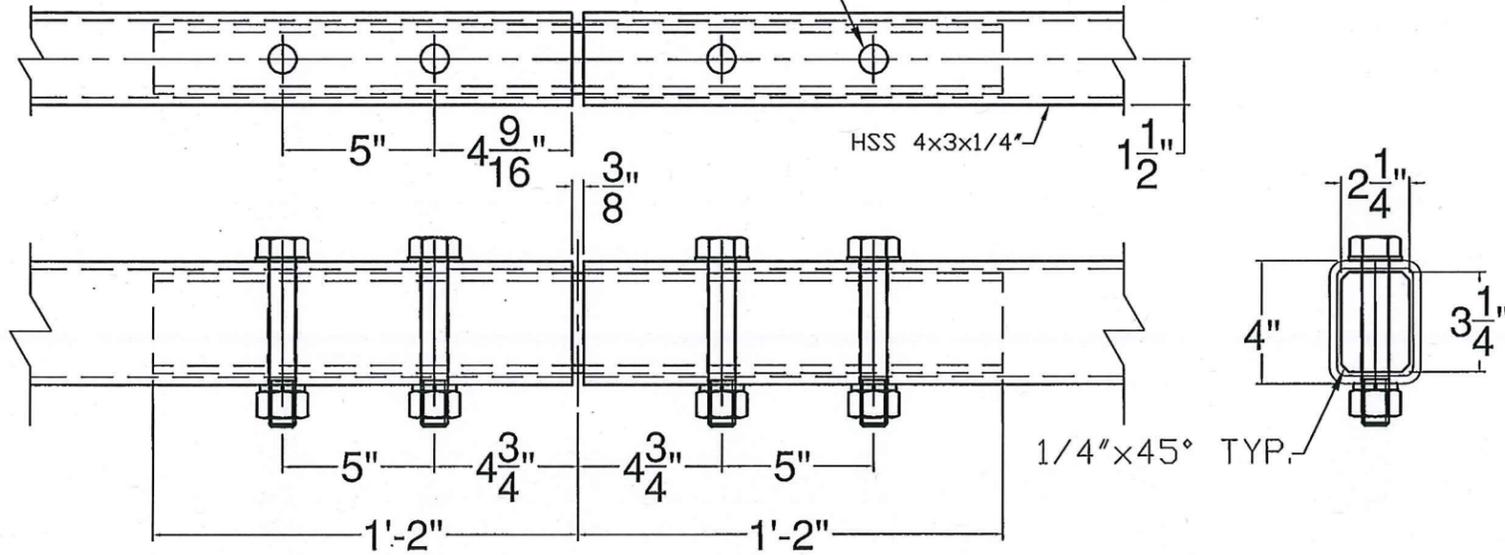


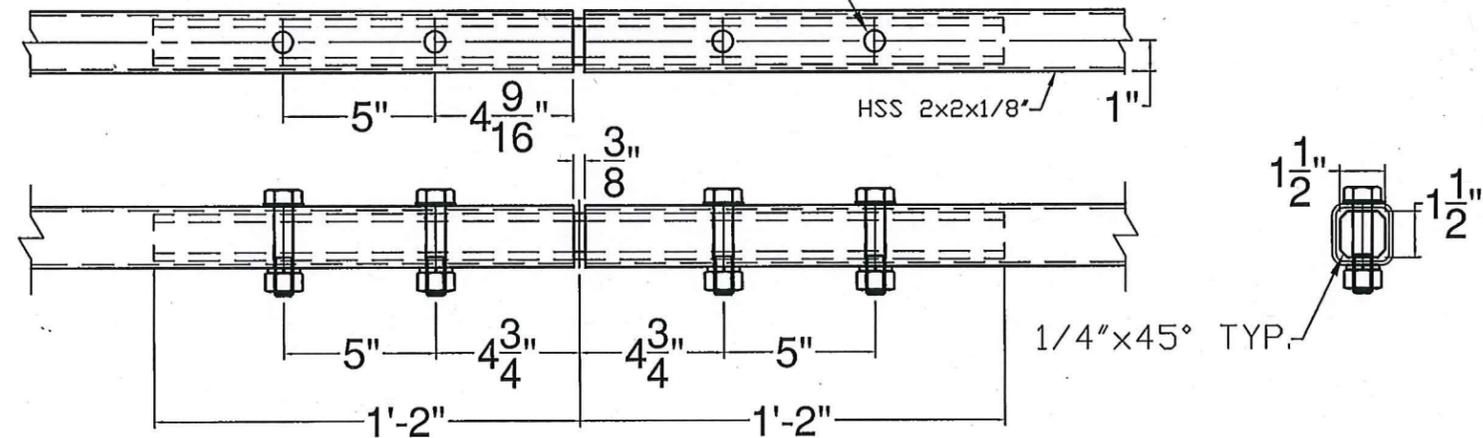
Ø15/16" THRU TUBE & SPLICE BAR,
 Ø7/8"X5 1/2" HEX BOLT & NUT,
 W/ (1) PLAIN HARDENED WASHER &
 (1) LOCK WASHER (4 PLACES)

TOP 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)

BOTTOM RAIL FIXED SPLICE DETAIL



Vermont Agency of Transportation

RECEIVED

ON: **May 30, 2014**

and Checked for

CONFORMANCE

BY: Jennifer Fitch DATE: 06/02/2014

SHOP DRAWING REVIEW

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: 57526
 Reviewed By: B. Moore
 Date: 5-30-14

ITEM #: 900.640

SHEET 2 OF 2

APPROVED BY:

BRIDGE RAIL DETAILS SHEET

ROCHESTER, BR 0162 (16) VT RTE 73 (MAJOR COLLECTOR), BRIDGE NO. 15, OVER BRANDON BROOK
 TOWN OF ROCHESTER, COUNTY OF WINDSOR, VT

R NO.	DATE	DESCRIPTION	BY	R NO.	DATE	DESCRIPTION	BY
1	5/28/14	REVISE PER 5/27/14 EMAIL	E.P.				

	ELDERLEE, INC.		DRAWN	E.P.	5/6/14
OAKS CORNERS, NEW YORK 14518			CHECKED	D.L.	5/6/14
E-Mail: dlong@elderlee.com / epeek@elderlee.com			APPROVED		
Tel: 315-789-6670 Fax: 315-789-6615			SCALE	SCHEMATIC	
			DRAWING NO. FR L - ROCH-BR15		

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	27	12	
		TO 269	TO 23	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

SHOP DRAWING REVIEW	
<input type="checkbox"/> 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. <input type="checkbox"/> REJECTED <input type="checkbox"/> REVISE AND RESUBMIT <input checked="" type="checkbox"/> 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: <u>57526</u> Reviewed By: <u>B. Mone</u> Date: <u>5-30-14</u>

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 BY: Jennifer Fitch DATE: 06/02/2014

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	27	12	
		TO 269	TO 23	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

SHOP DRAWING REVIEW	
<input type="checkbox"/> 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. <input type="checkbox"/> REJECTED <input type="checkbox"/> REVISE AND RESUBMIT <input checked="" type="checkbox"/> FURNISH AS CORRECTED	
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VHB	Job Number: <u>57526</u> Reviewed By: <u>B. Moore</u> Date: <u>5-30-14</u>

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