

PREQUALIFIED JOINT WELDING PROCEDURE  
 PROCEDURE **Grade 50**

Material specification A36  
 Welding process SMAW  
 Manual or machine MANUAL  
 Position of welding ALL POSITIONS  
 Filler metal specification E7018  
 Filler metal classification LOW HYDROGEN  
 Flux N/A  
 Weld metal grade\* \_\_\_\_\_ Flow rate \_\_\_\_\_  
 Single or multiple pass SINGLE MULTIPLE  
 Single or multiple arc SINGLE  
 Welding current DC  
 Polarity REVERSE  
 Welding progression TIG IF ZG&UF  
 Root treatment GRIND & WIRE BRUSH  
 Preheat and interpass temperature \_\_\_\_\_  
 Postheat treatment NONE

**Grade 50**

**A 5.1**

**E 7018**

**What is this?**

**Per AWS D1.5**

\*Applicable only when filler metal has no AWS classification.

WELDING PROCEDURE

Pass no.	Electrode size	Welding current		Travel speed	Joint detail
		Amperes	Volts		
2	5/32	180	30	4" / min	PILE SPLICE WELDING DETAIL

Contractor R:

BLOW & COTE, INC.  
 315 VT Route 16 East  
 Morrisville, VT 05651

Vermont Agency of Transportation  
**RECEIVED**

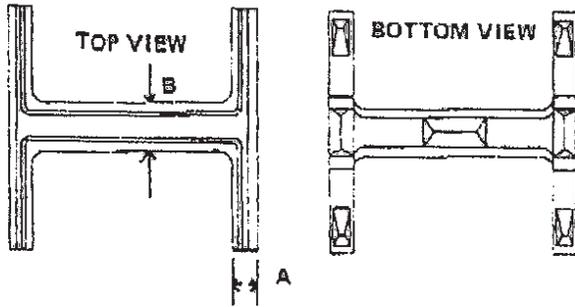
CK'D BY JC OK'D BY JS

January 20, 2015

RESUBMIT YES Rejected  
 BY KH DATE 2-5-2015

PROJECT:  
 CAMBRIDGE BRD 1448(39)  
 Submitted by:  
 MARC COTE

**Dimensions**



Material Cast Steel



	8"	10"	12"
A	1-1/16"	1"	1"
B	1"	1"	1-5/16"
C	1-7/8"	2-1/16"	2-1/2"

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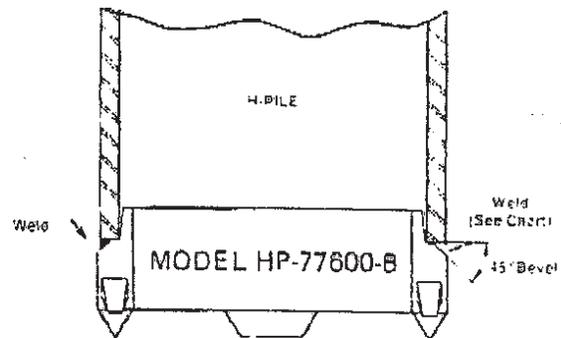
RESUBMIT YES Rejected

BY KH DATE 2-5-2015

**Installation Instructions**

HARD-BITE POINT MODEL HP-77600-B

1. Fit point onto the end of a square cut pile end.
2. Weld point to the pile in either flat or vertical position using E60 or E70XX electrodes.
3. Weld across full width of flange following chart below for minimum size weld.



Pile Size	Flange Thickness	Min. Size Groove Weld
HP 14 x 117	.805	7/16
x 102	.705	3/8
x 88	.615	3/8
x 73	.505	5/16
HP 12 x 84	.685	3/8
x 74	.610	3/8
x 63	.515	5/16
x 53	.425	5/16
HP 10 x 57	.565	5/16
x 42	.420	5/16
HP 8 x 36	.445	5/16

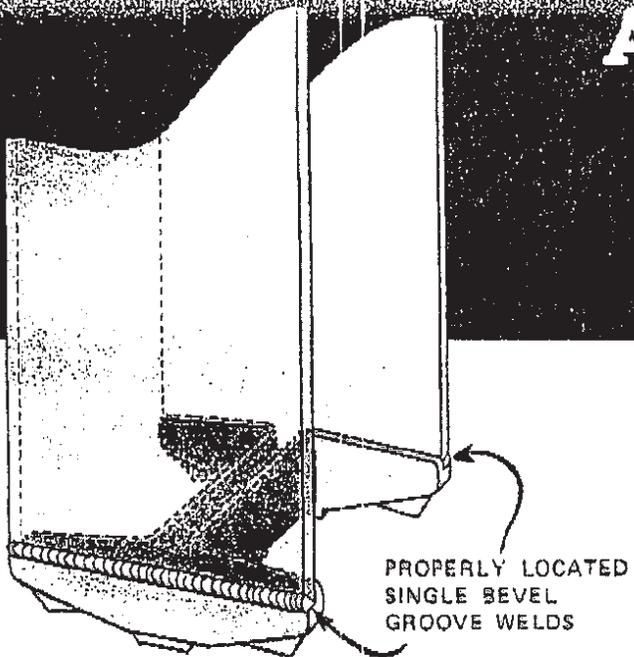
Call toll free 800-526-9047



**ASSOCIATED PILE & FITTING CORP.**

BOX 1048, CLIFTON, N.J. 07014 ■ 201-773-8400

# ATTACHMENT

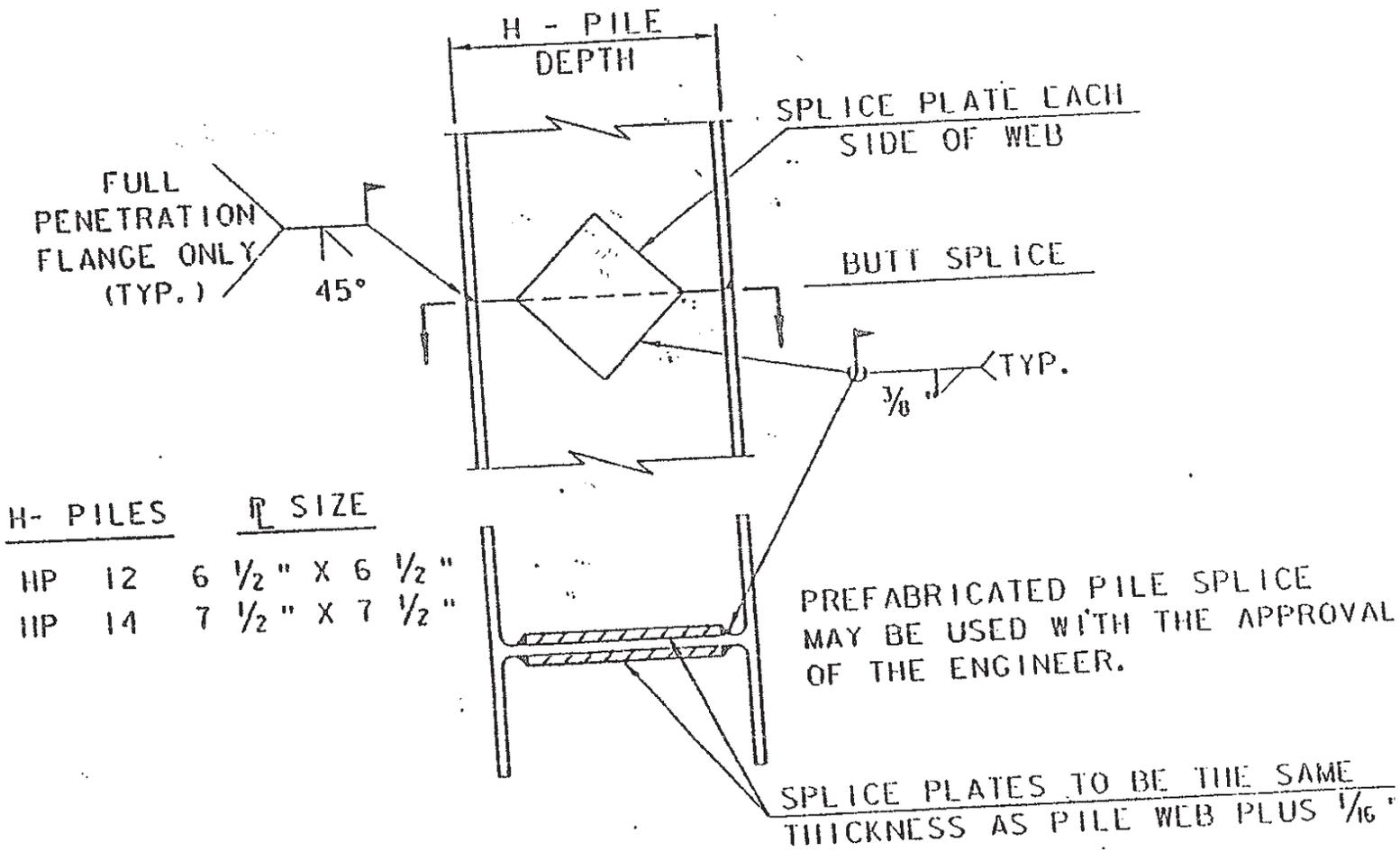


## RELIABLE ATTACHMENT IS QUICK AND EASY

APF Cast Steel H-Pile Points are designed for ease of handling and attachment. The integrally cast back-ups for welding, position the point accurately on the pile. For proper load transfer, the points must be attached by a single bevel groove weld across the outside of each flange. With correct weld placement, the load transfers cleanly to the point. Welding along the inside of the flanges is not advisable as it creates a stress pattern which could prove detrimental to the integrity of the pile. An E60 or E70 rod is suggested for manual welding.

SIZE OF PILE	FLANGE THICKNESS (INCHES)	SIZE OF GROOVE WELD
HP 14 x 117	0.805	7/16"
x 102	0.705	3/8"
x 89	0.615	5/16"
x 73	0.505	5/16"
HP 13 x 100	0.765	3/8"
x 87	0.665	5/16"
x 73	0.565	5/16"
x 60	0.460	5/16"
HP 12 x 84	0.685	5/16"
x 74	0.610	5/16"
x 63	0.515	5/16"
x 53	0.435	5/16"
HP 10 x 67	0.565	5/16"
x 42	0.420	5/16"
HP 8 x 36	0.445	5/16"

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DETAIL OF PILE SPLICE

N.T.S.

CONTRACTOR!

BLOW & COTE, INC.  
 815 VT Route 15 East  
 Morrisville, VT 05661

PROJECT!

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SUBMITTED BY:  
 MARC COTE

Work Log for Adam Thomann dba Spectrum Welding

Certified 12/31/2009

Please include his qualification/certification documents.

Worked for the following Vermont companies since 2009 on various Vermont projects that required a welding certification;

- CCS Construction
- Cote Steel Erectors
- Quarry Industrial Services
- Nops Metal Works
- St. Onge Construction

Feb 2010

Kubricky Construction  
Bridge Welding requiring certification.

August – September 2010

Dartmouth Medical Center - NH moment connections  
CCS – White River Train Bridge

January – December 2011

Kubricky Construction  
2 bridges in Ludlow Vermont requiring welding certification.

January – December 2012 & 2013

Cote Steel Erectors  
Colchester Steel Building requiring welding certification.

November – December 2013, April – May 2014

Blow & Cote, Inc.  
Bristol BRO 1445(32) – Pile Splices

August – 2014

The Belden Co.  
Rutland BRF 3000(18) – Pile Splices

November – 2014

ECl Engineers Construction  
Ryegate CULV(10)

