

GREEN & WHITE MOUNTAINS SECTION
AMERICAN WELDING SOCIETY



WELD QUALIFICATION TEST REPORT

NAME : Jerry Oudette SOCIAL SECURITY # 008-40-0116
ADDRESS : HCR 71 Box 76B TELEPHONE # 802-484-5048
CITY : Brownville COUNTY : Wendson
STATE : VT ZIP : 05037 TEST DATE : 4-8-94

CO / NAME : _____

TEST TYPE : AWS D1.1 5.10A AMBIENT TEMP : 70 PREHEAT : NA
PROCESS : SMAW INTERPASS TEMP : NA
POSITION : 3G PASSES REQUIRED : 11
BASE MATERIAL : A36 AMPS : 150 VOLTS : 22
THICKNESS : 1 TRAVEL SPEED : _____
EDGE PREPARATION : Sawed CLEANING : Chip + Brush
POWER SOURCE : SAM 400

TYPE OF CURRENT DC SPECIMEN TYPE : AWS 5.10.135

FILLER METAL TYPE : E7018 LAB NUMBER : 94003
FILLER METAL DIA : 5/32 DATE : 4-8-94

FLUX TYPE : NA TEST RESULTS : *****
VISUAL : Accepted

SHIELD GAS TYPE : NA BEND TEST : Accepted

GAS FLOW RATE : NA FACE : NA SIDE : ✓
ROOT : NA

WITNESSED BY CWI # 92070051
RAY HENDERSON II

Ray Henderson, II
AWS
QC
Ray Henderson, II
92070051
CWI

GREEN & WHITE MOUNTAINS SECTION
AMERICAN WELDING SOCIETY

0921-275
543-1260



WELD QUALIFICATION TEST REPORT

NAME : Jerry Orslette SOCIAL SECURITY # 008-40-0116
ADDRESS : HCR 71 Box 76B TELEPHONE # 802-484-5048
CITY : Brownsville COUNTY : Windham
STATE : VT ZIP : 05037 TEST DATE : 4-8-94
CO / NAME : _____

TEST TYPE : AWS D1.1 5.18A AMBIENT TEMP : 70 PREHEAT : NA
PROCESS : SMAW INTERPASS TEMP : NA
POSITION : 4G PASSES REQUIRED : 13
BASE MATERIAL : A-36 AMPS : 150 VOLTS : 22
THICKNESS : 1" TRAVEL SPEED : _____
EDGE PREPARATION : Sewed CLEANING : Chip + Brush
POWER SOURCE : SAM 400

TYPE OF CURRENT DC
FILLER METAL TYPE : E7018
FILLER METAL DIA : 5/32
FLUX TYPE : NA
SHIELD GAS TYPE : NA
GAS FLOW RATE : NA

SPECIMEN TYPE : AWS 5.10.1.35
LAB NUMBER : 94004
DATE : 4-8-94
TEST RESULTS : *****
VISUAL : Acceptable
BEND TEST : Acceptable
FACE : NA SIDE : V
ROOT : NA

WITNESSED BY CWI # 92070051
RAY HENDERSON II

Ray Henderson II
Ray C. Henderson, II
92070051
CWI



GREEN & WHITE MOUNTAINS SECTION
AMERICAN WELDING SOCIETY



WELD QUALIFICATION TEST REPORT

NAME : Jerry Oudette SOCIAL SECURITY # 008-40-0116
ADDRESS : HCR 71 Box 76B TELEPHONE # 802-484-5048
CITY : Brownville COUNTY : Windsor
STATE : VT ZIP : 05037 TEST DATE : 4-8-94
CO / NAME : _____

TEST TYPE : AWS Q1.1 5.10A AMBIENT TEMP : 70 PREHEAT : NA
PROCESS : SMAW INTERPASS TEMP : NA
POSITION : 3G PASSES REQUIRED : 11
BASE MATERIAL : A36 AMPS : 150 VOLTS : 22
THICKNESS : 1 TRAVEL SPEED : _____
EDGE PREPARATION : Sawed CLEANING : Chip + Brush
POWER SOURCE : SAM 400
TYPE OF CURRENT : DC SPECIMEN TYPE : AWS 5.10.1.35
FILLER METAL TYPE : E7018 LAB NUMBER : 94003
FILLER METAL DIA : 5/32 DATE : 4-8-94
FLUX TYPE : NA TEST RESULTS : *****
SHIELD GAS TYPE : NA VISUAL : Acceptable
GAS FLOW RATE : NA BEND TEST : Acceptable
FACE : NA SIDE : ✓
ROOT : NA

WITNESSED BY CWI # 92070051
RAY HENDERSON II

GREEN & WHITE MOUNTAINS SECTION
AMERICAN WELDING SOCIETY

09701-1260
543-1260



WELD QUALIFICATION TEST REPORT

NAME : Jerry Orslette SOCIAL SECURITY # 008-40-0116
ADDRESS : HCR 71 Box 76B TELEPHONE # 802-484-5048
CITY : Brownsville COUNTY : Windham
STATE : VT ZIP : 05037 TEST DATE : 4-8-94
CO / NAME : _____

TEST TYPE : AWS Q1.1 5.18A AMBIENT TEMP : 70 PREHEAT : NA
PROCESS : SMAW INTERPASS TEMP : NA
POSITION : 4G PASSES REQUIRED : 13
BASE MATERIAL : A-36 AMPS : 150 VOLTS : 22
THICKNESS : 1" TRAVEL SPEED : _____
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TYPE OF CURRENT DC
FILLER METAL TYPE : E7018
FILLER METAL DIA : 5/32
FLUX TYPE : NA
SHIELD GAS TYPE : NA
GAS FLOW RATE : NA

SPECIMEN TYPE : AWS 5.10.1.35
LAB NUMBER : 94004
DATE : 4-8-94
TEST RESULTS : *****
VISUAL : Acceptable
BEND TEST : Acceptable
FACE : NA SIDE : V
ROOT : NA

WITNESSED BY CWI # 92070051
RAY HENDERSON II

Ray Henderson II
Ray C. Henderson, II
92070051
CWI

POINT

PILE ~~SPLICE~~ WELDING PROCEDURE
 ROCKINGHAM BRF 0126(12)-COLD RIVER BRIDGES,LLC

MATERIAL SPEC	ASTM A572 GR 50
WELDING PROCESS	SMAW
MANUAL OR MACHINE	MAUAL
POSITION OF WELDING	HORIZONTAL
FILLER METAL SPEC	AWS A5.1
FILLER METAL CLASSIFICATION	E7018
FLUX	N/A
SHIELDING GAS	N/A
SINGLE OR MULTIPLE PASS	MULTIPLE IF REQUIRED
SINGLE OR MULTIPLE ARC	SINGLE
WELDING CURRENT	DC
POLARITY	REVERSE
WELDING PROCEDURE	N/A
ROOT TREATMENT	POINTS PRE-BEVELED TO PROFILE
PREHEAT AND INTERPASS TEMPERATURE	PER AWS D1.1
POST HEAT TREATMENT	NONE

WELDING PROCEDURE

PASS #	ELECTRODE SIZE	WELDING CURRENT		TRAVEL SPEED	JOINT DETAIL
		AMPS	VOLT		
1	1/8"	120-150	12-24	1 FT/MIN	
2+	5/32"	140-180	12-24	1FT/MIN	

This procedure may vary due to fabrication sequence, fit-up, pass size, ect. Within the limitations of variables given in section 5

PROCEDURE-PILE POINT
 REVISION#-0

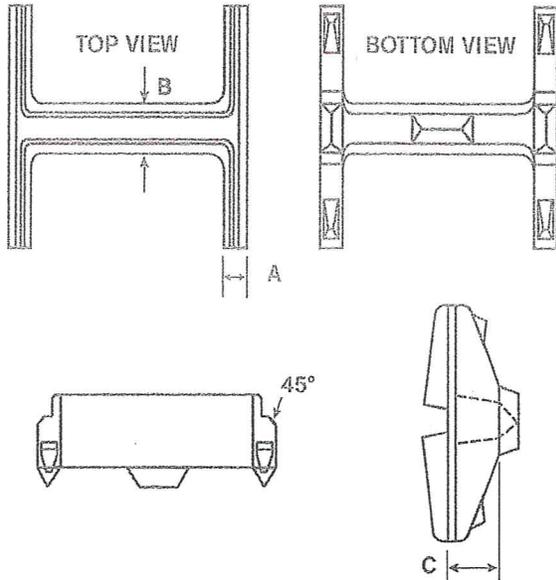
CONTRACTOR: COLD RIVER BRIDGES,LLC

AUTHORIZED BY:

DATE: 1-26-15

HARD-BITE™ – HP-77600-B 30#

Dimensions



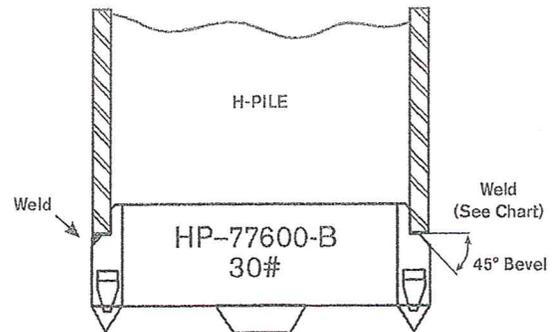
MATERIAL: CAST STEEL

ASTM A148 90/60

	12"
A	1"
B	1-5/16"
C	3"
Wt.	31#

Installation Instructions

1. Fit point onto the end of the square cut pile end.
2. Weld point to the pile in either flat or vertical position using E7018 electrodes.
3. Weld across full width of flange following chart below for minimum size weld.



Pile Size	Flange Thickness	Groove Weld
HP 12 x 84	.685	3/8
x 74	.610	3/8
x 63	.515	5/16
x 53	.435	5/16



**ASSOCIATED PILE
& FITTING**

PO Box 5933 Parsippany, NJ 07054-5933

Tel: 973-773-8400

Fax: 973-428-5146

email: apf@associatedpile.com

www.associatedpile.com

Call Toll Free: 800-526-9047

PILE SPLICE WELDING PROCEDURE
ROCKINGHAM BRF 0126(12)-COLD RIVER BRIDGES,LLC

MATERIAL SPEC	ASTM A572 GR 50		
WELDING PROCESS	SMAW		
MANUAL OR MACHINE	MAUAL		
POSITION OF WELDING	HORIZONTAL		
FILLER METAL SPEC	AWS A5.1		
FILLER METAL CLASSIFICATION	E7018		
FLUX	N/A		
SHIELDING GAS	N/A		
SINGLE OR MULTIPLE PASS	MULTIPLE IF REQUIRED		
SINGLE OR MULTIPLE ARC	SINGLE		
WELDING CURRENT	DC		
POLARITY	REVERSE		
WELDING PROCEDURE	N/A		
ROOT TREATMENT	GRIND/BEVEL TO PROFILE		
PREHEAT AND INTERPASS TEMPERATURE	PER AWS D1.1		
POST HEAT TREATMENT	NONE		

WELDING PROCEDURE

PASS #	ELECTRODE SIZE	WELDING CURRENT		TRAVEL SPEED	JOINT DETAIL
		AMPS	VOLT		
1	1/8"	120-150	12-24	1 FT/MIN	
2+	5/32"	140-180	12-24	1FT/MIN	

This procedure may vary due to fabrication sequence, fit-up, pass size, ect. Within

the limitations of variables given in section 5

PROCEDURE-VAOT DIAMOND SPLICE

REVISION#-0

CONTRACTOR:

COLD RIVER BRIDGES,LLC

AUTHORIZED BY:

DATE: 1/23/15