

Vermont Agency of Transportation

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ON: October 7, 2015

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BY: Jennifer Fitch DATE: 10/19/2015

SUBMITTAL REVIEW

REVIEWED AND APPROVED BUT ONLY FOR CONFORMANCE TO THE CONSTRUCTION CONTRACT DOCUMENTS

REVISE AND RESUBMIT

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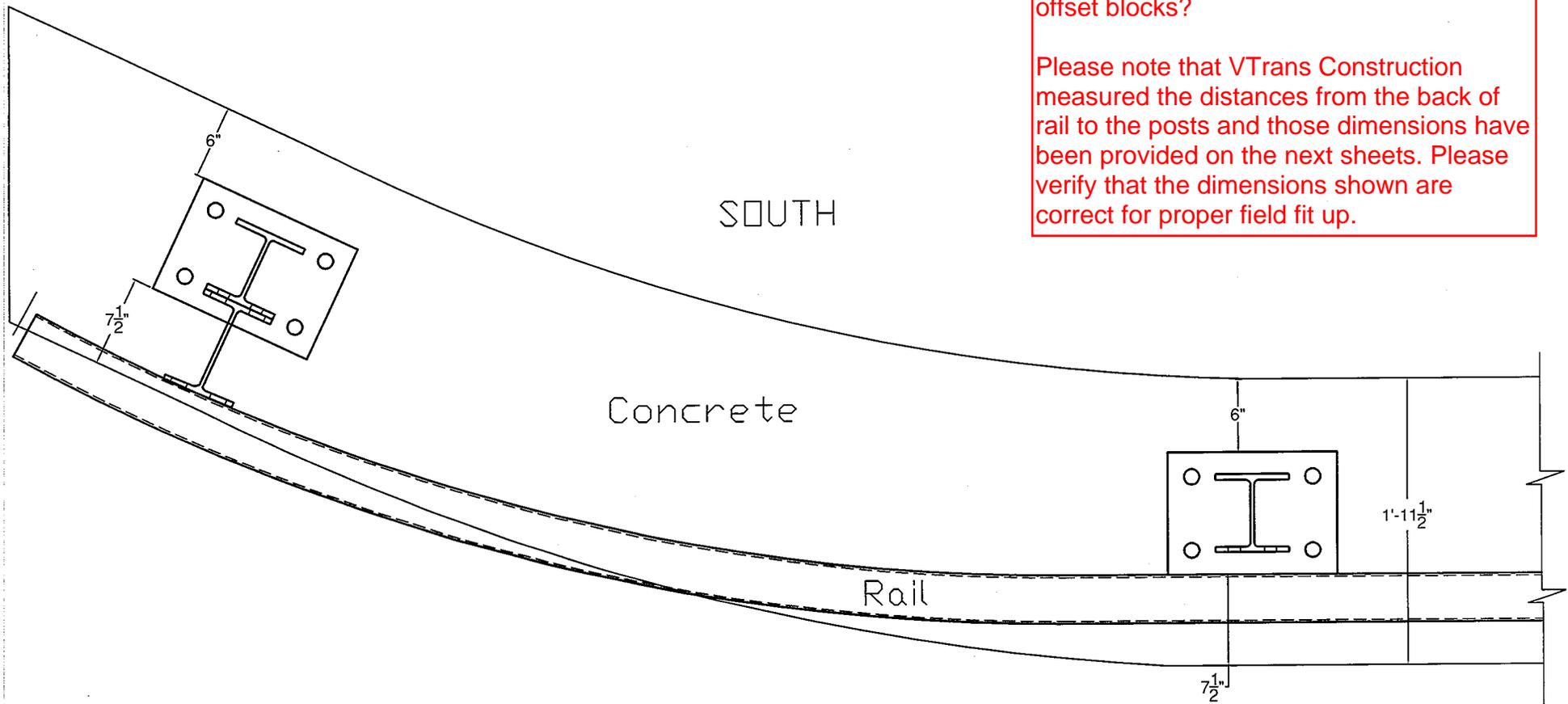
40 IDX Drive
Building 100, Suite 200
South Burlington, VT 05403
802.497.6100

Job Number: 57517.00
Reviewed By: E.F. LAWES
Date: 10/19/2015

Is it intended to have a full penetration weld in the web thickness?

How does the flange angle get put into the offset blocks?

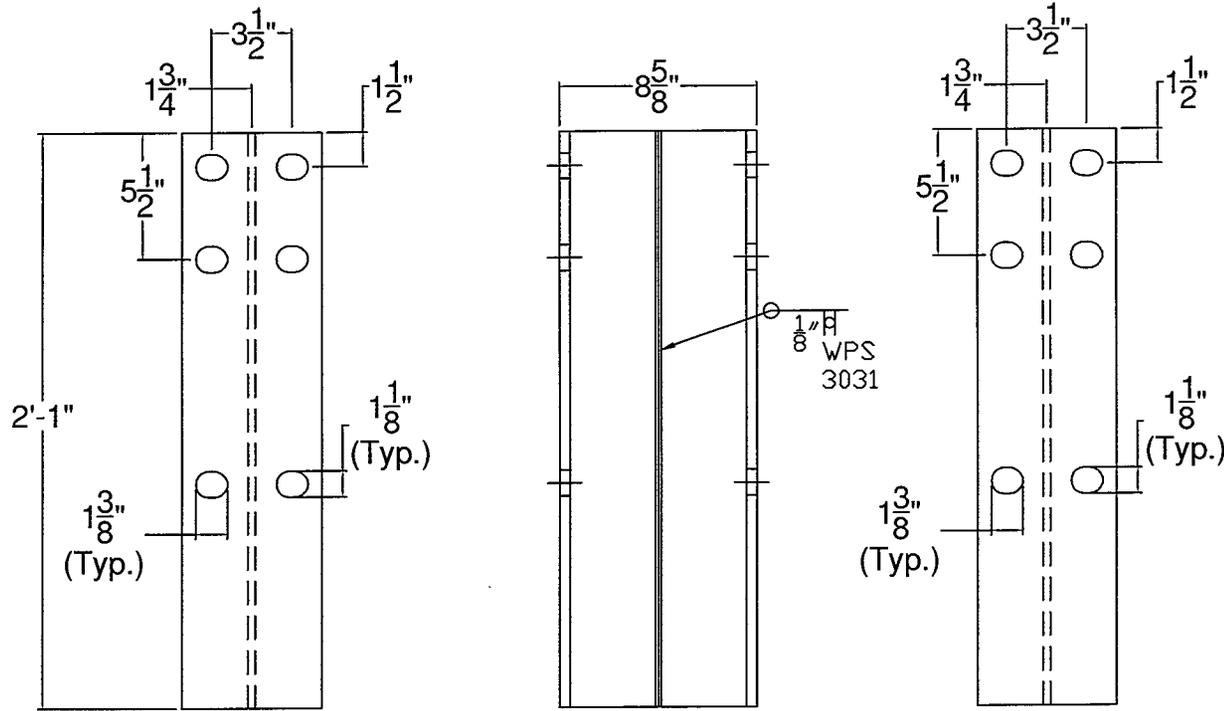
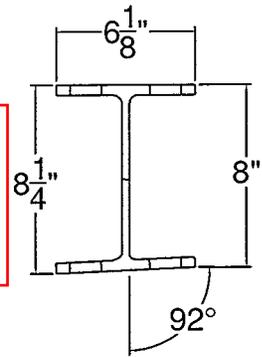
Please note that VTrans Construction measured the distances from the back of rail to the posts and those dimensions have been provided on the next sheets. Please verify that the dimensions shown are correct for proper field fit up.



State of Vermont
 Rochester Bridge 19
 Cut from W6x25 I-Beam
 ASTM A572, Grade 50
 Item: #0033.903955
 Quantity: 1

9" Top Rail
 8 1/2" Bot Rail

8 1/2" Top Rail
 8" Bottom Rail



Back

Side

Front

Southeast Corner
 for Last Bridge Post

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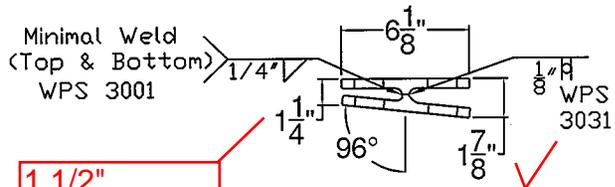
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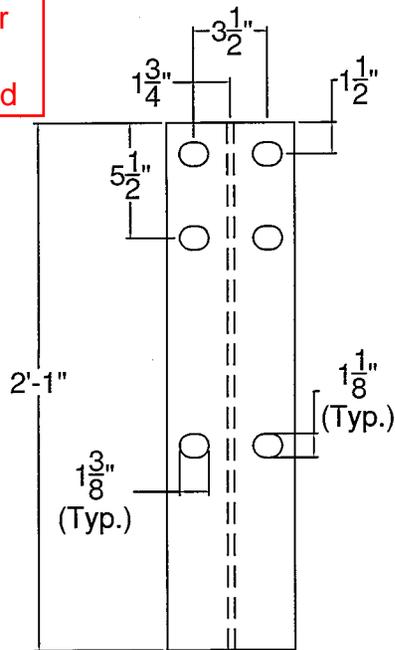
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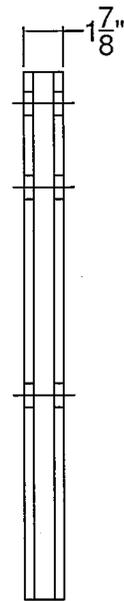
State of Vermont
 Rochester Bridge 19
 Cut from W6x25 I-Beam
 ASTM A572, Grade 50
 Item: #0033.903952
 Quantity: 1



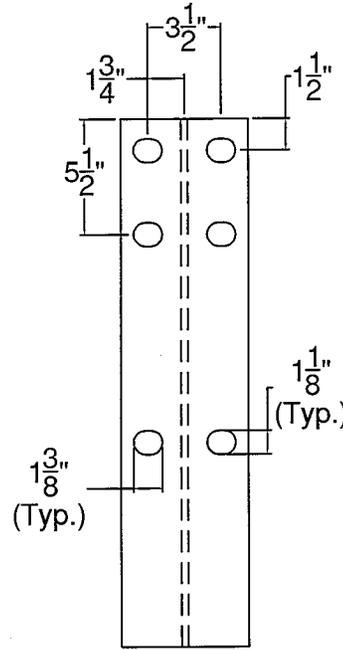
1 1/2"
 Top Corner
 of Post is
 Bent Inward



Back



Side



Front

Southeast Corner
 for Post #1

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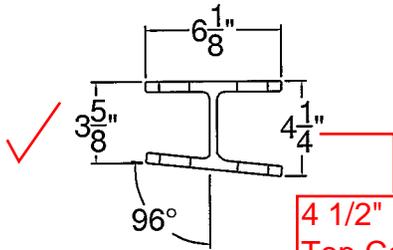
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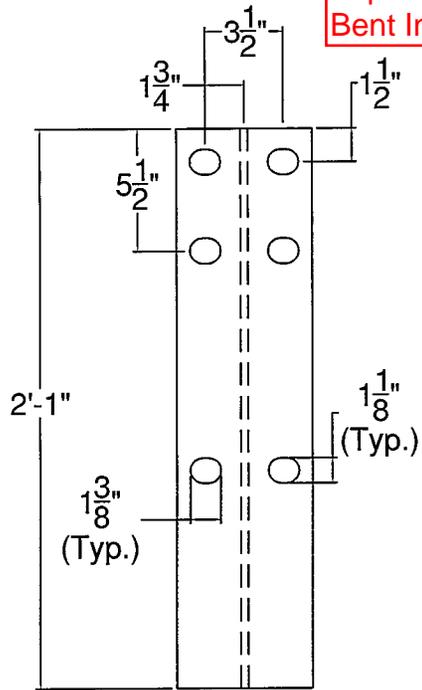
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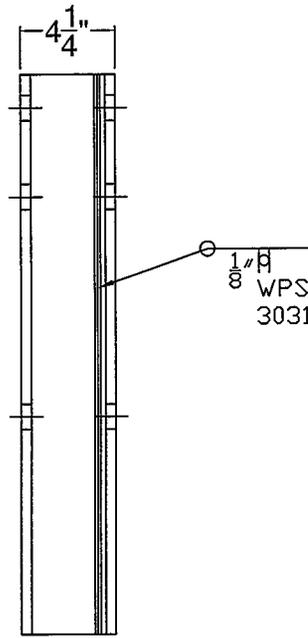


4 1/2"
Top Corner is
Bent Inward

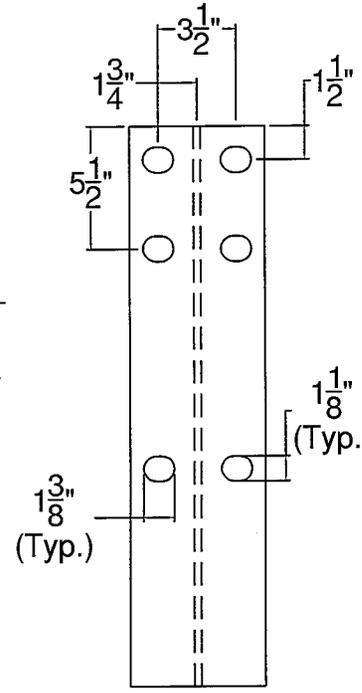
State of Vermont
Rochester Bridge 19
Cut from W6x25 I-Beam
ASTM A572, Grade 50
Item: #0033.903953
Quantity: 1



Back



Side



Front

Southeast Corner
for Post #2

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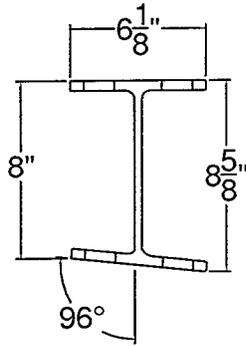


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Reviewed By: E.F. LAWES
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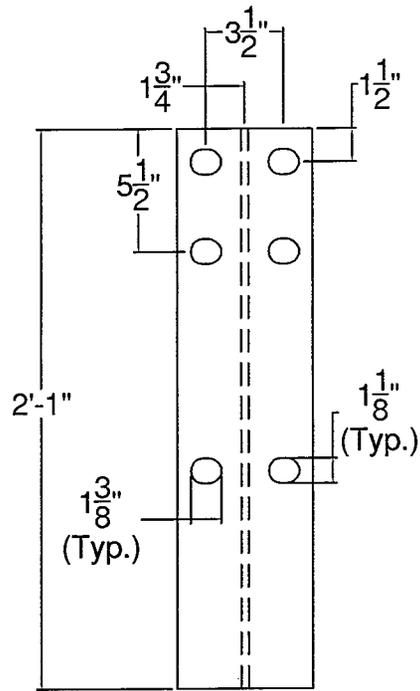
Post Sits 1" Behind Curb

8 1/4" Top Rail
7 3/8" Bot Rail

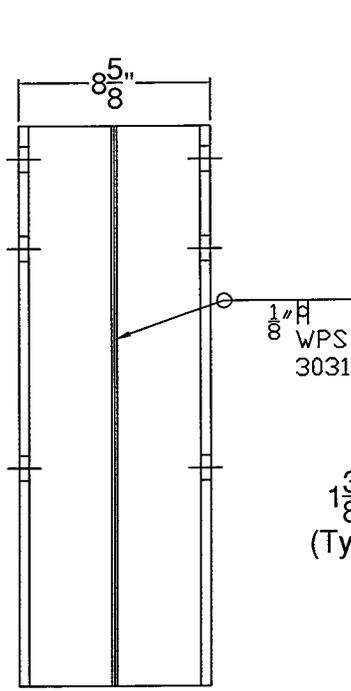


9 1/8" Top Rail
8 1/8" Bot Rail

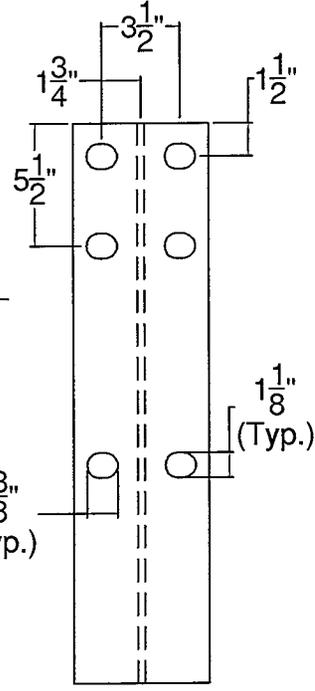
State of Vermont
Rochester Bridge 19
Cut from W6x25 I-Beam
ASTM A572, Grade 50
Item: #0033.903954
Quantity: 1



Back



Side



Front

Southeast Corner
for Post #3

Vermont Agency of Transportation

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South Burlington, VT 05403
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Job Number: 57517.00
Reviewed By: E.F. LAWES
Date: 10/19/2015

**WELDING PROCEDURE SPECIFICATION
PQR ELDERLEE #3**

Material Specification	A572 GRADE 50 TO A572 GRADE 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	
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		
	1/16	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. 3031
Revision No. _____

Contractor Elderlee, Inc.
Authorized By RANDY SCOTT
Date 10/6/2015

ON: **October 7, 2015**
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Vermont Agency of Transportation

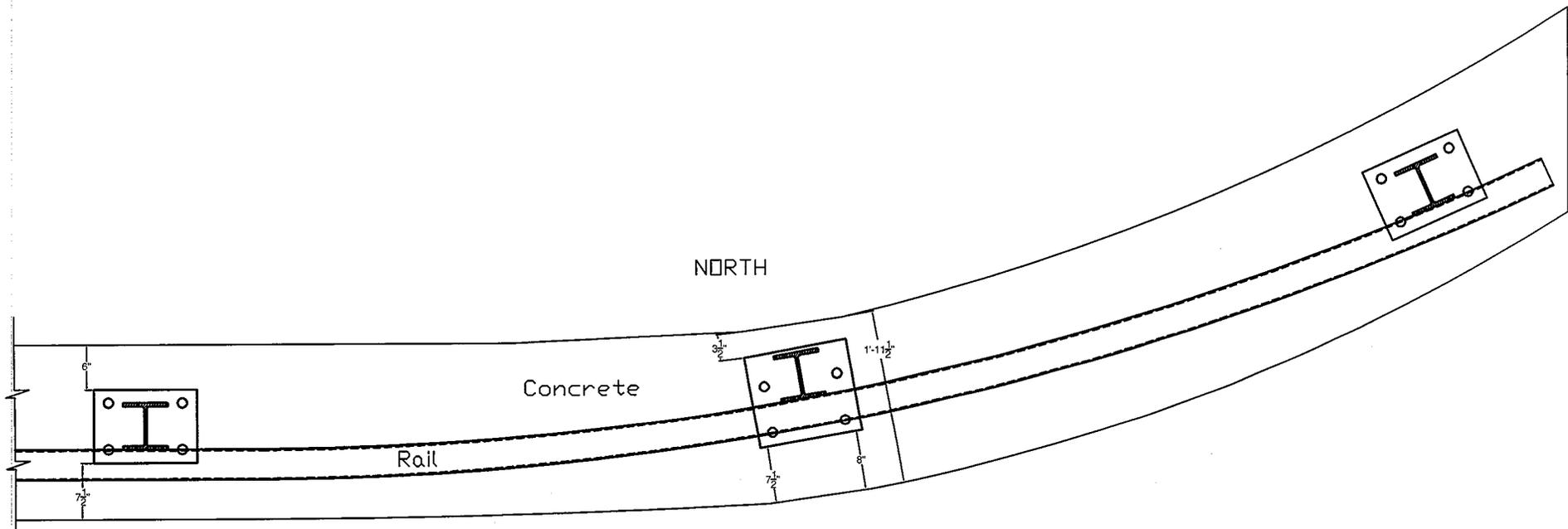
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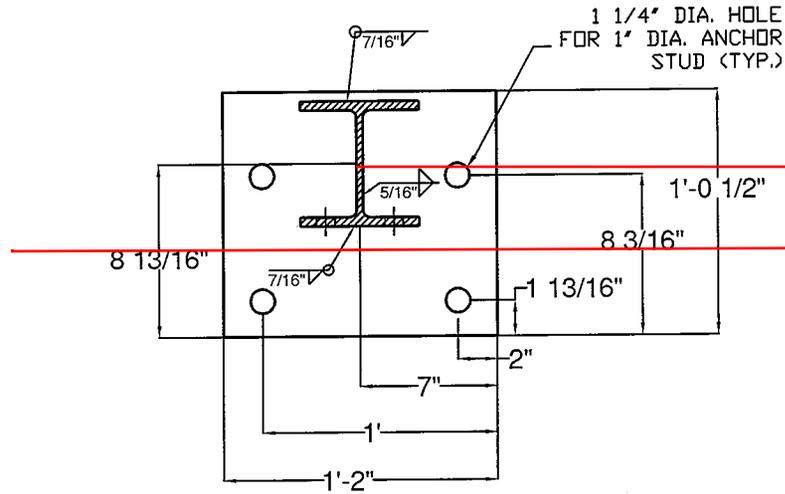
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BY: **Jennifer Fitch** DATE: **10/19/2015**

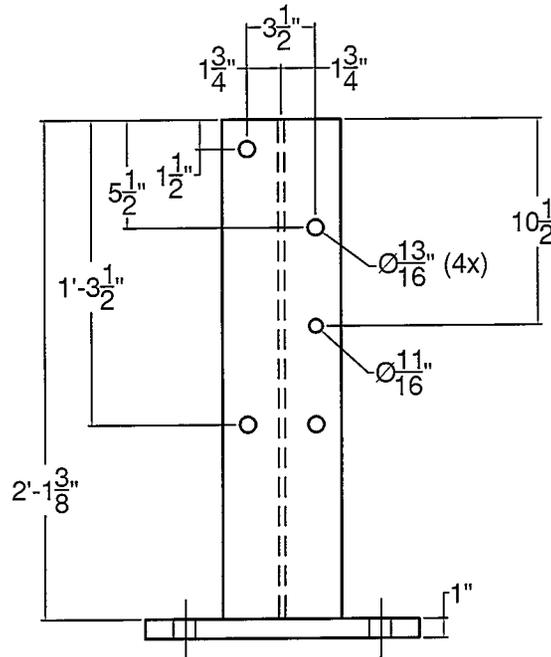
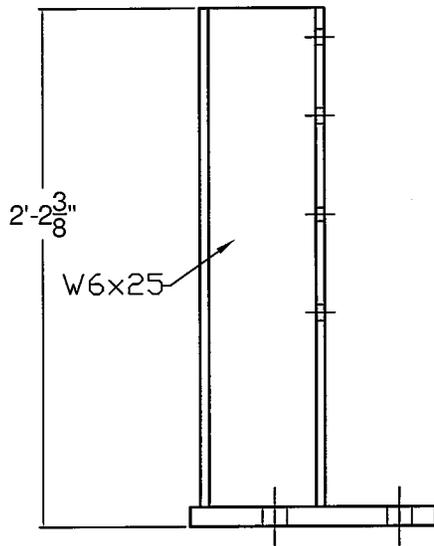


State of Vermont
 Rochester Bridge 19
 ASTM A572, Grade 50
 Item: #0033.903951
 Quantity: 1



4 1/4" from back of rail to proposed CL of post

WPS 3024



NORTH

Vermont Agency of Transportation

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802.497.6100

Job Number: 57517.00
Reviewed By: E.F. LAWES
Date: 10/19/2015

WELDING PROCEDURE SPECIFICATION

Material Specification	<u>A572 GRD. 50 /A992-06a</u>		
Welding Process	<u>FCAW</u>		
Manual or Machine	<u>SEMAUTOMATIC</u>		
Position of Welding	<u>FLAT</u>		
Filler Metal Specification	<u>A5.20</u>		
Filler Metal Classification	<u>E70 LINCOLN OUTERSHEILD</u>		
Flux	<u>N/A</u>		
Shielding Gas	<u>CO 2</u>	Dew Point	<u>-40DEG F</u>
Single or Multiple Pass	<u>SINGLE</u>	Flow Rate	<u>50 CFM</u> (45 TO 63 CFM)
Single or Multiple Arc	<u>N/A</u>		
Welding Current	<u>DC</u>		
Polarity	<u>DCEP</u>		
Welding Progression	<u>STRINGER</u>		
Root Treatment	<u>PER D1.5</u>		
Preheat and Interpass Temperature	<u>PER DI.5</u>		
Postheat Temperature	<u>NONE</u>		
Heat Input	Min _____	Max _____	

WELDING PROCEDURE.

Pass no.	Electrode size	Welding Current		Travel speed	Joint detail
		Amperes	Volts		
1	3/32	390	27	12	
Variable	LIMITS	351 TO 429	25 TO 29	11 TO 13	

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

Procedure No. 3024
Revision No. _____

Contractor Elderlee, Inc.
Authorized By RANDY SCOTT
Date 5/1/2013

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