



CONSTRUCTION LEADERS

SUBMITTAL NO. : 48
Structural Steel Repair Procedure

Item No.	Specification	Description
1	N/A	Structural Steel Repair Procedure

PROJECT:
HARTFORD LATERAL SLIDE
PROJECT NO.: IM 091-2(79)
CONTRACT ID.: 12A132

OWNER:
STATE OF VERMONT AGENCY OF TRANSPORTATION

ENGINEER OF RECORD:
STATE OF VERMONT AGENCY OF TRANSPORTATION

CONTRACTOR:
PCL CIVIL CONSTRUCTORS, INC.

JUNE 16, 2015

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Submitter Info: Structural Steel Repair Procedure.pdf
CK'D BY JC OK'D BY JS
June 24, 2015
RESUBMIT NO Approved
BY JS DATE 6-25-2015

Structural Steel Repair Procedure

During inspection it was discovered that (2) small areas on I-91NB girder #6 were cut into with a torch. See pictures below for reference:



This happened when the welder cut and moved one of the legs for the fall protection. The welder has since been talked to as has the crew. If cutting of any temporary members is required grinders (not torches) are to be used. In no situation shall the permanent girders be damaged.

PCL proposes the following repair procedure:

1. Grind off all latent materials
2. Fill divots with weld (E70XX)
3. Grind area to be flush with flange

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WELDER, WELDING OPERATOR OR TACK WELDER QUALIFICATION TEST RECORD

Code: AASHTO/AWS D1.5M/D1.5:2010

Name: Chris Bodisher

Identification No. 0314CB

Welding Procedure Specification No. AWS B2.1-1-016-94R

Date: 05/12/2015

Variables		Record Actual Values Used in Qualification	Qualification Range
Process/Type		SMAW	SMAW
Electrode (single or multiple)		Single	Single
Current/Polarity		DCEP	DCEP
Position		2G	Flat/Horizontal
Backing (YES or NO)	Weld Progression	N/A	N/A
Material/Spec.		Yes	With Steel Backing Only
Base Material		M 270M/ M270 (A 709/A 709M) Gr. 250 [Gr. 36]	M 270M/ M270 (A 709/A 709M) Gr. 250 [Gr. 36]
	Thickness (Plate)		
	Groove	1"	1/8" to Unlimited
	Fillet	N/A	Flat, Horizontal
	Thickness: (Pipe/Tube)		
	Groove	N/A	1/8" to Unlimited
	Fillet	N/A	Unlimited Thickness
	Diameter: (Pipe)		
	Groove	N/A	N/A
	Fillet	N/A	N/A
Filler Metal			
		AWS A5.1	AWS A5.1/A5.1M or AWS A5.5/A5.5M
		E7018	E7018
		F4	F4 Only
		N/A	N/A
		N/A	N/A

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Visual Inspection: Acceptable YES or NO

Guided Bend Test Results

Type	Results	Type	Results
Side	Accept		N/A
Side	Accept		N/A

Fillet Test Results

Appearance: N/A Fillet Size: N/A
 Fracture Test Root Penetration: N/A Macro etch: N/A
 (Describe the location, nature and size of any crack or tearing of specimen.)
 N/A

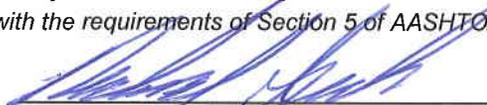
Inspected by: Richard Irick Test No: N/A
 Organization: VT Nondestructive Testing Date: N/A

Radiographic Results

Film Identification			Film Identification		
Number	Results	Remarks	Number	Results	Remarks

Interpreted by: N/A Test Number: N/A
 Organization: N/A Date: N/A

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded and tested in accordance with the requirements of Section 5 of AASHTO/AWS D1.5M/D1.5:2010 Bridge Welding Code

Inspected by: 
 Richard Irick AWS/CWI
 Contractor: PCL Civil Constructors Inc.

Witnessed by: Richard Irick
 Date: 5/12/2015

