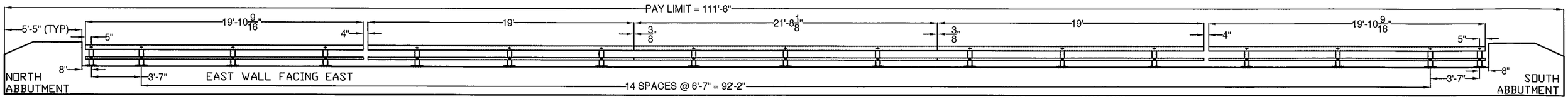
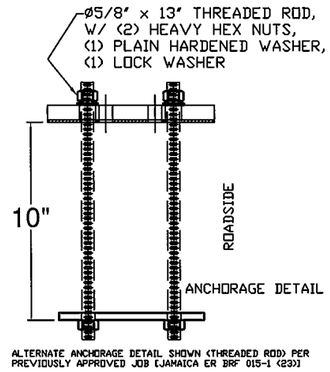
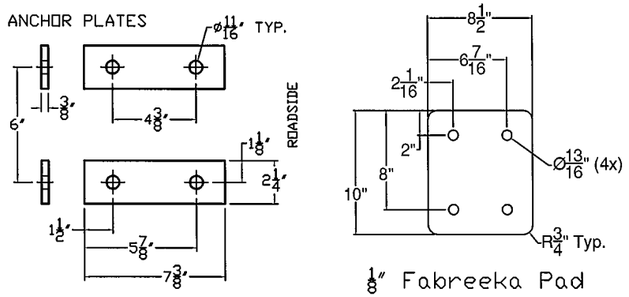
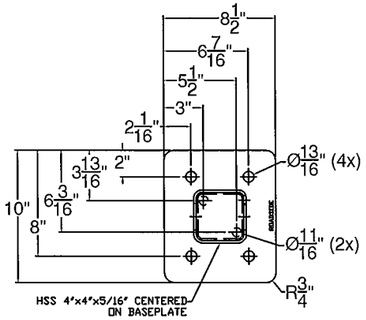
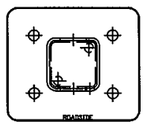
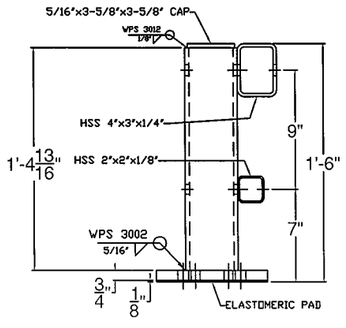


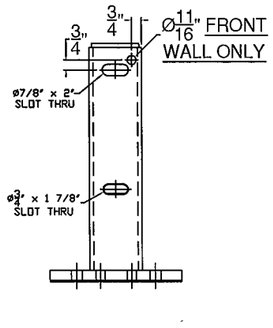


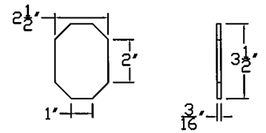


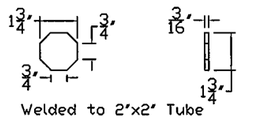


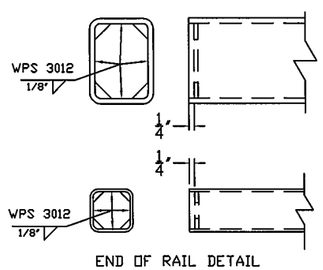












Vermont Agency of Transportation

RECEIVED

ON: April 3, 2014

and Checked for

CONFORMANCE

BY: Jennifer Fitch DATE: 04/04/2014

SHOP DRAWING REVIEW

X REVIEWED AS REQUIRED BY THE CONSTRUCTION CONTRACT DOCUMENTS AND APPROVED, BUT ONLY FOR CONFORMANCE TO THE DESIGN CONCEPT OF THE WORK, AND SUBJECT TO FURTHER LIMITATIONS AND REQUIREMENTS CONTAINED IN THE CONSTRUCTION CONTRACT DOCUMENTS.

☐ REJECTED ☐ REVISE AND RESUBMIT ☐ FURNISH AS CORRECTED

CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DO NOT RELIEVE CONTRACTOR FROM COMPLIANCE WITH REQUIREMENTS OF THE DRAWINGS AND SPECIFICATIONS. THIS CHECK IS ONLY FOR REVIEW OF GENERAL CONFORMANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND GENERAL COMPLIANCE WITH THE INFORMATION GIVEN IN THE CONTRACT DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR: CONFIRMING AND CORRELATING ALL QUANTITIES AND DIMENSIONS; SELECTING FABRICATION PROCESSES AND TECHNIQUES OF CONSTRUCTION; COORDINATING HIS WORK WITH THAT OF ALL OTHER TRADES; AND PERFORMING HIS WORK IN A SAFE AND SATISFACTORY MANNER.

VHB

Job Number: 57438

Reviewed By: KZS

Date: 4/4/2014

BILL OF MATERIAL

ITEM #	QTY	PART #	DESCRIPTION	ASTM DESIGNATION
1	34	0033.90017	TWO RAIL POST & BASEPLATE ASSEMBLY	A572 Gr. 50
2	2	0033.91070	4" X 3" X 1/4" RAIL @ 19'-10 9/16" W/ END PLATES (EAST RAIL)	A500 Gr. B
3	2	0033.91071	4" X 3" X 1/4" RAIL @ 19'-11 1/2" W/ END PLATES (WEST RAIL)	A500 Gr. B
4	4	0033.91072	4" X 3" X 1/4" RAIL @ 19'-0"	A500 Gr. B
5	2	0033.91073	4" X 3" X 1/4" RAIL @ 21'-8 1/8"	A500 Gr. B
6	2	0033.91074	2" X 2" X 1/8" RAIL @ 19'-10 9/16" W/ END PLATES (EAST RAIL)	A500 Gr. B
7	2	0033.91075	2" X 2" X 1/8" RAIL @ 19'-11 1/2" W/ END PLATES (WEST RAIL)	A500 Gr. B
8	4	0033.91076	2" X 2" X 1/8" RAIL @ 19'-0"	A500 Gr. B
9	2	0033.91077	2" X 2" X 1/8" RAIL @ 21'-8 1/8"	A500 Gr. B
10	4	0033.90069	1-1/2" X 1-1/2" FIX. SPL BAR @ 2' 4"	A572 Gr. 50
11	4	0033.90328	1-1/2" X 1-1/2" EXP. SPL BAR @ 2' 4"	A572 Gr. 50
12	4	0033.90071	2-1/4" X 3-1/4" FIX. SPL. BAR @ 2' 4"	A572 Gr. 50
13	4	0033.90072	2-1/4" X 3-1/4" EXP. SPL. BAR @ 2' 4"	A572 Gr. 50
14	68	0033.00295	3/8" X 2 1/4" X 7 3/8" ANCHOR PLATES	A36
15	136	0042.05813	ø 5/8" X 13" ANCHOR STUDS	A449
16	272	0080.15901	ø 5/8" HEAVY HEX NUTS	A563
17	136	0080.15911	ø 5/8" FLAT WASHERS	F436
18	136	0080.15920	ø 5/8" LOCK WASHERS	ASME D18.2
19	34	0080.05560	ø 5/8" X 7 1/2" ROUND HEAD BOLT, NUT, F.W., & L.W.	A325, A563, F436, & ASME D18.2
20	34	0080.05585	ø 3/4" X 8 1/2" ROUND HEAD BOLT, NUT, F.W., & L.W.	A325, A563, F436, & ASME D18.2
21	32	0080.05275	ø 5/8" X 3" HEX BOLT, NUT, F.W., & L.W.	A325, A563, F436, & ASME D18.2
22	32	0080.07330	ø 7/8" X 5 1/2" HEX BOLT, NUT, F.W., & L.W.	A325, A563, F436, & ASME D18.2
23	34	0033.90068	1/8" ELASTOMERIC PAD	D2240

NOTES:

1. ALL WORK AND MATERIALS SHALL CONFORM TO SECTION 525.
2. PRIOR TO GALVANIZING THE ASSEMBLED POST, GRIND ALL EDGES TO A MINIMUM RADIUS OF 1/16".
3. ALL POSTS SHALL BE SET NORMAL TO GRADE.
4. SECTIONS OF RAIL TUBE SHALL BE ATTACHED TO A MINIMUM OF TWO BRIDGE POSTS AND PREFERABLY TO AT LEAST 4 POSTS.
5. HOLES IN RAILS FOR TUBE ATTACHMENT, MAY BE FIELD-DRILLED. HOLES SHALL BE COATED WITH AN APPROVED ZINC-RICH PAINT PRIOR TO INSTALLATION.
6. BOLTS SHALL BE TORQUED SNUG TIGHT (APPROXIMATELY 100 FT-LB).
7. RAIL TUBES SHALL BE ATTACHED USING 3/4" FULL DIAMETER BODY ASTM A449 (TYPE I) ROUND HEAD BOLTS INSERTED THROUGH THE FACE OF THE TUBE.
8. SEE STANDARD DRAWING G-1 FOR DETAILS OF DELINEATORS. A DELINEATOR SHALL BE INSTALLED AT 30 FOOT SPACING OR THE NEAREST POST. WHITE IS TO BE INSTALLED ON THE DRIVER'S RIGHT. FOR ONE WAY BRIDGES, YELLOW IS TO BE INSTALLED ON THE DRIVER'S LEFT. PAYMENT FOR DELINEATORS SHALL BE INCIDENTAL TO OTHER ITEMS.
9. AESTHETIC TREATMENT TYPE SHALL BE APPLIED AS SPECIFIED IN THE CONTRACT PLANS. IF NONE IS SPECIFIED IT SHALL NOT BE USED. AESTHETIC TREATMENT DETAILED ON THIS SHEET MAY ALSO BE APPLIED ON THE FASCIA SIDE OF THE RAIL, IF SPECIFIED IN THE CONTRACT PLANS.
10. BRIDGE RAILING SHALL HAVE A RUBBED FINISH IN ACCORDANCE WITH SECTION 501.
11. THIS RAILING MEETS THE REQUIREMENTS FOR A NCHRP REPORT 350 TL-4 SERVICE LEVEL.
12. HOLES FOR MOUNTING DELINEATORS TO BE FIELD DRILLED. HOLES SHALL BE COATED WITH AN APPROVED ZINC-RICH PAINT PRIOR TO INSTALLATION.
13. ALL STEEL COMPONENTS SHALL BE POWDER COATED BLACK AFTER GALVANIZING. COLOR SHALL CONFORM TO FEDERAL STANDARD NO. 595, COLOR CHIP NO. 27038

ITEM #: 900.640 FR Lafayette - MIDDLEBURY, (2014) SHEET 1 OF 2

APPROVED BY:

BRIDGE RAIL DETAILS SHEET

EM13-252, MIDDLEBURY RS 0174 (8)

TOWN OF MIDDLEBURY, ADDISON COUNTY, VT RTE 125 (MAJOR COLLECTOR), BRIDGE NO : 13

REV NO.	DATE	DESCRIPTION	BY	REV NO.	DATE	DESCRIPTION	BY

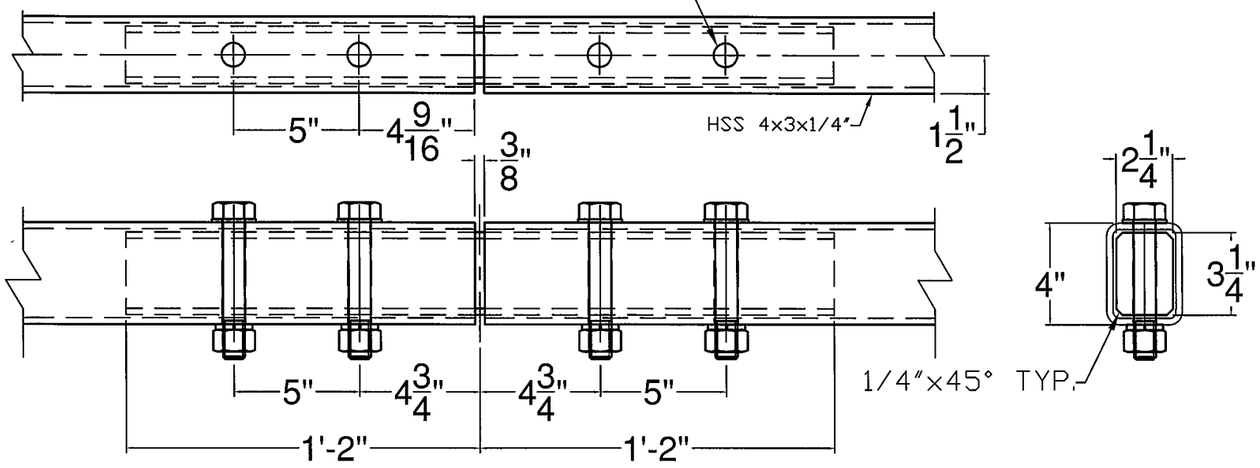
ELDERLEE, INC.
OAKS CORNERS, NEW YORK 14518
E-Mail:dlong@elderlee.com / epeek@elderlee.com
Tel:315-789-6670 Fax:315-789-6615

CERTIFIED FABRICATOR

DRAWN	E.P.	3/7/14
CHECKED	D.L.	3/10/14
APPROVED	.	.
SCALE	SCHEMATIC	
DRAWING NO.	FR L - MIDDLEBURY	

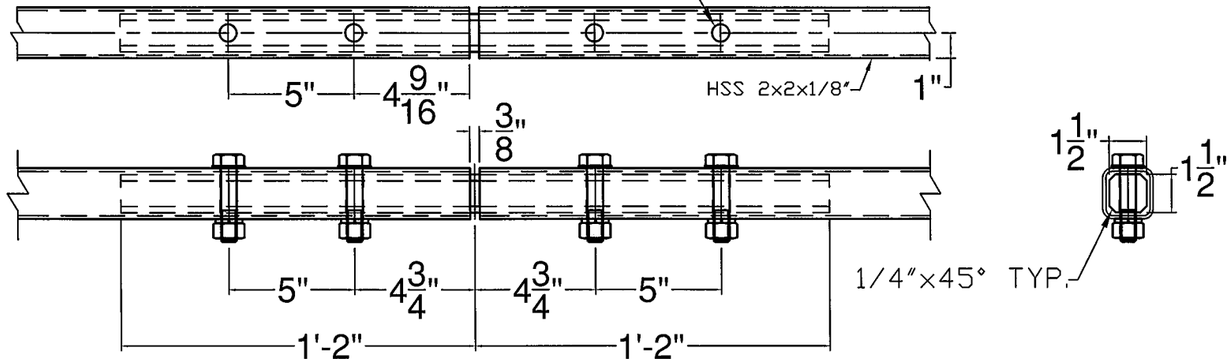
TOP RAIL FIXED SPLICE DETAIL

ø15/16" THRU TUBE & SPLICE BAR, ø7/8"X5 1/2" HEX BOLT & NUT, W/ (1) PLAIN HARDENED WASHER & (1) LOCK WASHER (4 PLACES)



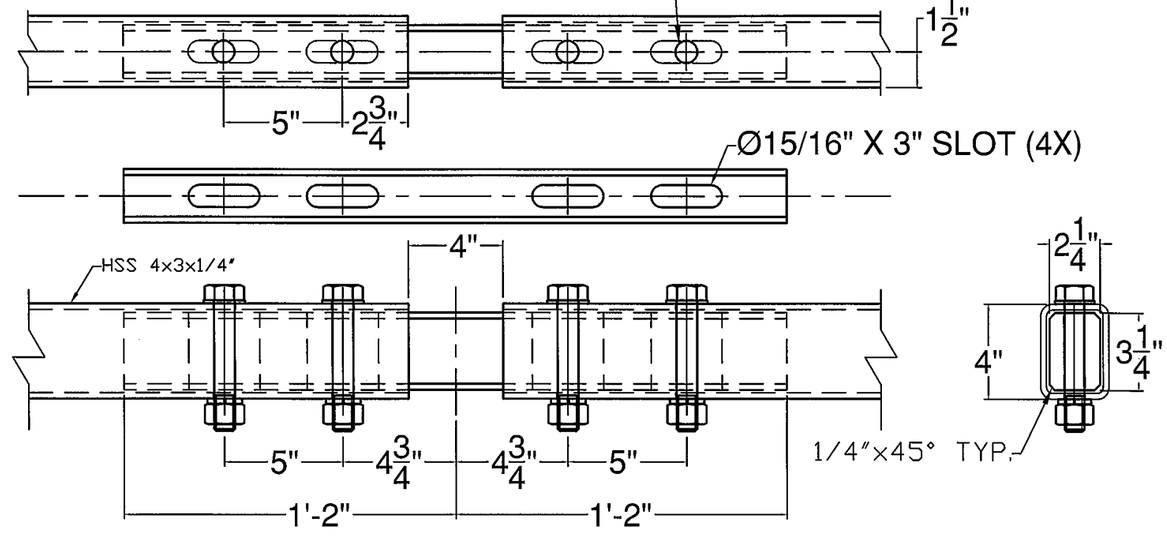
BOTTOM RAIL FIXED SPLICE DETAIL

ø11/16" THRU TUBE & SPLICE BAR, ø5/8"X3" HEX BOLT & NUT, W/ (1) PLAIN HARDENED WASHER & (1) LOCK WASHER (4 PLACES)



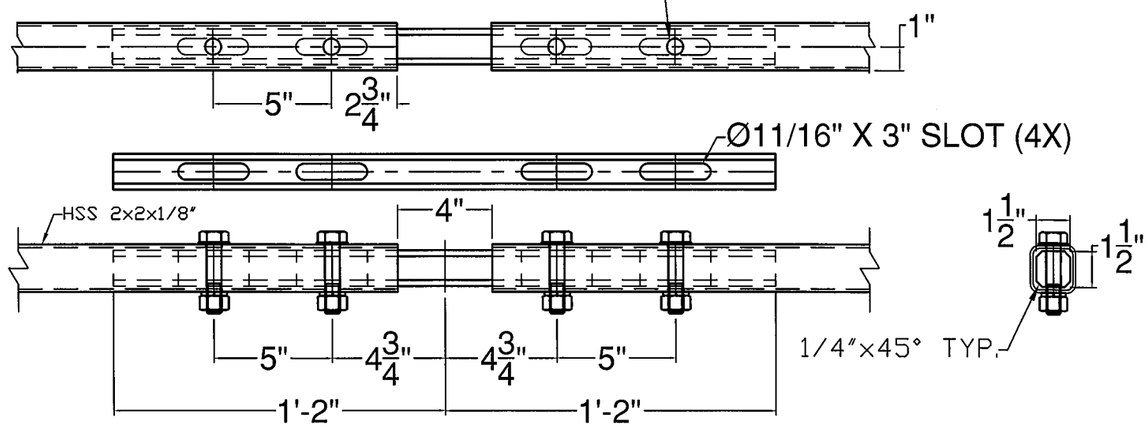
TOP RAIL EXPANSION SPLICE DETAIL

ø15/16" THRU TUBE & ø15/16" X 3" SLOT THRU SPLICE BAR, ø7/8"X5 1/2" HEX BOLT & NUT, W/ (1) PLAIN HARDENED WASHER & (1) LOCK WASHER (4 PLACES)



BOTTOM RAIL EXPANSION SPLICE DETAIL

ø11/16" THRU TUBE & ø11/16" X 3" SLOT THRU SPLICE BAR, ø5/8"X3" HEX BOLT & NUT, W/ (1) PLAIN HARDENED WASHER & (1) LOCK WASHER (4 PLACES)



SHOP DRAWING REVIEW

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VHB

Job Number: 57438
Reviewed By: KZS
Date: 4/4/2014

Vermont Agency of Transportation

RECEIVED

ON: April 3, 2014

and Checked for

CONFORMANCE

BY: Jennifer Fitch DATE: 04/04/2014

ITEM #: 900.640

FR Lafayette - MIDDLEBURY, (2014)

SHEET 2 OF 2

APPROVED BY:

BRIDGE RAIL DETAILS SHEET

EM13-252, MIDDLEBURY RS 0174 (8)

TOWN OF MIDDLEBURY, ADDISON COUNTY, VT RTE 125 (MAJOR COLLECTOR), BRIDGE NO : 13

REV	NO.	DATE	DESCRIPTION	BY

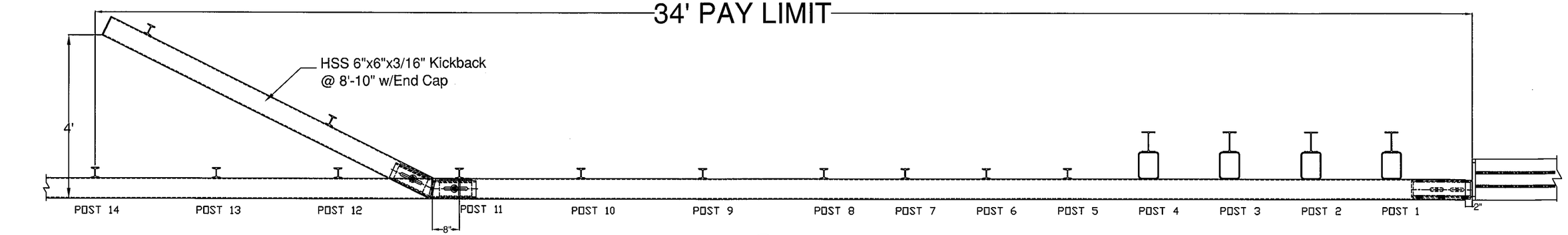
REV	NO.	DATE	DESCRIPTION	BY

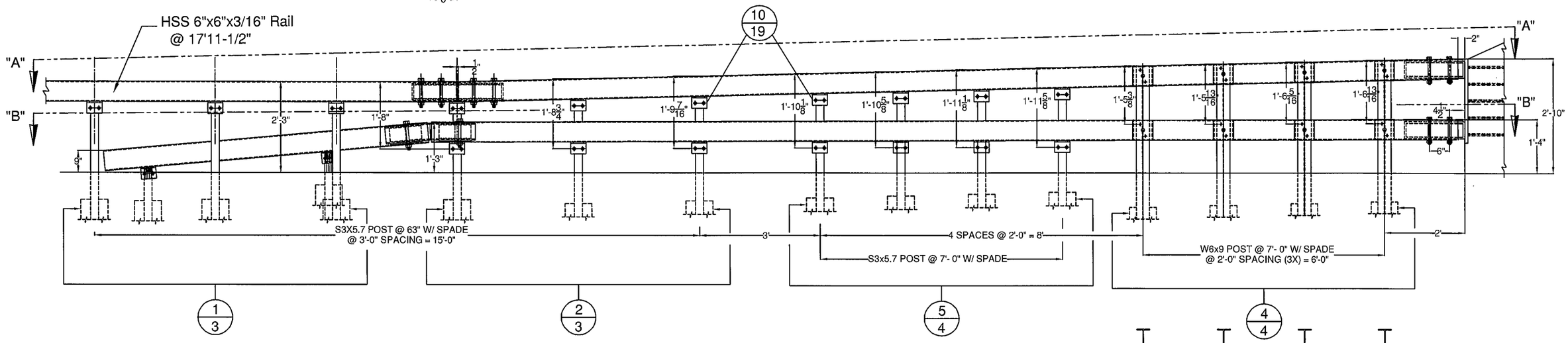
ELDERLEE, INC.
OAKS CORNERS, NEW YORK 14518
E-Mail: dlong@elderlee.com / epeek@elderlee.com
Tel:315-789-6670 Fax:315-789-6615

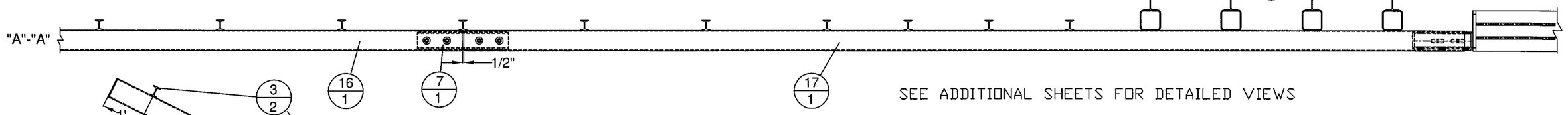
CERTIFIED FABRICATOR

DRAWN	E.P.	3/7/14
CHECKED	D.L.	3/10/14
APPROVED	.	.
SCALE	SCHEMATIC	
DRAWING NO.	FR L - MIDDLEBURY	

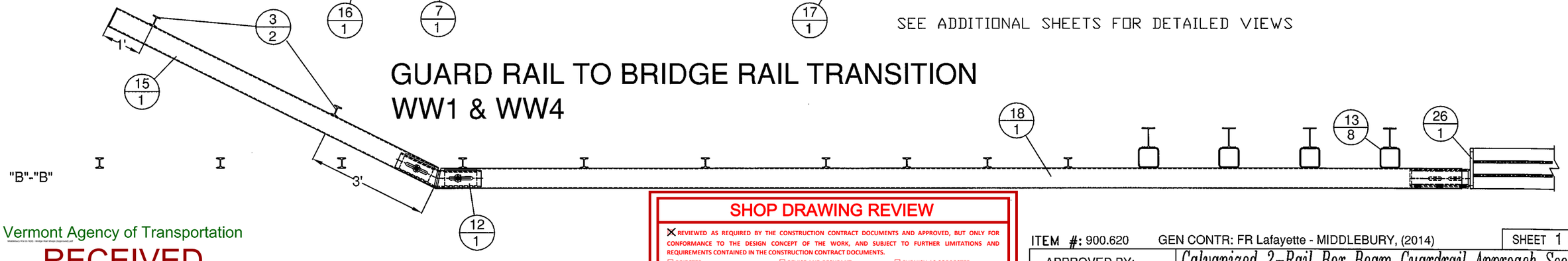
34' PAY LIMIT







SEE ADDITIONAL SHEETS FOR DETAILED VIEWS



GUARD RAIL TO BRIDGE RAIL TRANSITION
WW1 & WW4

Vermont Agency of Transportation

RECEIVED

ON: April 3, 2014

and Checked for

CONFORMANCE

BY: Jennifer Fitch DATE: 04/04/2014

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VHB

Job Number: 57438

Reviewed By: KZS

Date: 4/4/2014

ITEM #: 900.620 GEN CONTR: FR Lafayette - MIDDLEBURY, (2014)

SHEET 1 OF 8

APPROVED BY:

Galvanized 2-Rail Box Beam Guardrail Approach Section

EM13-252, MIDDLEBURY RS 0174 (8)

TOWN OF MIDDLEBURY, ADDISON COUNTY, VT RTE 125 (MAJOR COLLECTOR), BRIDGE NO : 13

R	NO.	DATE	DESCRIPTION	BY
E	1	3/20/14	REVISED PER 3/18/14 MARK-UP	E.P.
V	2	4/2/14	REVISED PER 3/25/14 MARK-UP	E.P.

R	NO.	DATE	DESCRIPTION	BY
E				
V				

ELDERLEE, INC.
OAKS CORNERS, NEW YORK 14518
E-Mail:dlong@elderlee.com / epeek@elderlee.com
Tel:315-789-6620 Fax:315-789-6615

CERTIFIED FABRICATOR

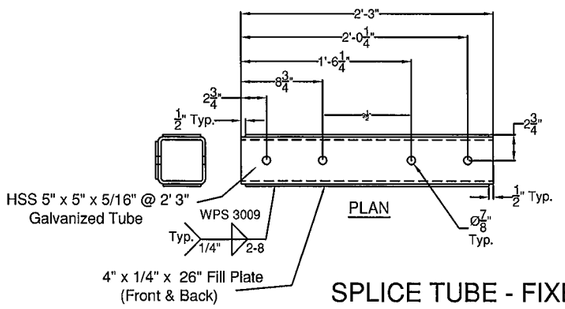
DRAWN	E.P.	3/7/14
CHECKED	D.L.	3/10/14
APPROVED	M.V.	.
SCALE	SCHEMATIC	
DRAWING NO.	FR L - MIDDLEBURY 2014	

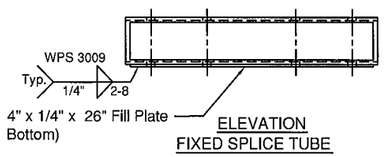
BILL OF MATERIALS, WW 1

ITEM #	QTY.	COMPONENT #	DESCRIPTION	MATERIAL (ASTM)
1	3	0013.57021	3' I-POST, PUNCH 8' W/SPD @ 63' LG	ASTM A572 Gr. 50
2	3	0013.57025	3' I-POST, PUNCH 8', & 20' W/SPD @ 63' LG	ASTM A572 Gr. 50
3	2	0013.57060	3' I-END POST W/SPD @ 3'-8' LG	ASTM A572 Gr. 50
4	4		W6X9 POST @ 7' W/SPD & 5/8' HOLES @ VARIOUS	ASTM A572 Gr. 50
5	4		3' I-POST, PUNCH 8' & VARIOUS', W/8X32' SPADE @7'	ASTM A572 Gr. 50
7	1	0033.00640	HSS 5X5 TUBE SPLICE @27' LG W/ 1/4' SHIMS	A500 Gr. B / A572 Gr 50
10	19	0054.00050	REG BB SHELF ANGLES @ 4-1/2'	ASTM A36
12	1		HSS 5X5 DBL BEND TUBE SPL @ 27' LG & 42°ANGLE	A500 Gr. B / A572 Gr 50
13	8	0054.00566	6X6' TRANS. TUBE B/O @ 6' LG	A500 Gr. B
15	1		6X6' BB @ 9'-0" KICKBACK, W/ CAP & 21° ANGLE	A500 Gr. B / A36
16	1		6X6' BB @ 17'-11 1/2', DRILL 3' CC, W/ 19'-6' RADIUS	A500 Gr. B
17	1		6X6' BB TOP TRANS @ 24'-9 3/4' LG W/EXP END, & 19'-6' RAD.	A500 Gr. B
18	1		6X6' BB BTM TRANS @ 25'-6 3/4' LG W/EXP END & 19'-6' RAD.	A500 Gr. B
19	18	0080.03355	3/8' X 7 1/2' BOLT, NUT, & 2 FW	A307, A563, F436
20	19	0080.04100	1/2' x 1-1/2' BOLT, NUT, & FW	A307, A563, F436
21	16	0080.04120	1/2' x 1-1/2' BOLT, NUT, 2 FW & LW	A307, A563, F436
23	14	0080.06340	3/4' X 7-1/2' BOLT, NUT, 2 FW	A325, A563, F436
24	8	0080.06370	3/4' X 8' CARR BOLT, NUT, FW & LW	A307, A563, F436
26	1		PARAPET WALL CONNECTIONS, LEFT-TRAILING	A572 Gr. 50, A615 Gr. 60, A709

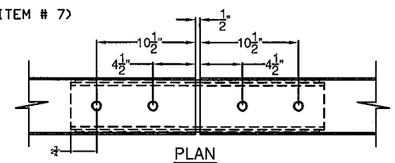
HARDWARE NOTES

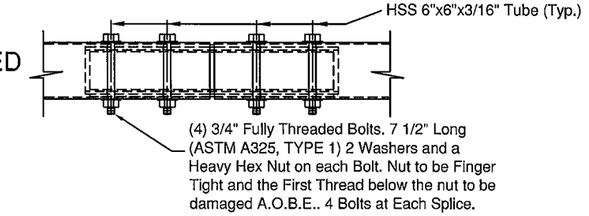
ITEM #	FUNCTION
19	BOLT RAIL TO SHELF ANGLE (ITEM #10)
20	BOLT SHELF ANGLE (ITEM # 10) TO POST
21	BOLT BLOCK-OUTS (ITEM # 13) TO HEAVY POST (ITEM # 4)
23	SPLICE TUBING (ITEM #'S 7 & 12), & (4) PER PARAPET WALL CONNECTION (ITEM # 26)
24	BOLT RAIL (ITEMS #'S 17, & 18 TO BLOCK-OUTS (ITEM # 13)

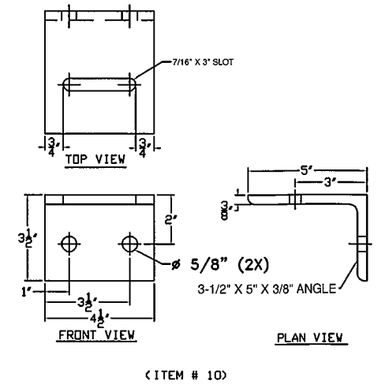




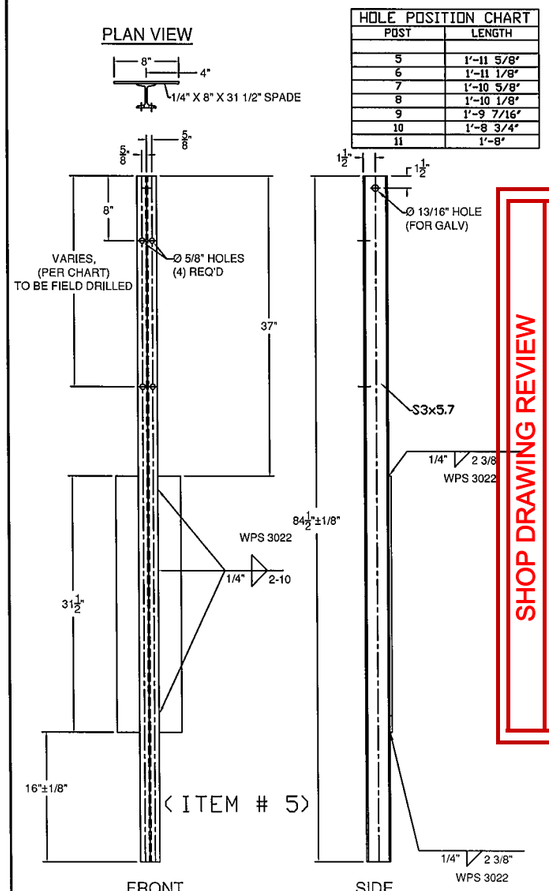
(ITEM # 7)



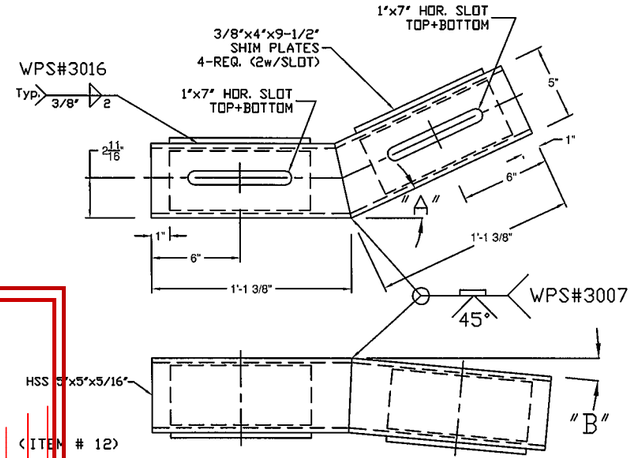




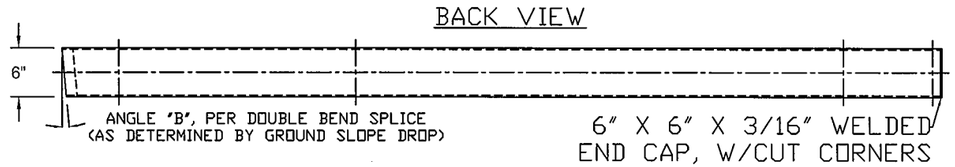
(ITEM # 10)

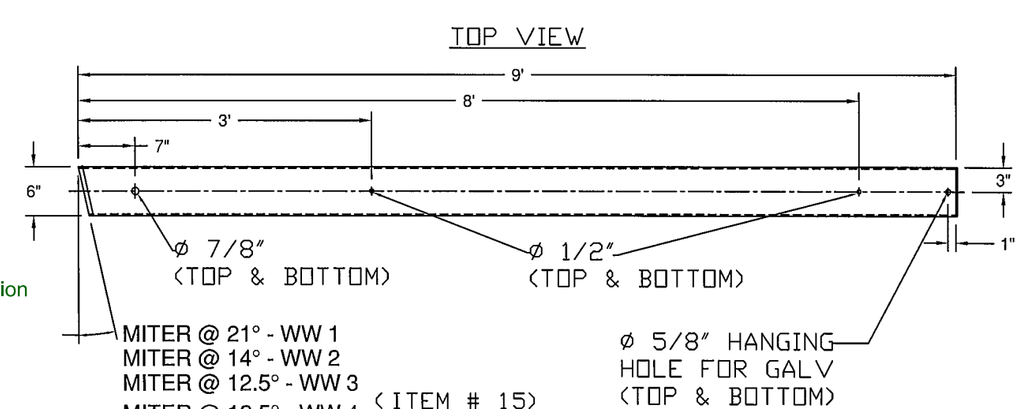


HOLE POSITION CHART	
POST	LENGTH
5	1'-11 5/8"
6	1'-11 1/8"
7	1'-10 5/8"
8	1'-10 1/8"
9	1'-9 7/16"
10	1'-8 3/4"
11	1'-8"



"A" - SEE PLAN FOR TURN BACK DISTANCE, SET ANGLE ACCORDINGLY.(WW1-42°, WW2-28°, WW3-25°, WW4-25°)
"B" - TURN DOWN ANGLE SET BY THE 9" MEASURMENT AT THE END OF THE BOX BEAM.





SHOP DRAWING REVIEW

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VHB

Job Number: 57438
Reviewed By: KZS
Date: 4/4/2014

Vermont Agency of Transportation

RECEIVED
ON: April 3, 2014
and Checked for
CONFORMANCE
BY: Jennifer Fitch DATE: 04/04/2014

GENERAL NOTES:

1) ALL RAILING IS TO BE FABRICATED AND ERECTED ACCORDING TO SECTION 525 OF THE STANDARD SPECIFICATIONS.
2) BOLTS SHALL BE TORQUED SNUG TIGHT (APPROXIMATELY 100 FT-LB).
3) PROTRUSIONS CAUSED BY WELDING OR GALVANIZING ARE NOT PERMITTED ON THE ADJOINING SURFACES OF THE BOX BEAM RAILS, SPLICE TUBES AND FILL PLATES.
4) BOX BEAM TUBE AND STEEL POST MATERIALS, DIMENSION SIZES AND NOTES SHALL BE THE SAME AS THOSE OF THE BRIDGE RAIL, UNLESS OTHERWISE NOTED.
5) ANY BENDING OF RAIL SHALL BE DONE AT THE FABRICATION PLANT. RADII GREATER THAN 16' TO BE CURVED ON A TUBE BENDING MACHINE, RADII LESS THAN 16' TO BE "PIE CUT" AND WELDED. CURVED RAILING WILL HAVE AN 18" LENGTH ON EACH END STRAIGHT TO ACCOMADATE SPLICES.

ITEM #: 900.620 GEN CONTR: FR Lafayette - MIDDLEBURY, (2014)

SHEET 2 OF 8

APPROVED BY:

Galvanized 2-Rail Box Beam Guardrail Approach Section

EM13-252, MIDDLEBURY RS 0174 (8)

TOWN OF MIDDLEBURY, ADDISON COUNTY, VT RTE 125 (MAJOR COLLECTOR), BRIDGE NO : 13

R	NO.	DATE	DESCRIPTION	BY
E	1	3/20/14	REVISED PER 3/18/14 MARK-UP	E.P.
V	2	4/2/14	REVISED PER 3/25/14 MARK-UP	E.P.

R	NO.	DATE	DESCRIPTION	BY
E				
V				

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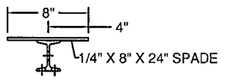
OAKS CORNERS, NEW YORK 14518
E-Mail: dlong@elderlee.com / epeek@elderlee.com
Tel: 315-789-6670 Fax: 315-789-6615

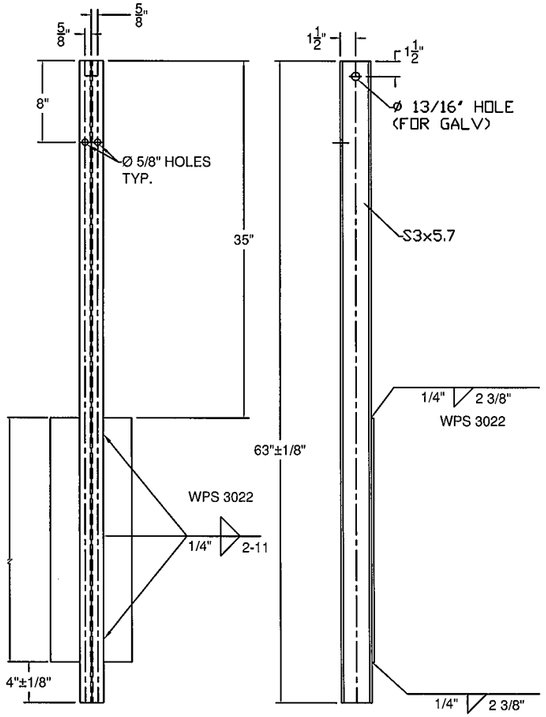
CERTIFIED FABRICATOR

DRAWN	E.P.	3/7/14
CHECKED	D.L.	3/10/14
APPROVED	M.V.	-
SCALE	SCHEMATIC	
DRAWING NO.	FR L - MIDDLEBURY 2014	

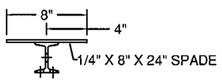
PLAN VIEW



(ITEM # 1)



PLAN VIEW



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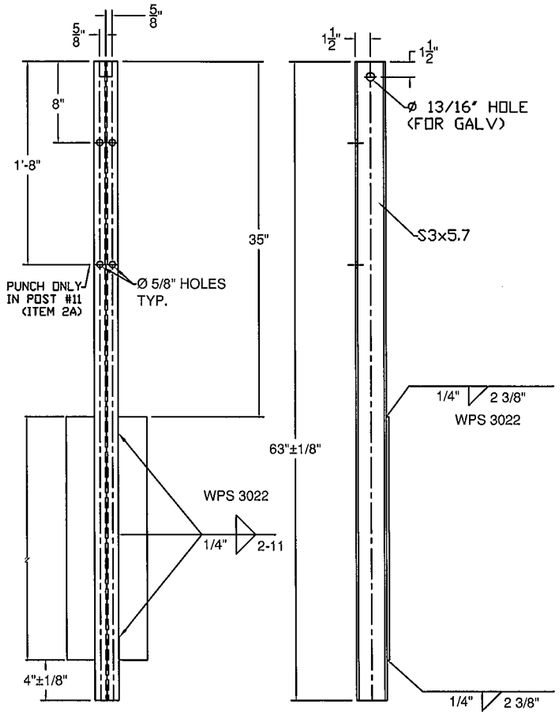
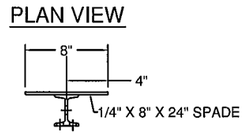


PLAN VIEW



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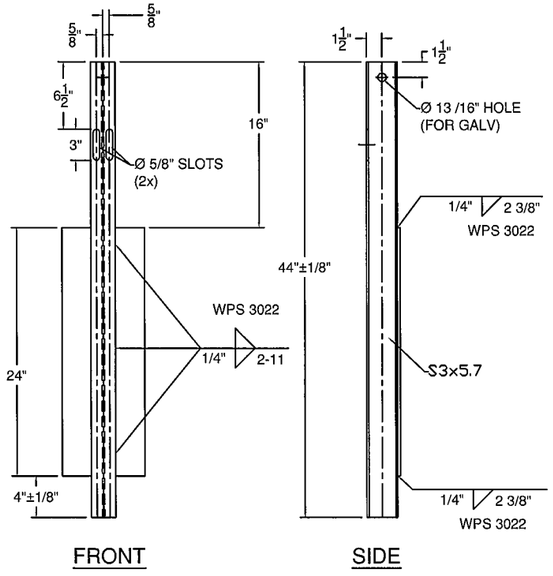
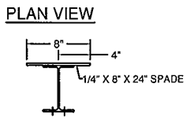
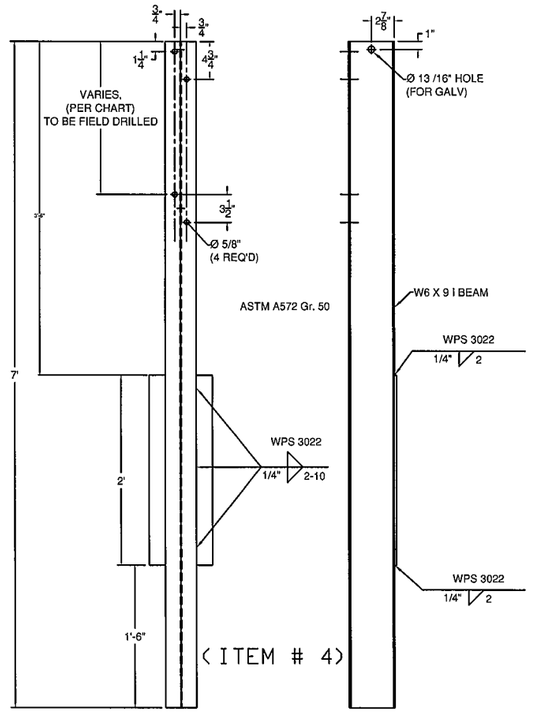


PLAN VIEW

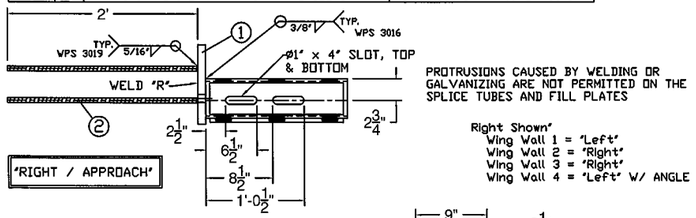


HOLE POSITION CHART	
POST	LENGTH
1	1'-6 13/16"
2	1'-6 5/16"
3	1'-5 13/16"
4	1'-5 3/8"



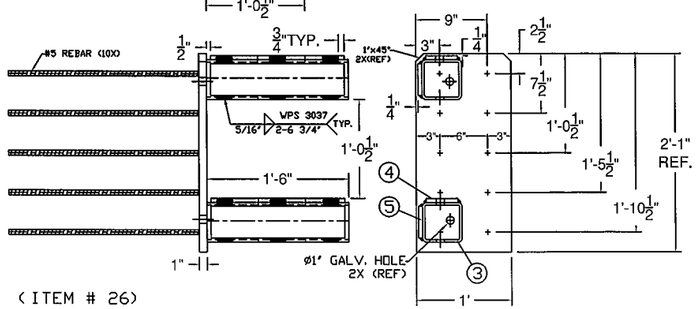
(ITEM # 4)

BILL OF MATERIALS			
ITEM #	QTY	DESCRIPTION	ASTM #
1	1	DBL TUBE WALL PLATE - 1" X 12" x 25"	ASTM A572 Gr. 50
2	10	RAW, Ø5/8" REBAR @ 24"	A615, Gr. 60
3	2	5" X 5" X 5/16" TUBE W/ SLOTS @ 18"	ASTM A500 Gr. B
4	2	SHIM PL 1/2" X 4" X 17" W/ SLOTS	ASTM A36(ASTM A709 Gr. 36)CVN
5	2	SHIM PL 1/2" X 4" X 17" (W/O SLOTS)	ASTM A36(ASTM A709 Gr. 36)CVN



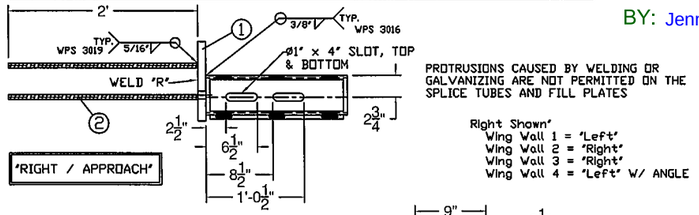
PROTRUSIONS CAUSED BY WELDING OR GALVANIZING ARE NOT PERMITTED ON THE SPLICE TUBES AND FILL PLATES

Right Shown'
Wing Wall 1 = 'Left'
Wing Wall 2 = 'Right'
Wing Wall 3 = 'Right'
Wing Wall 4 = 'Left' W/ ANGLE



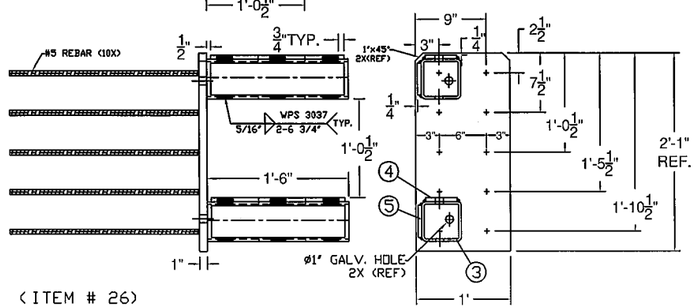
(ITEM # 26)

BILL OF MATERIALS			
ITEM #	QTY	DESCRIPTION	ASTM #
1	1	DBL TUBE WALL PLATE - 1" X 12" x 25"	ASTM A572 Gr. 50
2	10	RAW, Ø5/8" REBAR @ 24"	A615, Gr. 60
3	2	5" X 5" X 5/16" TUBE W/ SLOTS @ 18"	ASTM A500 Gr. B
4	2	SHIM PL 1/2" X 4" X 17" W/ SLOTS	ASTM A36(ASTM A709 Gr. 36)CVN
5	2	SHIM PL 1/2" X 4" X 17" (W/O SLOTS)	ASTM A36(ASTM A709 Gr. 36)CVN



PROTRUSIONS CAUSED BY WELDING OR GALVANIZING ARE NOT PERMITTED ON THE SPLICE TUBES AND FILL PLATES

Right Shown'
Wing Wall 1 = 'Left'
Wing Wall 2 = 'Right'
Wing Wall 3 = 'Right'
Wing Wall 4 = 'Left' W/ ANGLE



(ITEM # 26)

Vermont Agency of Transportation

RECEIVED
ON: April 3, 2014
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CONFORMANCE
BY: Jennifer Fitch DATE: 04/04/2014

SHOP DRAWING REVIEW

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VHB
Job Number: 57438
Reviewed By: KZS
Date: 4/4/2014

ITEM #: 900.620 GEN CONTR: FR Lafayette - MIDDLEBURY, (2014)

SHEET 3 OF 8

APPROVED BY:

Galvanized 2-Rail Box Beam Guardrail Approach Section

EM13-252, MIDDLEBURY RS 0174 (8)
TOWN OF MIDDLEBURY, ADDISON COUNTY, VT RTE 125 (MAJOR COLLECTOR), BRIDGE NO : 13

R	NO.	DATE	DESCRIPTION	BY	R	NO.	DATE	DESCRIPTION	BY
E	1	3/20/14	REVISED PER 3/18/14 MARK-UP	E.P.	E				
V	2	4/2/14	REVISED PER 3/25/14 MARK-UP	E.P.	V				

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OAKS CORNERS, NEW YORK 14518
E-Mail: dlong@elderlee.com / epeek@elderlee.com
Tel: 315-789-6670 Fax: 315-789-6615

CERTIFIED FABRICATOR

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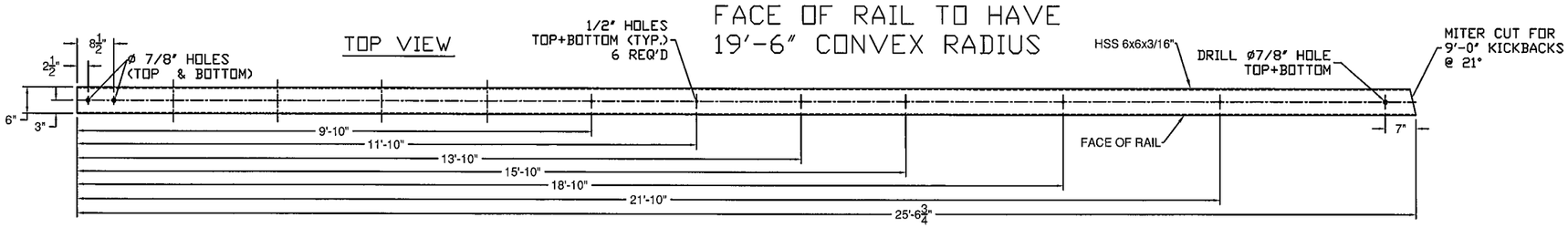
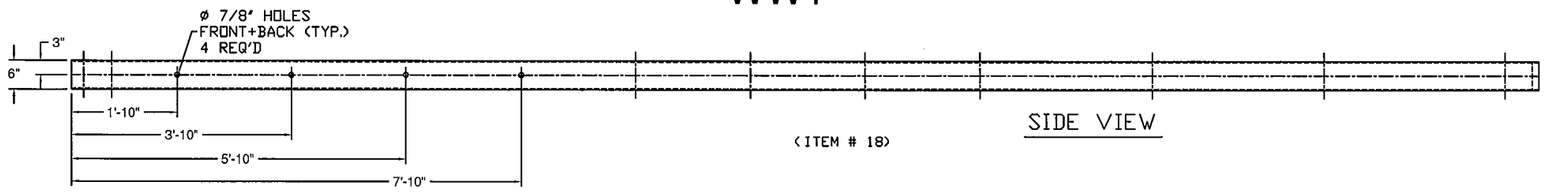
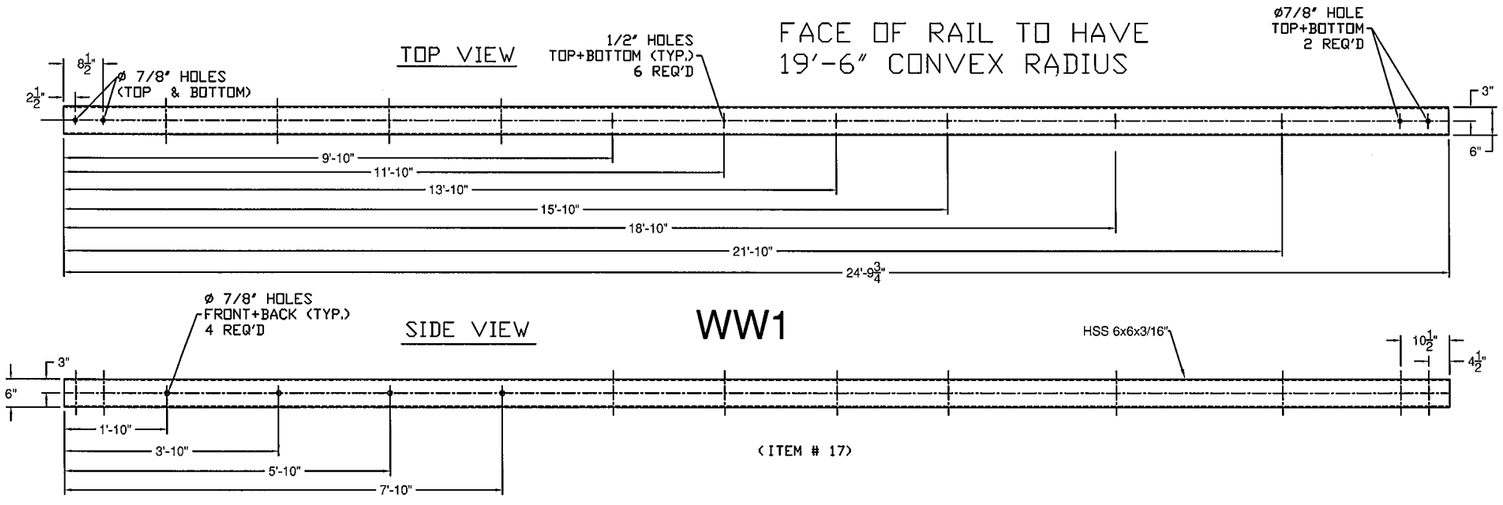
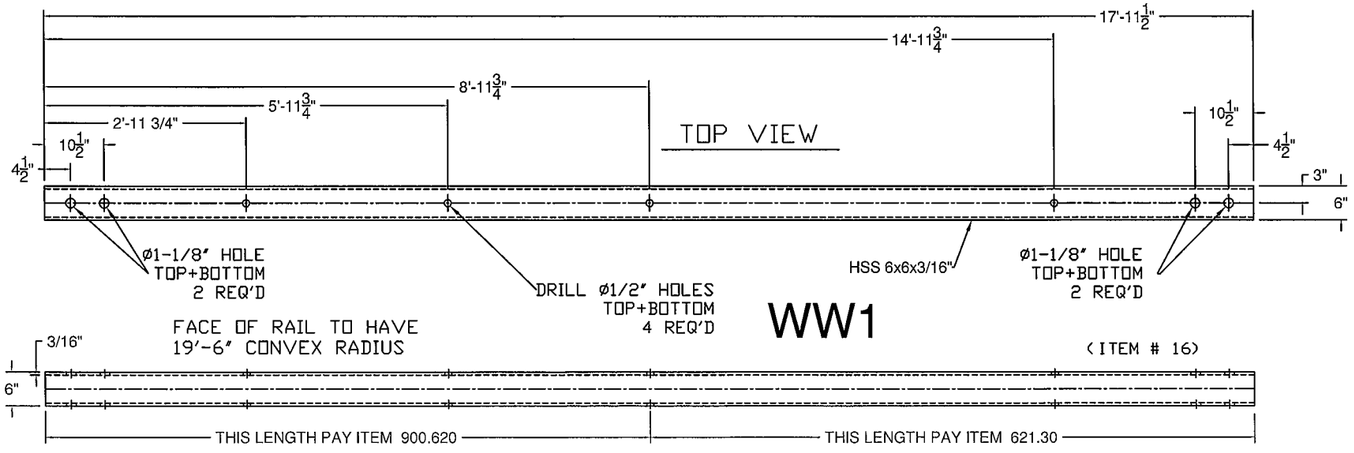
APPROVED	M.V.	-
SCALE	SCHEMATIC	
DRAWING NO.	FR L - MIDDLEBURY 2014	

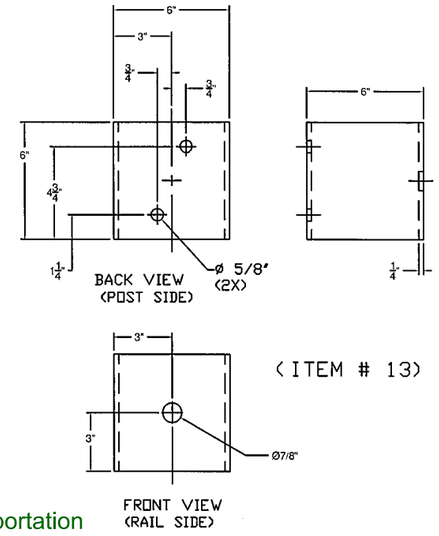


WW1









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Vermont Agency of Transportation

RECEIVED

ON: April 3, 2014

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CONFORMANCE

BY: Jennifer Fitch DATE: 04/04/2014

ITEM #: 900.620 GEN CONTR: FR Lafayette - MIDDLEBURY, (2014) SHEET 4 OF 8

APPROVED BY:

Galvanized 2-Rail Box Beam Guardrail Approach Section

EM13-252, MIDDLEBURY RS 0174 (8)

TOWN OF MIDDLEBURY, ADDISON COUNTY, VT RTE 125 (MAJOR COLLECTOR), BRIDGE NO : 13

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V	2	4/2/14	REVISED PER 3/25/14 MARK-UP	E.P.

R	NO.	DATE	DESCRIPTION	BY
E				
V				

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OAKS CORNERS, NEW YORK 14518
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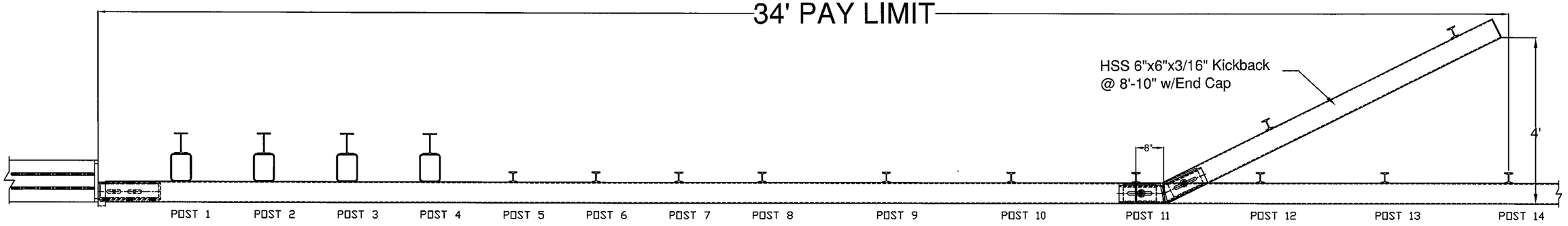
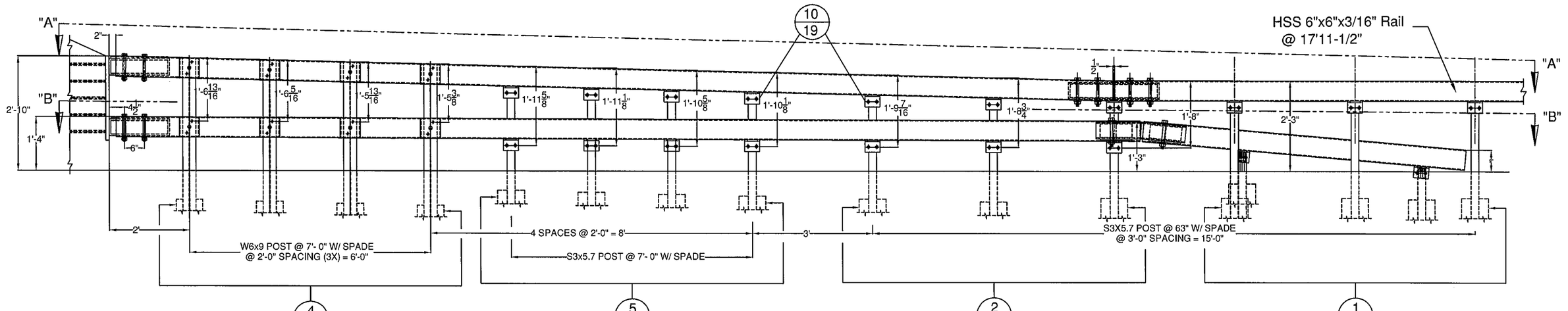
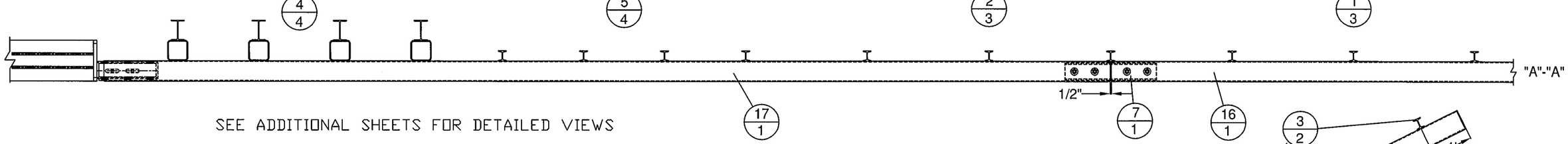
CHECKED	D.L.	3/10/14
APPROVED	M.V.	.
SCALE	SCHEMATIC	
DRAWING NO.	FR L - MIDDLEBURY 2014	

34' PAY LIMIT







SEE ADDITIONAL SHEETS FOR DETAILED VIEWS

GUARD RAIL TO BRIDGE RAIL TRANSITION
WW2 & WW3

Vermont Agency of Transportation

RECEIVED

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Date: 4/4/2014

ITEM #: 900.620 GEN CONTR: FR Lafayette - MIDDLEBURY, (2014)

SHEET 5 OF 8

APPROVED BY:

Galvanized 2-Rail Box Beam Guardrail Approach Section

EM13-252, MIDDLEBURY RS 0174 (8)

TOWN OF MIDDLEBURY, ADDISON COUNTY, VT RTE 125 (MAJOR COLLECTOR), BRIDGE NO : 13

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V	2	4/2/14	REVISED PER 3/25/14 MARK-UP	E.P.	V				

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CERTIFIED FABRICATOR

DRAWN	E.P.	3/7/14
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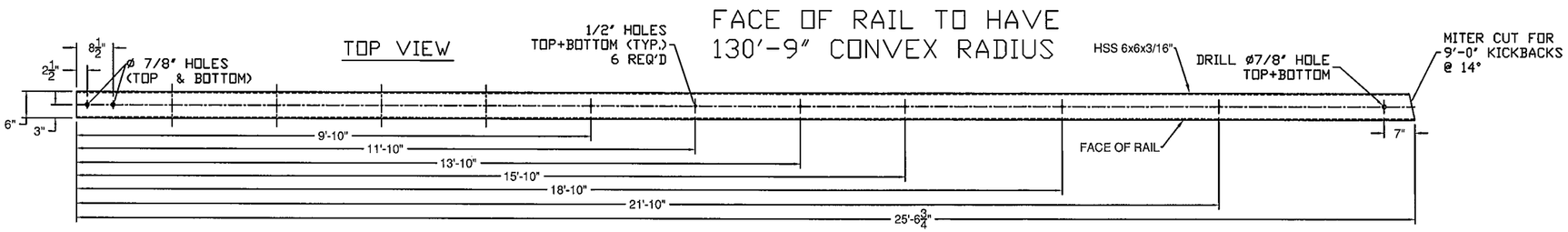
APPROVED	M.V.	.
SCALE	SCHEMATIC	
DRAWING NO.	FR L - MIDDLEBURY 2014	



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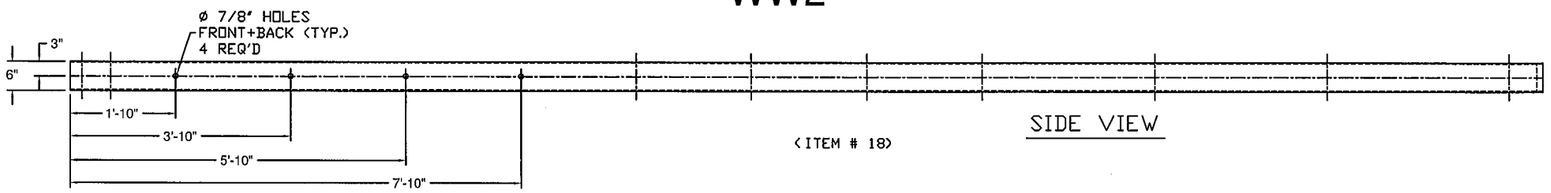

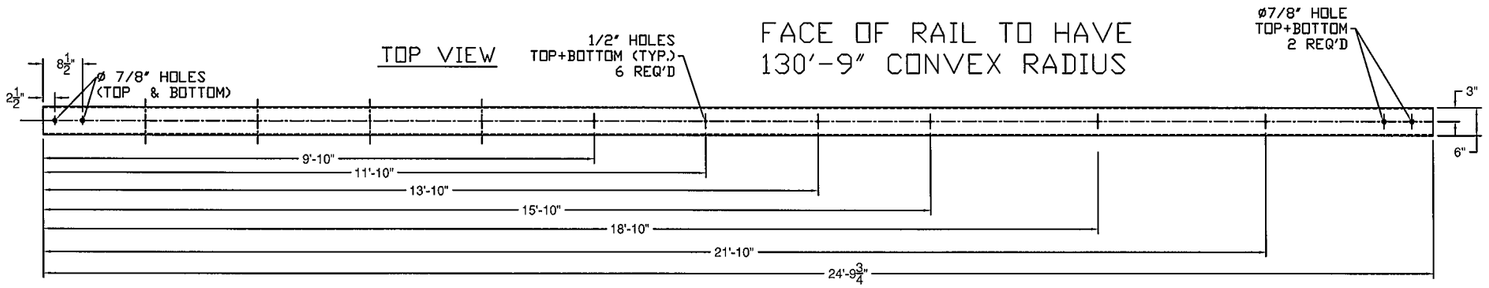

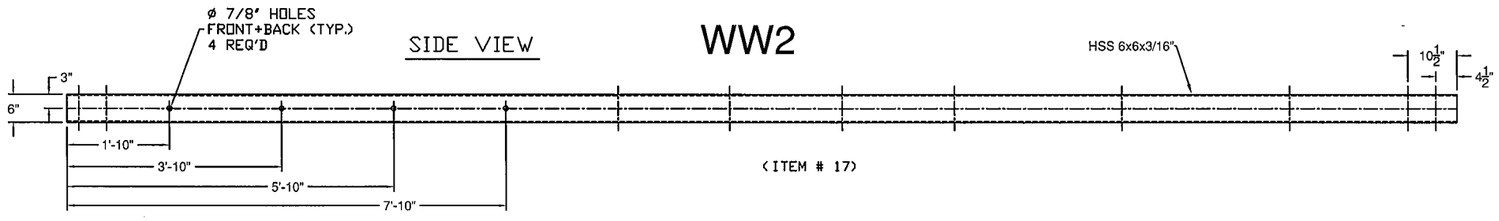

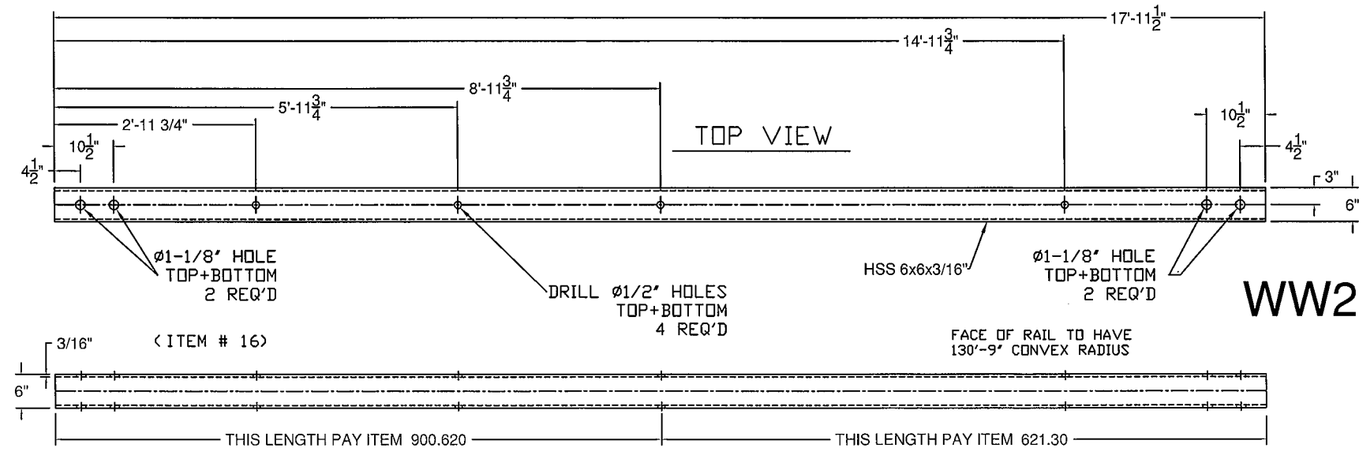

Vermont Agency of Transportation

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SHOP DRAWING REVIEW

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VHB

Job Number: 57438

Reviewed By: KZS

Date: 4/4/2014

BILL OF MATERIALS, WW 2

ITEM #	QTY.	COMPONENT #	DESCRIPTION	MATERIAL (ASTM)
1	3	0013.57021	3' I-POST, PUNCH 8' W/SPD @ 63' LG	ASTM A572 Gr. 50
2	3	0013.57025	3' I-POST, PUNCH 8', & 20' W/SPD @ 63' LG	ASTM A572 Gr. 50
3	2	0013.57060	3' I-END POST W/SPD @ 3'-8' LG	ASTM A572 Gr. 50
4	4	0013.09001	W6X9 POST @ 7' W/SPD & 5/8' HOLES	ASTM A572 Gr. 50
5	4	0013.57010	3' I-POST, PUNCH 8' & 20', W/8X32' SPADE @7'	ASTM A572 Gr. 50
7	1	0033.00640	HSS 5X5 TUBE SPLICE @27' LG W/ 1/4' SHIMS	A500 Gr. B / A572 Gr 50
10	19	0054.00050	REG BB SHELF ANGLES @ 4-1/2'	ASTM A36
12	1		HSS 5X5 DBL BEND TUBE SPL @ 27' LG & 28°ANGLE	A500 Gr. B / A572 Gr 50
13	8	0054.00566	6X6' TRANS. TUBE B/O @ 6' LG	A500 Gr. B
15	1		6X6' BB @ 9'-0" KICKBACK, W/ CAP & 14° ANGLE	A500 Gr. B / A36
16	1		6X6' BB @ 17'-11 1/2', DRILL 3' CC, W/ 130'-9' RADIUS	A500 Gr. B
17	1		6X6' BB TOP TRANS @ 24'-9 3/4' LG W/EXP END, & 130'-9' RAD.	A500 Gr. B
18	1		6X6' BB BTM TRANS @ 25'-6 3/4' LG W/EXP END & 130'-9' RAD.	A500 Gr. B
19	18	0080.03355	3/8' X 7 1/2' BOLT, NUT, & 2 FW	A307, A563, F436
20	19	0080.04100	1/2' x 1-1/2' BOLT, NUT, & FW	A307, A563, F436
21	16	0080.04120	1/2' x 1-1/2' BOLT, NUT, 2 FW & LW	A307, A563, F436
23	14	0080.06340	3/4' X 7-1/2' BOLT, NUT, 2 FW	A325, A563, F436
24	8	0080.06370	3/4' X 8' CARR BOLT, NUT, FW & LW	A307, A563, F436
26	1		PARAPET WALL CONNECTIONS	A572 Gr. 50, A615 Gr. 60, A709

HARDWARE NOTES

ITEM #	FUNCTION
19	BOLT RAIL TO SHELF ANGLE (ITEM #10)
20	BOLT SHELF ANGLE (ITEM # 10) TO POST
21	BOLT BLOCK-OUTS (ITEM # 13) TO HEAVY POST (ITEM # 4)
23	SPLICE TUBING (ITEM #'S 7 & 12), & (4) PER PARAPET WALL CONNECTION (ITEM # 26)
24	BOLT RAIL (ITEMS #'S 17, & 18 TO BLOCK-OUTS (ITEM # 13)

ITEM #: 900.620 GEN CONTR: FR Lafayette - MIDDLEBURY, (2014) SHEET 6 OF 8

APPROVED BY:

Galvanized 2-Rail Box Beam Guardrail Approach Section

EM13-252, MIDDLEBURY RS 0174 (8)

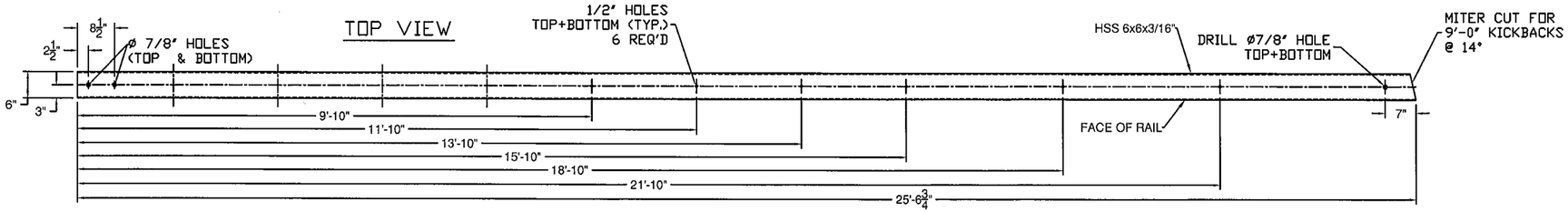
TOWN OF MIDDLEBURY, ADDISON COUNTY, VT RTE 125 (MAJOR COLLECTOR), BRIDGE NO : 13

R	NO.	DATE	DESCRIPTION	BY	R	NO.	DATE	DESCRIPTION	BY
E	1	3/20/14	REVISED PER 3/18/14 MARK-UP	E.P.	E				
V	2	4/2/14	REVISED PER 3/25/14 MARK-UP	E.P.	V				

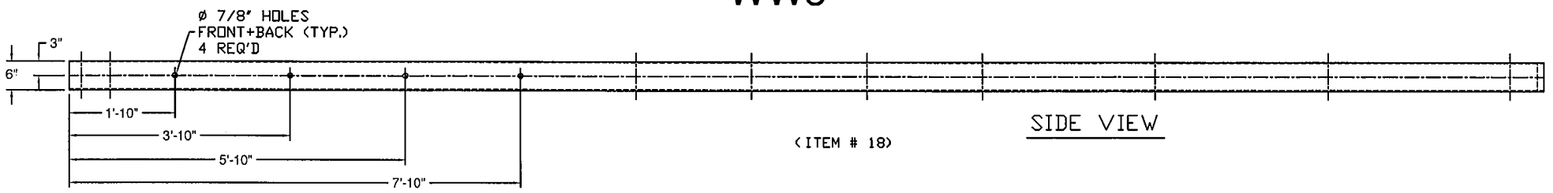
ELDERLEE, INC.
OAKS CORNERS, NEW YORK 14518
E-Mail: dlong@elderlee.com / epeek@elderlee.com
Tel: 315-789-6620 Fax: 315-789-6615

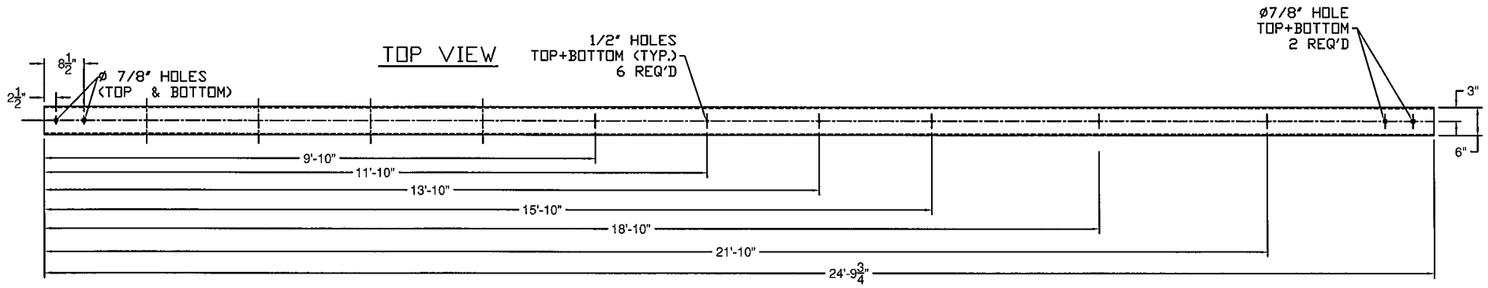
CERTIFIED FABRICATOR

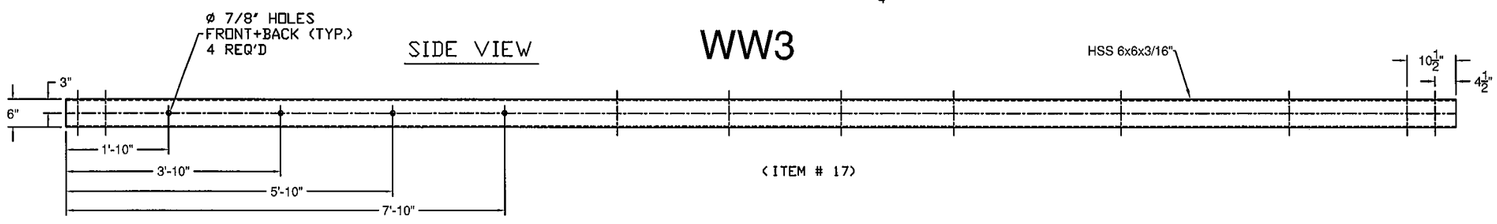
DRAWN	E.P.	3/7/14
CHECKED	D.L.	3/10/14
APPROVED	M.V.	-
SCALE	SCHEMATIC	
DRAWING NO.	FR L - MIDDLEBURY 2014	

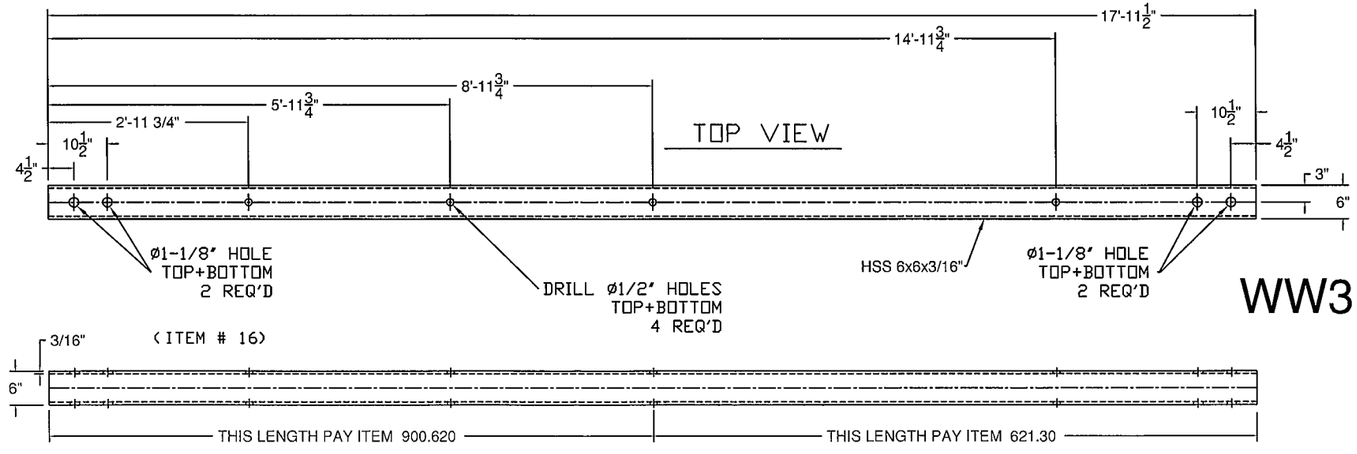


WW3









Vermont Agency of Transportation

RECEIVED

ON: April 3, 2014

and Checked for

CONFORMANCE

BY: Jennifer Fitch DATE: 04/04/2014

SHOP DRAWING REVIEW

X REVIEWED AS REQUIRED BY THE CONSTRUCTION CONTRACT DOCUMENTS AND APPROVED, BUT ONLY FOR CONFORMANCE TO THE DESIGN CONCEPT OF THE WORK, AND SUBJECT TO FURTHER LIMITATIONS AND REQUIREMENTS CONTAINED IN THE CONSTRUCTION CONTRACT DOCUMENTS.

☐ REJECTED ☐ REVISE AND RESUBMIT ☐ FURNISH AS CORRECTED

CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DO NOT RELIEVE CONTRACTOR FROM COMPLIANCE WITH REQUIREMENTS OF THE DRAWINGS AND SPECIFICATIONS. THIS CHECK IS ONLY FOR REVIEW OF GENERAL CONFORMANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND GENERAL COMPLIANCE WITH THE INFORMATION GIVEN IN THE CONTRACT DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR: CONFIRMING AND CORRELATING ALL QUANTITIES AND DIMENSIONS; SELECTING FABRICATION PROCESSES AND TECHNIQUES OF CONSTRUCTION; COORDINATING HIS WORK WITH THAT OF ALL OTHER TRADES; AND PERFORMING HIS WORK IN A SAFE AND SATISFACTORY MANNER.

VHB

Job Number: 57438

Reviewed By: KZS

Date: 4/4/2014

BILL OF MATERIALS, WW 3

ITEM #	QTY.	COMPONENT #	DESCRIPTION	MATERIAL (ASTM)
1	3	0013.57021	3' I-POST, PUNCH 8' W/SPD @ 63' LG	ASTM A572 Gr. 50
2	3	0013.57025	3' I-POST, PUNCH 8', & 20' W/SPD @ 63' LG	ASTM A572 Gr. 50
3	2	0013.57060	3' I-END POST W/SPD @ 3'-8" LG	ASTM A572 Gr. 50
4	4	0013.09001	W6X9 POST @ 7' W/SPD & 5/8" HOLES	ASTM A572 Gr. 50
5	4	0013.57010	3' I-POST, PUNCH 8' & 20', W/8X32" SPADE @7'	ASTM A572 Gr. 50
7	1	0033.00640	HSS 5X5 TUBE SPLICE @27' LG W/ 1/4" SHIMS	A500 Gr. B / A572 Gr 50
10	19	0054.00050	REG BB SHELF ANGLES @ 4-1/2'	ASTM A36
12	1		HSS 5X5 DBL BEND TUBE SPL @ 27' LG & 25°ANGLE	A500 Gr. B / A572 Gr 50
13	8	0054.00566	6X6' TRANS. TUBE B/O @ 6' LG	A500 Gr. B
15	1		6X6' BB @ 9'-0" KICKBACK, W/ CAP & 12 1/2" ANGLE	A500 Gr. B / A36
16	1		6X6' BB @ 17'-11 1/2", DRILL 3' CC	A500 Gr. B
17	1		6X6' BB TOP TRANS @ 24'-9 3/4" LG W/EXP END	A500 Gr. B
18	1		6X6' BB BTM TRANS @ 25'-6 3/4" LG W/EXP END	A500 Gr. B
19	18	0080.03355	3/8" X 7 1/2" BOLT, NUT, & 2 FW	A307, A563, F436
20	19	0080.04100	1/2" x 1-1/2" BOLT, NUT, & FW	A307, A563, F436
21	16	0080.04120	1/2" x 1-1/2" BOLT, NUT, 2 FW & LW	A307, A563, F436
23	14	0080.06340	3/4" X 7-1/2" BOLT, NUT, 2 FW	A325, A563, F436
24	8	0080.06370	3/4" X 8" CARR BOLT, NUT, FW & LW	A307, A563, F436
26	1		PARAPET WALL CONNECTIONS	A572 Gr. 50, A615 Gr. 60, A709

HARDWARE NOTES

ITEM #	FUNCTION
19	BOLT RAIL TO SHELF ANGLE (ITEM #10)
20	BOLT SHELF ANGLE (ITEM # 10) TO POST
21	BOLT BLOCK-OUTS (ITEM # 13) TO HEAVY POST (ITEM # 4)
23	SPLICE TUBING (ITEM #'S 7 & 12), & (4) PER PARAPET WALL CONNECTION (ITEM # 26)
24	BOLT RAIL (ITEMS #'S 17, & 18 TO BLOCK-OUTS (ITEM # 13)

ITEM #: 900.620 GEN CONTR: FR Lafayette - MIDDLEBURY, (2014)

SHEET 7 OF 8

APPROVED BY:

Galvanized 2-Rail Box Beam Guardrail Approach Section

EM13-252, MIDDLEBURY RS 0174 (8)

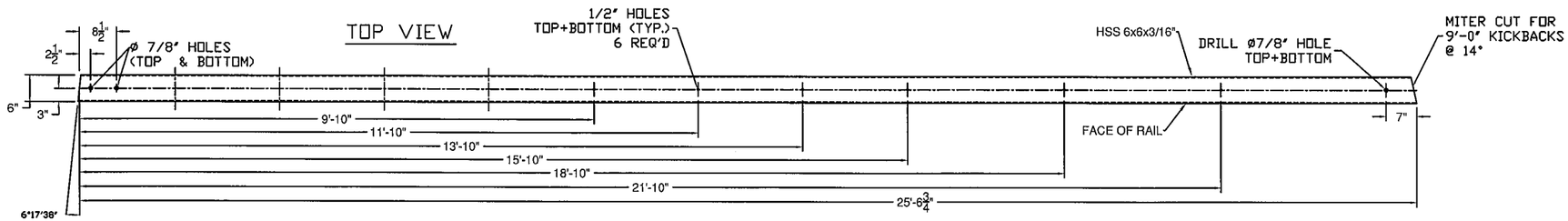
TOWN OF MIDDLEBURY, ADDISON COUNTY, VT RTE 125 (MAJOR COLLECTOR), BRIDGE NO : 13

R	NO.	DATE	DESCRIPTION	BY	R	NO.	DATE	DESCRIPTION	BY
E	1	3/20/14	REVISED PER 3/18/14 MARK-UP	E.P.	E				
V	2	4/2/14	REVISED PER 3/25/14 MARK-UP	E.P.	V				

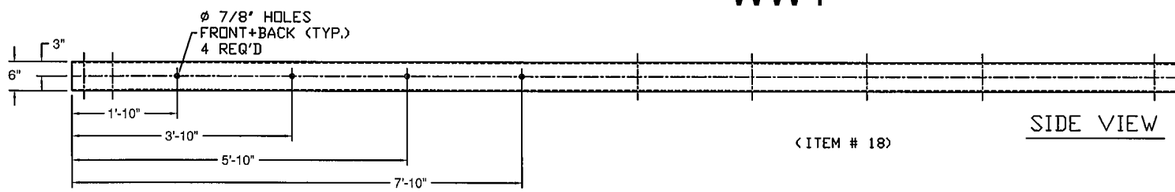
ELDERLEE, INC.
OAKS CORNERS, NEW YORK 14518
E-Mail: dlong@elderlee.com / epeek@elderlee.com
Tel: 315-789-6670 Fax: 315-789-6615

AISC CERTIFIED FABRICATOR

DRAWN	E.P.	3/7/14
CHECKED	D.L.	3/10/14
APPROVED	M.V.	-
SCALE	SCHEMATIC	
DRAWING NO.	FR L - MIDDLEBURY 2014	

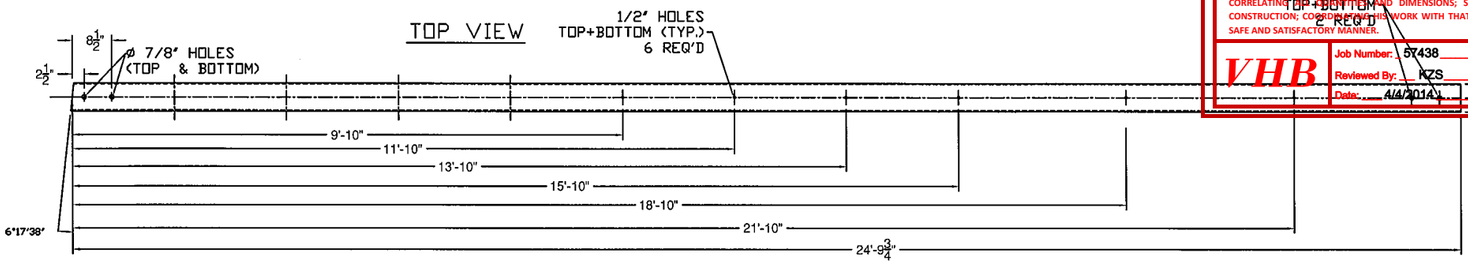


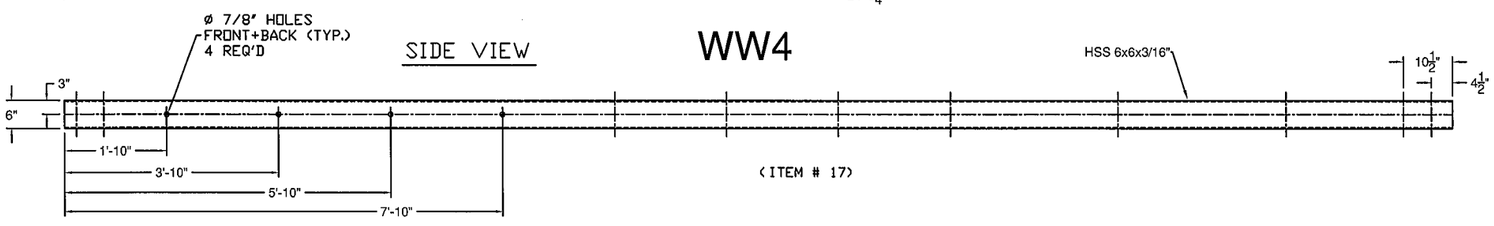
WW4



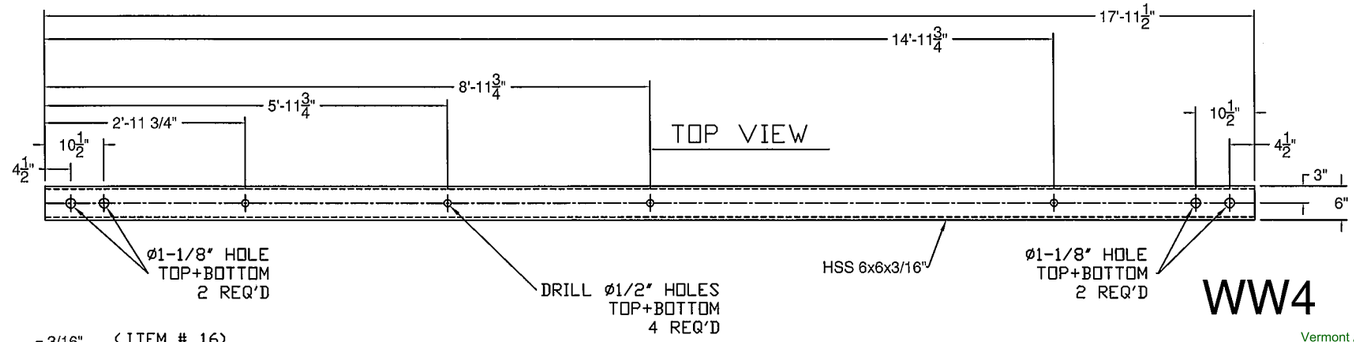
(ITEM # 18)

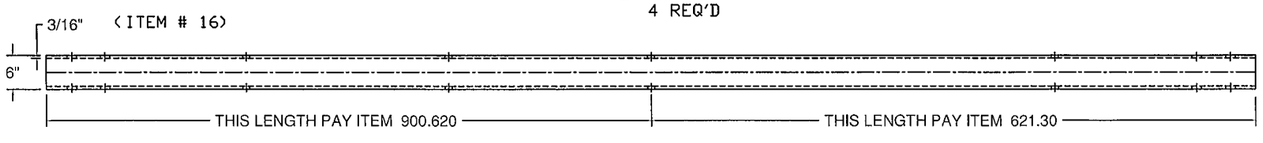
SIDE VIEW





(ITEM # 17)



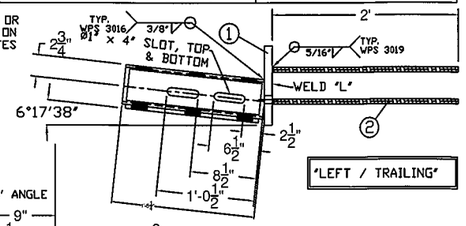


BILL OF MATERIALS

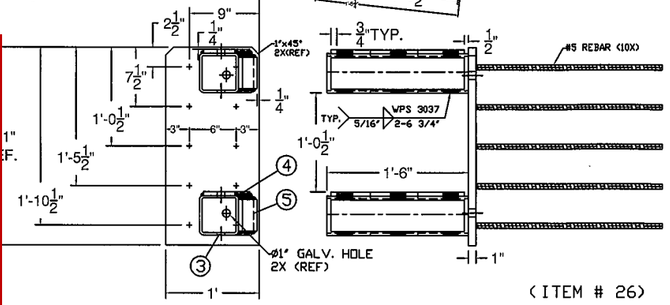
ITEM #	QTY	DESCRIPTION	ASTM #
1	1	DBL TUBE WALL PLATE - 1' X 12" x 25"	ASTM A572 Gr. 50
2	10	RAW, ø5/8" REBAR @ 24"	A615, Gr. 60
3	2	5" X 5" X 5/16" TUBE W/ SLOTS @ 18"	ASTM A500 Gr. B
4	2	SHIM PL 1/2" X 4" X 17" W/ SLOTS	ASTM A36(ASTM A709 Gr. 36)CVN
5	2	SHIM PL 1/2" X 4" X 17" (W/O SLOTS)	ASTM A36(ASTM A709 Gr. 36)CVN

PROTRUSIONS CAUSED BY WELDING OR GALVANIZING ARE NOT PERMITTED ON THE SPLICE TUBES AND FILL PLATES

WW4



Right Shown"
Wing Wall 1 = 'Left'
Wing Wall 2 = 'Right'
Wing Wall 3 = 'Right'
Wing Wall 4 = 'Left' W/ 6" 8' ANGLE



(ITEM # 26)

BILL OF MATERIALS, WW 4

ITEM #	QTY.	COMPONENT #	DESCRIPTION	MATERIAL (ASTM)
1	3	0013.57021	3" I-POST, PUNCH 8' W/SPD @ 63" LG	ASTM A572 Gr. 50
2	3	0013.57025	3" I-POST, PUNCH 8', & 20' W/SPD @ 63" LG	ASTM A572 Gr. 50
3	2	0013.57060	3" I-END POST W/SPD @ 3'-8" LG	ASTM A572 Gr. 50
4	4	0013.09001	W6X9 POST @ 7' W/SPD & 5/8" HOLES	ASTM A572 Gr. 50
5	4	0013.57010	3" I-POST, PUNCH 8' & 20', W/8X32" SPADE @7'	ASTM A572 Gr. 50
7	1	0033.00640	HSS 5X5 TUBE SPLICE @27" LG W/ 1/4" SHIMS	A500 Gr. B / A572 Gr 50
10	19	0054.00050	REG BB SHELF ANGLES @ 4-1/2"	ASTM A36
12	1		HSS 5X5 DBL BEND TUBE SPL @ 27" LG & 25°ANGLE	A500 Gr. B / A572 Gr 50
13	8	0054.00566	6X6" TRANS. TUBE B/O @ 6" LG	A500 Gr. B
15	1		6X6" BB @ 9'-0" KICKBACK, W/ CAP & 12 1/2° ANGLE	A500 Gr. B / A36
16	1		6X6" BB @ 17'-11 1/2", DRILL 3" CC	A500 Gr. B
17	1		6X6" BB TOP TRANS @ 24'-9 3/4" LG W/EXP END & 6° 8' ANGLE	A500 Gr. B
18	1		6X6" BB BTM TRANS @ 25'-6 3/4" LG W/EXP END & 6° 8' ANGLE	A500 Gr. B
19	18	0080.03355	3/8" X 7 1/2" BOLT, NUT, & 2 FW	A307, A563, F436
20	19	0080.04100	1/2" x 1-1/2" BOLT, NUT, & FW	A307, A563, F436
21	16	0080.04120	1/2" x 1-1/2" BOLT, NUT, 2 FW & LW	A307, A563, F436
23	14	0080.06340	3/4" X 7-1/2" BOLT, NUT, 2 FW	A325, A563, F436
24	8	0080.06370	3/4" X 8" CARR BOLT, NUT, FW & LW	A307, A563, F436
26	1		PARAPET WALL CONNECTIONS W/ 6" 18' ANGLE	A572 Gr. 50, A615 Gr. 60, A709

HARDWARE NOTES

ITEM #	FUNCTION
19	BOLT RAIL TO SHELF ANGLE (ITEM #10)
20	BOLT SHELF ANGLE (ITEM # 10) TO POST
21	BOLT BLOCK-OUTS (ITEM # 13) TO HEAVY POST (ITEM # 4)
23	SPLICE TUBING (ITEM #'S 7 & 12), & (4) PER PARAPET WALL CONNECTION (ITEM # 26)
24	BOLT RAIL (ITEMS #'S 17, & 18 TO BLOCK-OUTS (ITEM # 13)

SHOP DRAWING REVIEW

X REVIEWED AS REQUIRED BY THE CONSTRUCTION CONTRACT DOCUMENTS AND APPROVED, BUT ONLY FOR CONFORMANCE TO THE DESIGN CONCEPT OF THE WORK, AND SUBJECT TO FURTHER LIMITATIONS AND REQUIREMENTS CONTAINED IN THE CONSTRUCTION CONTRACT DOCUMENTS.

☐ REJECTED ☐ REVISE AND RESUBMIT ☐ FURNISH AS CORRECTED

CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DO NOT RELIEVE CONTRACTOR FROM COMPLIANCE WITH REQUIREMENTS OF THE DRAWINGS AND SPECIFICATIONS. THIS CHECK IS ONLY FOR REVIEW OF GENERAL CONFORMANCE WITH THE DESIGN CONCEPT OF THE PROJECT AND GENERAL COMPLIANCE WITH THE INFORMATION GIVEN IN THE CONTRACT DOCUMENTS. THE CONTRACTOR IS RESPONSIBLE FOR: CONFIRMING AND CORRELATING ALL QUANTITIES AND DIMENSIONS; SELECTING FABRICATION PROCESSES AND TECHNIQUES OF CONSTRUCTION; COORDINATING THIS WORK WITH THAT OF ALL OTHER TRADES; AND PERFORMING HIS WORK IN A SAFE AND SATISFACTORY MANNER.

VHB

Job Number: 57438
Reviewed By: KZS
Date: 4/4/2014

Vermont Agency of Transportation
RECEIVED
ON: April 3, 2014
and Checked for
CONFORMANCE
BY: Jennifer Fitch DATE: 04/04/2014

ITEM #: 900.620 GEN CONTR: FR Lafayette - MIDDLEBURY, (2014) SHEET 8 OF 8

APPROVED BY:

Galvanized 2-Rail Box Beam Guardrail Approach Section

EM13-252, MIDDLEBURY RS 0174 (8)
TOWN OF MIDDLEBURY, ADDISON COUNTY, VT RTE 125 (MAJOR COLLECTOR), BRIDGE NO : 13

R	NO.	DATE	DESCRIPTION	BY	R	NO.	DATE	DESCRIPTION	BY
E	1	3/20/14	REVISED PER 3/18/14 MARK-UP	E.P.	E				
V	2	4/2/14	REVISED PER 3/25/14 MARK-UP	E.P.	V				

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Tel: 315-789-6670 Fax: 315-789-6615

CERTIFIED FABRICATOR

DRAWN	E.P.	3/7/14
CHECKED	D.L.	3/10/14
APPROVED	M.V.	.
SCALE	SCHEMATIC	
DRAWING NO.	FR L - MIDDLEBURY 2014	

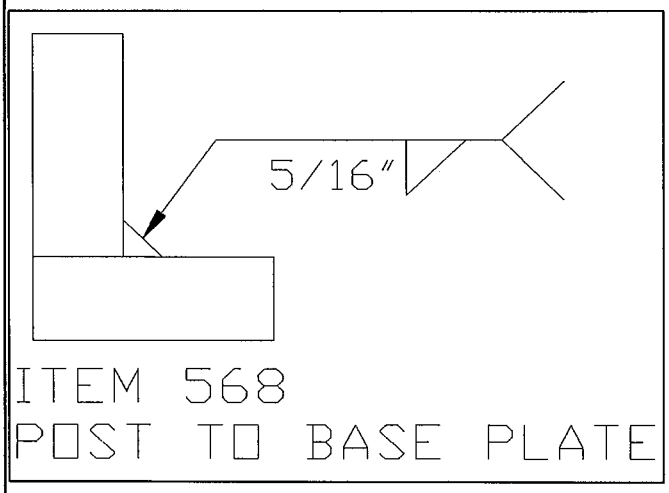
WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE #3

Material Specification	A572 TO A572		
Welding Process	FCAW-G		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	FLAT/HORIZONTAL		
Filler Metal Specification	A5.29		
Filler Metal Classification	E81T1-Ni1C-JH4		
Flux	N/A		
Shielding Gas	CO 2	Dew Point -40DEG F Flow Rate	50CFH
Single or Multiple Pass	SINGLE		
Single or Multiple Arc	SINGLE		
Welding Current	DC ELECTRODE POSITIVE		
Polarity	REVERSE		
Welding Progression	STRINGER		
Root Treatment	PER D1.5		
Preheat and Interpass Temperature	PER D1.5		
Postheat Temperature	NONE		
Heat Input	Min	Max	

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
Variable	LIMITS	341 TO 269	27 TO 23	12 TO 10	



This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 3002

Revision No.

Contractor Elderlee, Inc.

Authorized By RANDY SCOTT

Date 3/20/2014

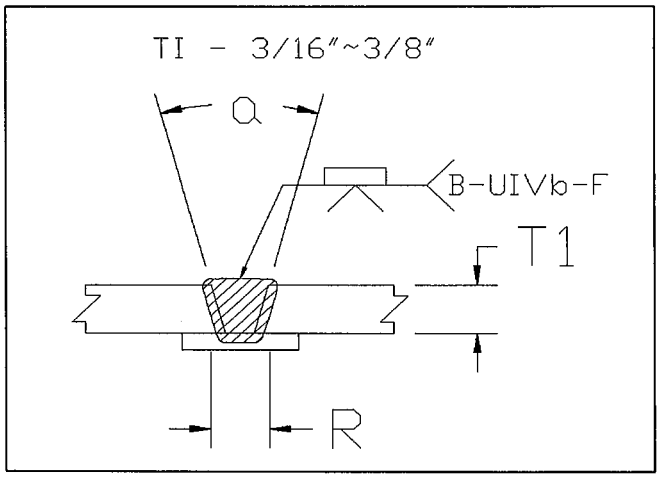
WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE#3

Material Specification	A500 GR B		
Welding Process	FCAW-G		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	FLAT/HORIZONTAL		
Filler Metal Specification	A5.29		
Filler Metal Classification	E81T1-Ni1C-JH4		
Flux	N/A		
Shielding Gas	CO 2	Dew Point -40DEG F	Flow Rate 50CFH
Single or Multiple Pass	SINGLE		
Single or Multiple Arc	SINGLE		
Welding Current	DC		
Polarity	REVERSE ELECTRODE POSITIVE		
Welding Progression	STRINGER		
Root Treatment	PER D1.5		
Preheat and Interpass Temperature	PER D1.5		
Postheat Temperature	NONE		
Heat Input	Min	Max	

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
Variable	LIMITS	341 TO 269	27 TO 23	12 TO 10	



This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 3007

Revision No.

Contractor Elderlee, Inc.

Authorized By RANDY SCOTT

Date 3/20/2014

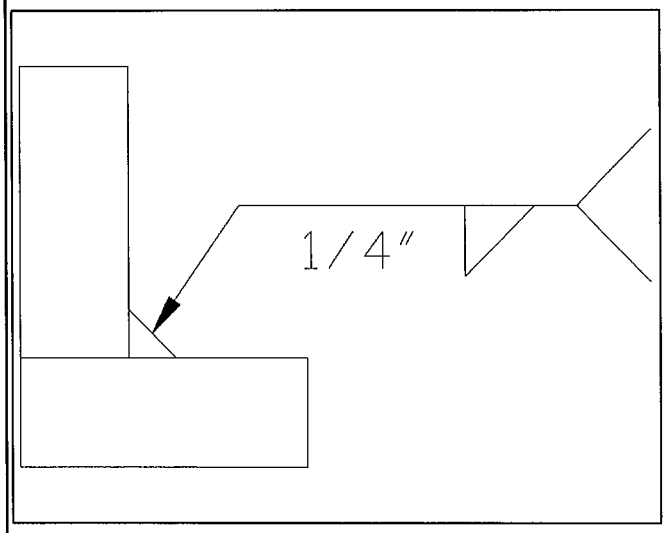
WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE #3

Material Specification	A709 TO A500 GR B		
Welding Process	FCAW-G		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	FLAT/HORIZONTAL		
Filler Metal Specification	A5.29		
Filler Metal Classification	E81T1-Ni1C-JH4		
Flux	N/A		
Shielding Gas	CO 2	Dew Point -40DEG F Flow Rate	50CFH
Single or Multiple Pass	SINGLE		
Single or Multiple Arc	SINGLE		
Welding Current	DC		
Polarity	REVERSE ELECTRODE POSITIVE		
Welding Progression	STRINGER		
Root Treatment	D1.5		
Preheat and Interpass Temperature	D1.5		
Postheat Temperature	NONE		
Heat Input	Min	Max	

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
Variable	LIMITS	341 TO 269	27 TO 23	12 TO 10	



This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 3009

Revision No.

Contractor Elderlee, Inc.

Authorized By RANDY SCOTT

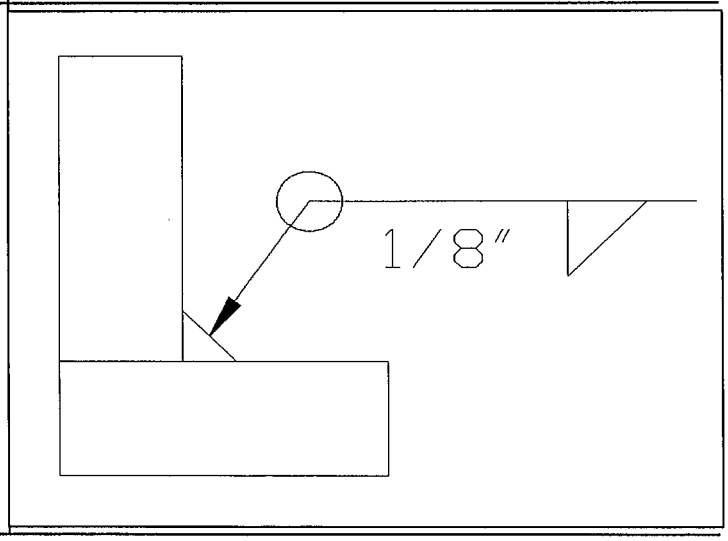
Date 3/20/2014

WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE #3

Material Specification	ASTM-A500-A53-GRADE B TO A36			
Welding Process	FCAW-G			
Manual or Machine	SEMAUTOMATIC			
Position of Welding	1G			
Filler Metal Specification	A5.29			
Filler Metal Classification	E81T1-Ni1C-JH4			
Flux	N/A			
Shielding Gas	CO 2	Dew Point	-40DEG F	FLOW RATE 50 CFH
Single or Multiple Pass	SINGLE			
Single or Multiple Arc	SINGLE			
Welding Current	DC			
Polarity	REVERSE ELECTRODE POSITIVE			
Welding Progression	STRINGER			
Root Treatment	PER D1.5			
Preheat and Interpass Temperature	PER. D1.5			
Postheat Temperature	NONE			
Heat Input	Min		Max	

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
Variable	LIMITS	341 TO 269	27 TO 23	12 TO 10	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

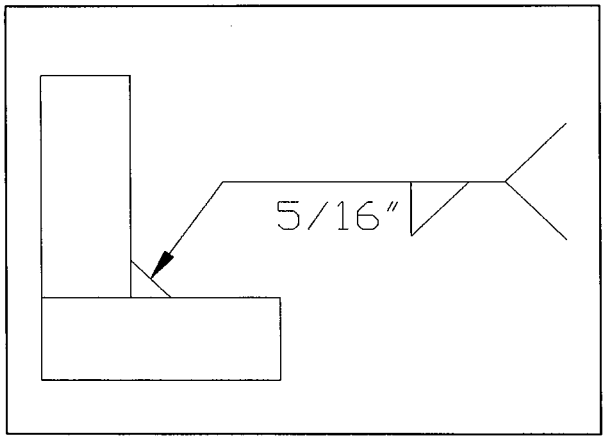
Procedure No.	3012	Contractor	Elderlee, Inc.
Revision No.		Authorized By	RANDY SCOTT
		Date	3/20/2014

WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE #3

Material Specification	ASTM A572 GR. 50
Welding Process	FCAW-G
Manual or Machine	SEMAUTOMATIC
Position of Welding	FLAT/HORIZONTAL
Filler Metal Specification	A5.29
Filler Metal Classification	E81T1-Ni1C-JH4
Flux	N/A
Shielding Gas	CO 2 Dew Point -40DEG F Flow Rate 50CFH
Single or Multiple Pass	SINGLE
Single or Multiple Arc	SINGLE
Welding Current	DC
Polarity	REVERSE ELECTRODE POSITIVE
Welding Progression	STRINGER
Root Treatment	CLEAN PER D1.5
Preheat and Interpass Temperature	PER D1.5
Postheat Temperature	NONE
Heat Input	Min _____ Max _____

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
Variable	LIMITS	341 TO 269	27 TO 23	12 TO 10	

This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 3019

Revision No. _____

Contractor Elderlee, Inc.

Authorized By RANDY SCOTT

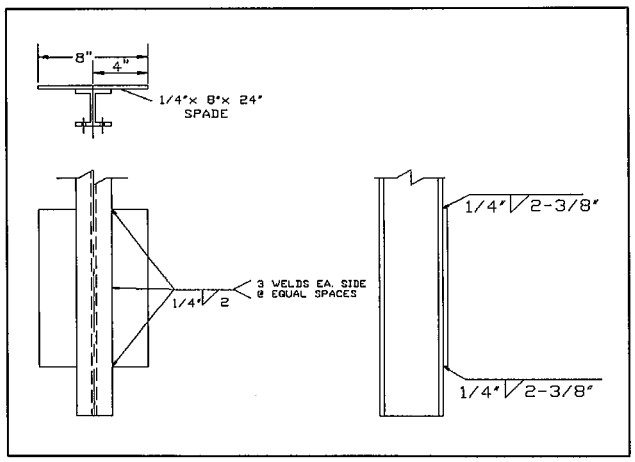
Date 3/20/2014

WELDING PROCEDURE SPECIFICATION

Material Specification	ASTM A36-08
Welding Process	GMAW
Manual or Machine	SEMIAUTOMATIC/ROBOTIC
Position of Welding	FLAT/HORIZONTAL
Filler Metal Specification	A5.18
Filler Metal Classification	L-56 LINCOLN
Flux	N/A
Shielding Gas	90% ARGON /10% CO2 Dew Point -40DEG F Flow Rate 45CFH
Single or Multiple Pass	SINGLE
Single or Multiple Arc	SINGLE
Welding Current	DC
Polarity	REVERSE
Welding Progression	STRINGER
Root Treatment	PER D1.5
Preheat and Interpass Temperature	PER D1.5
Postheat Temperature	NONE
Heat Input	Min _____ Max _____

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
	.045	190	22	19	
Variable	LIMITS	171 TO 209	20 TO 24	17 TO 21	



This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 3022

Revision No. _____

Contractor Elderlee, Inc.

Authorized By RANDY SCOTT

Date 3/20/2014

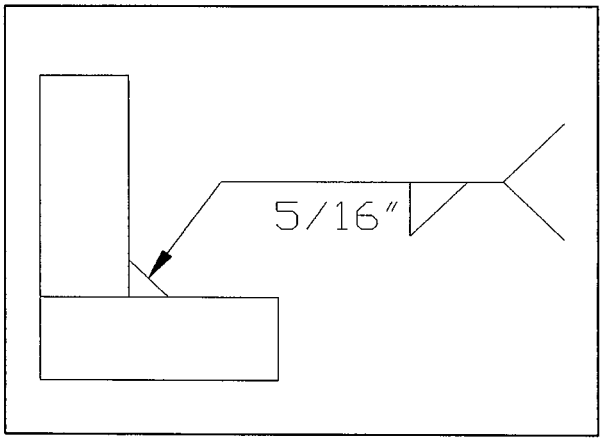
WELDING PROCEDURE SPECIFICATION

PQR ELDERLEE #3

Material Specification	ASTM A572 GR. 50 CVN	A500 GR B	
Welding Process	FCAW-G		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	FLAT/HORIZONTAL		
Filler Metal Specification	A5.29		
Filler Metal Classification	E81T1-Ni1C-JH4		
Flux	N/A		
Shielding Gas	CO 2	Dew Point -40DEG F	Flow Rate 50CFH
Single or Multiple Pass	SINGLE		
Single or Multiple Arc	SINGLE		
Welding Current	DC		
Polarity	REVERSE ELECTRODE POSITIVE		
Welding Progression	STRINGER		
Root Treatment	PER D1.5		
Preheat and Interpass Temperature	PER D1.5		
Postheat Temperature	NONE		
Heat Input	Min	Max	

WELDING PROCEDURE

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	1/16	310	25	11	
Variable	LIMITS	341 TO 269	27 TO 23	12 TO 10	



This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variables given in Section 5.

Procedure No. 3037

Revision No.

Contractor Elderlee, Inc.

Authorized By RANDY SCOTT

Date 3/20/2014