infinite. Additional assessment is unnecessary at this time.

(4) If the maximum full stress range exceeds the fatigue limit of the structural detail in question, the fatigue life is not infinite, and the risk of fatigue cracking must be assessed. The total fatigue life is determined using the appropriate S-N relationship.

(5) Use the ADO information to determine the stress cycles to date and the remaining fatigue life. Use projected ADO information to convert the remaining life cycles to number of years. If the remaining fatigue life is judged to be inadequate, retrofitting or strengthening measures should be considered to extend the bridge life.

4-5. Prediction of Crack Growth

a. Fatigue is a process causing cumulative damage from repeated loading. Fatigue damage occurs at stress concentrated regions where the localized stress exceeds the material yield stress. After a certain number of load cycles, the accumulated damage results in crack initiation, as well as propagation. Fatigue life is the sum of the total number of cycles required to initiate a crack and propagate the crack to failure.

$$N_T = N_i + N_p \tag{4-6}$$

where

N_T = total number of life cycles

N_i = initiation life

N_p = propagation life

Fatigue assessment is performed to determine the remaining life of a bridge.

b. A crack under repeated loading could be a nonpropagating crack. Tensile plastic strains developed at the crack tip during the initial tensile loading can result in compressive residual stresses upon unloading. If subsequent tensile loading is not sufficient to reopen this closed crack tip, the crack will not grow. Therefore, for a crack to propagate, the stress intensity factor must exceed a threshold value. The threshold values given below are applicable to martensitic, bainitic, ferrite-pearlite, and austenitic steels, which are the primary bridge steels (Barsom and Rolfe 1987).

$$\Delta K_{th} = 6.4(1 - 0.85R)\,\text{ksi sqt(in) for } R > 0.1 \tag{4-7}$$

$$\Delta K_{th} = 5.5 \text{ ksi sqt(in) for } R < 0.1 \tag{4-8}$$

where

R = the fatigue ratio which can be defined as the ratio of minimum stress to the maximum stress

ΔK_I = stress intensity factor range which is determined using the full applied stress range (i.e., the maximum stress minus the minimum stress) for welded structures

c. The crack will propagate according to Paris's power law of propagation if the stress intensity factor range is greater than the threshold value (Barsom and Rolfe 1987). Ferritic-pearlitic steels such as ASTM A36 and A572 Grade 50 steels are commonly used in bridge construction. For welded steel bridges fabricated with this type of material, the following crack growth rate equation has been developed:

$$da/dN = 3.6 \times 10^{-10} (\Delta K_I)^3 \tag{4-9}$$

d. Crack growth rate accelerates as the subcritical crack approaches its critical dimension. Catastrophic fracture of the distressed bridge structural member will occur when the stress intensity factor at the maximum load reaches the critical fracture toughness value (i.e., $K_I = K_{Ic}$).

4-6. Fracture and Fatigue Assessment Procedures

a. The following fracture and fatigue procedures have been used for assessing a bridge's fitness for service (Barsom and Rolfe 1987).

(1) On the basis of the inspection data, determine the maximum initial crack size a_o present in the distressed connections and calculate the associated K_I.

(2) Knowing K_{Ic} for the material and the nominal maximum design stress, calculate the critical crack size (a_{cr}) that would cause failure by brittle fracture.

(3) Determine fatigue crack growth rate using Paris's power law.

(4) Determine K_I using the appropriate equation, the estimated initial crack size a_o, and the range of live load stress.

(5) Integrate the crack growth rate equation between the limits of a_o (at the initial K_I) and a_{cr} (at K_{Ic}) to obtain the life of the structure prior to failure. To identify inspection intervals, integration may be applied with the upper limit being the tolerable size (a_t). A safety factor of 2 may be appropriate for some applications. Another consideration to specifying a tolerable crack size is the crack growth rate (*da/dN*). The tolerable crack size (a_t) should be chosen such that the crack growth rate (*da/dN*) is relatively small and a reasonable length of time remains before the critical size is reached.

b. Large embedded cracks or surface cracks may be recategorized into an equivalent surface crack or a through-thickness crack, respectively. The crack recategorization procedure is as follows:

(1) For embedded cracks, assume that the crack grows until it reaches a circular shape. Subsequently, it grows radially and eventually protrudes a surface at which time it is treated as a surface crack.

(2) For surface cracks, the initial propagation will result in a semi-circular shape. Further propagation will result in the crack reaching the other surface, at which time it is treated as a through thickness crack.

4-7. Development of Inspection Schedule

Inspection schedules can be developed from number of cycles versus crack size curves. Figure 4-7 shows a schematic curve of the number of cycles versus crack size, which can be obtained from integrating the crack growth rate equation (West 1982). The critical crack size is determined by equating the maximum K_I to K_{Ic}. Repair will be needed before the crack grows to the critical dimension (a_{cr}). For some applications, repair might be made when the crack reaches one half the critical crack length (i.e., factor of safety 2). Inspection intervals may be determined by dividing the remaining life cycles into several intervals.

4-8. Fitness-for-Service Assessment Procedure

A bridge is fit for service when it performs the intended structural functions satisfactorily in service during its lifetime without reaching any serious limit state. Fitness-for-service is the concept of developing a maintenance schedule to ensure structural reliability for the lifetime of the structure. Some essential constituents to be considered when determining a structure's fitness-for-service include design, materials, welding, fatigue, codes and standards, reliability analysis, fracture control plans, failure modes, and the effectiveness of the quality assurance program. The fitness-for-service assessment procedure presented in this section addresses the evaluation of distressed existing bridges. The procedure consists of the following five steps:

- *Description of general concerns*. The general concerns include structural performance of the distressed bridge, consequences of failure, political and economic impact, costs for further inspection and repair, interruption of bridge operation due to further inspection or repair, and operation scheduling.

- *History review of the bridge and preliminary analysis*. This would include reviewing the design, drawings, performance functions, loading history, environmental conditions, properties of structural materials, welding procedures used, fracture control plan, and quality control documentation. Fatigue categorization of various joint details may also be necessary to select the appropriate S-N curve for life assessment, along with information pertaining to the location of FCMs.

- *Fracture and fatigue analysis*. After the bridge inspection has been performed, it may be necessary to perform fracture and fatigue analysis to determine if discontinuities are defects. The appropriate fracture criterion must be selected; idealization of the total stresses must be considered, and it may be necessary to recategorize the discontinuities identified in the field inspection. It may become necessary to calculate stress intensity factors and perform material testing to obtain information on the mechanical and chemical properties of the bridge members. For fatigue life estimation it may be necessary to use S-N curves and the Paris crack propagation law.

- *Fitness-for-service assessment*. With the analysis results and information obtained from the preceding steps, the life expectancy of the distressed bridge can be assessed based on the service requirements, as well as other considerations, such as, failure consequences and economic and scheduling impact due to repair or replacement of the distressed members. A fracture control plan can be developed at this time if one does not already exist.

- *Repair and damage control*. If the discontinuities are determined to be defects, a repair procedure must be developed to restore the distressed bridge to a level fit-for-service. A maintenance schedule must be developed based on the fracture and fatigue analysis to restore the bridge. If the discontinuities are determined to be noncritical at this time, then an inspection and evaluation schedule must be developed considering the estimated remaining bridge life and the calculated crack growth rate.

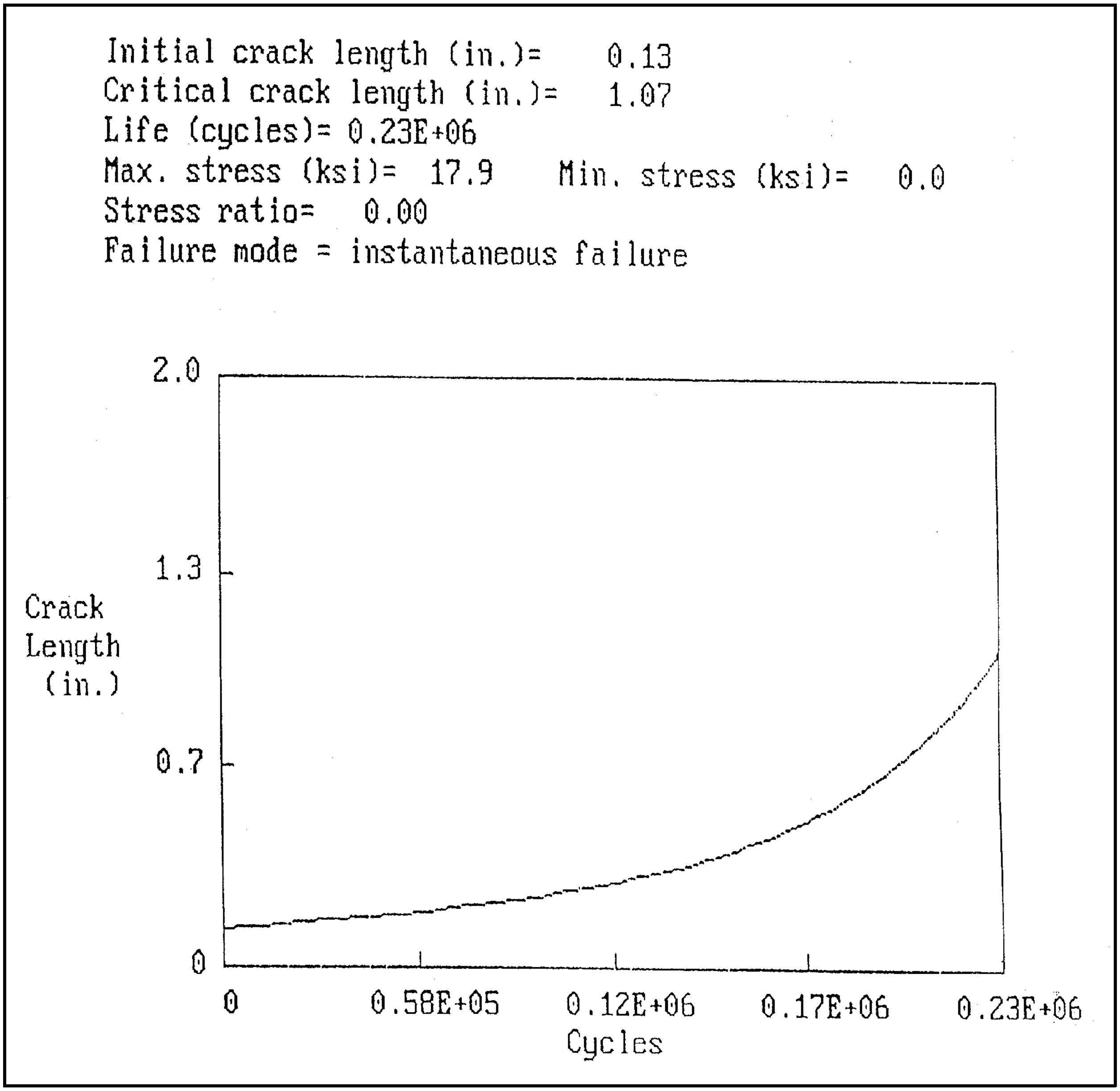


Figure 4-7. Relation between number of cycles and crack size