

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 checked="" type="checkbox"/> REVISE AND RESUBMIT
<input 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.	
 40 IDX Drive Building 100, Suite 200 South Burlington, VT 05403 802.497.6100	Job Number: <u>57517.00</u> Reviewed By: <u>S.E. BURBANK</u> Date: <u>11/3/2015</u>

Notes:

- 1) While a note has been added saying the welds are full penetration welds, both the procedure WPS3031 and the symbols/details are not for full penetration welds. These welds/joints should match one of the details shown in figure 2.4 of the AWS D1.5.
- 2) The offset block labeled "Southeast Corner for Post #1" does not seem possible to weld. The side view shows WPS3031 being used to weld all the way around the web joint but based on the top view dimensions, that doesn't seem possible. However, in the top view it shows WPS3031 only being welded on one side of the web and an unknown WPS 3001 being used for "minimal weld top and bottom" that is a 1/4" fillet weld. It is unclear what the intentions are here but certainly this isn't a full penetration weld.

Vermont Agency of Transportation

2015-11-3 Rochester ER BRP 016218 Review.pdf

RECEIVED

ON: October 27, 2015

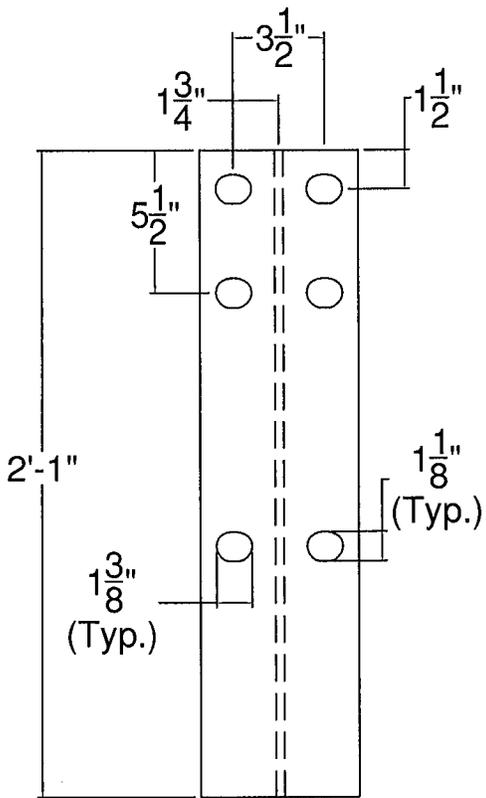
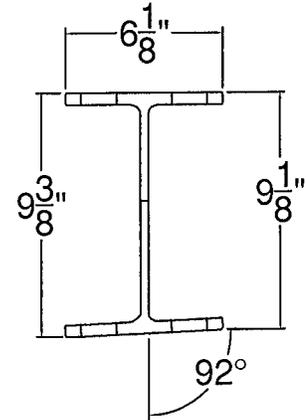
and Checked for

CONFORMANCE

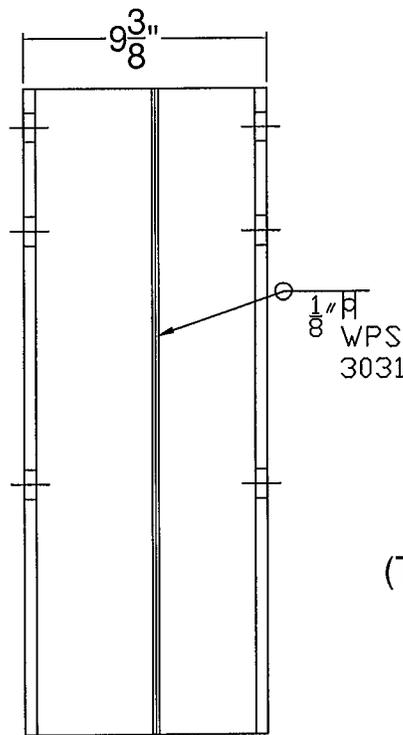
BY: Jennifer Fitch DATE: 11/4/2015

REVISED on 10/27/2015
 State of Vermont
 Rochester Bridge 19
 Cut from W6x25 I-Beam
 ASTM A572, Grade 50
 Item: #0033.903955

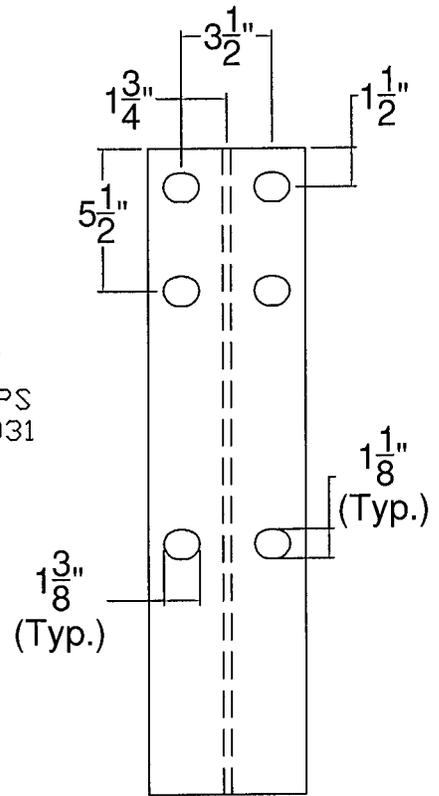
Quantity: 1
 WPS 3031 = Full Penetration Weld
 The Flange Angle will be Cold
 Formed on a press break.



Back

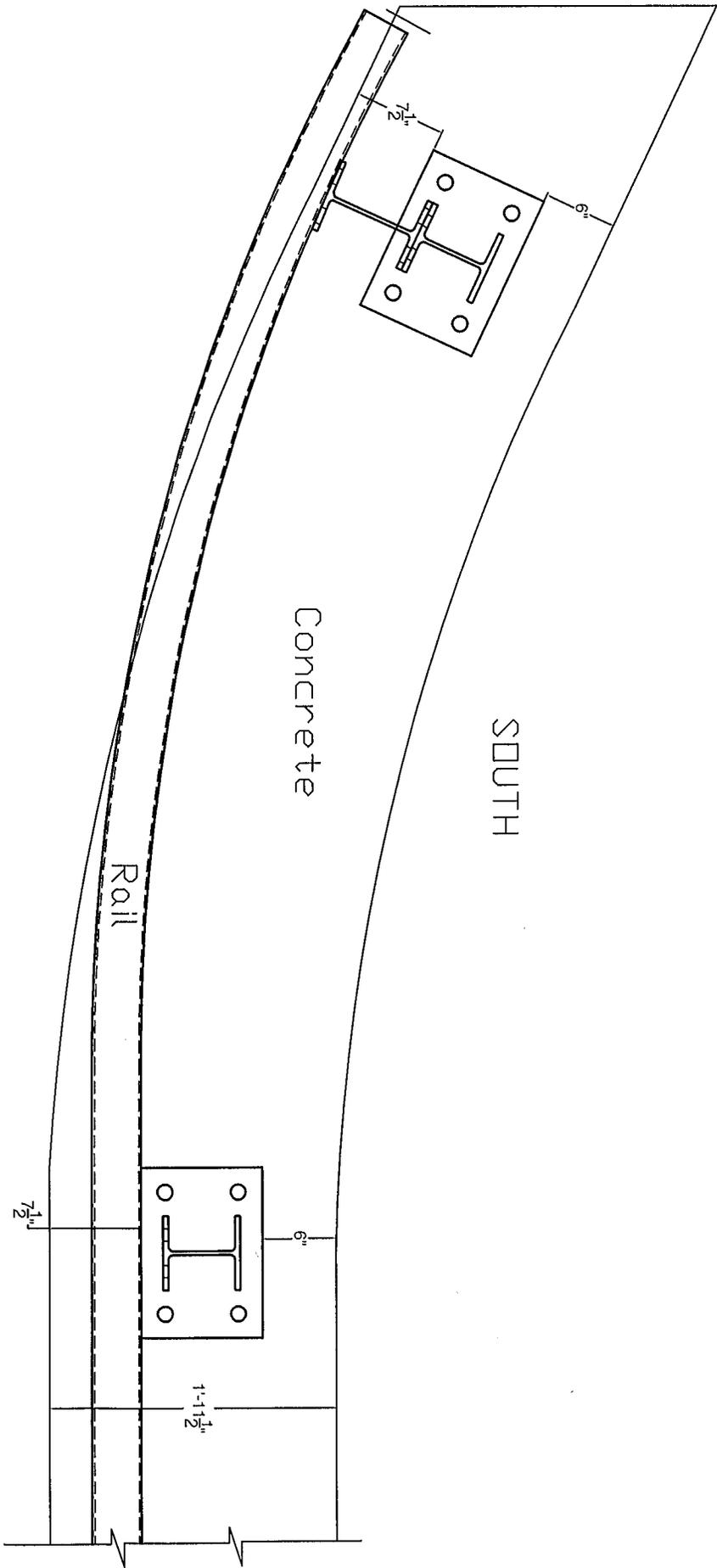


Side



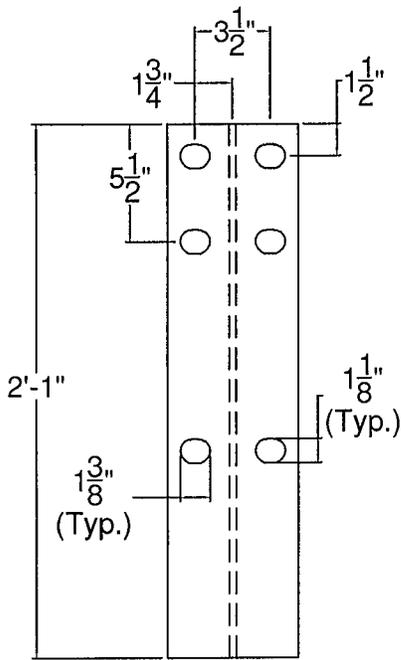
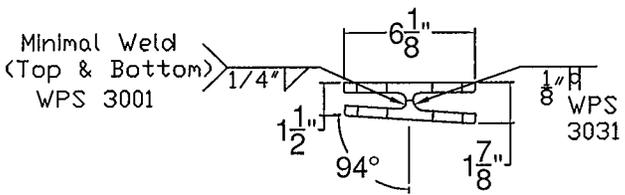
Front

Southeast Corner
 for Last Bridge Post

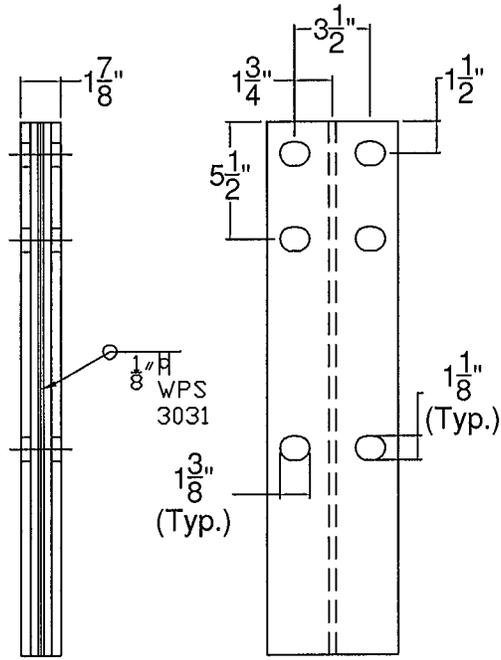


REVISED on 10/27/2015
 State of Vermont
 Rochester Bridge 19
 Cut from W6x25 I-Beam
 ASTM A572, Grade 50
 Item: #0033.903952

Quantity: 1
 WPS 3031 = Full Penetration Weld
 The Flange Angle will be Cold
 Formed on a press Break



Back



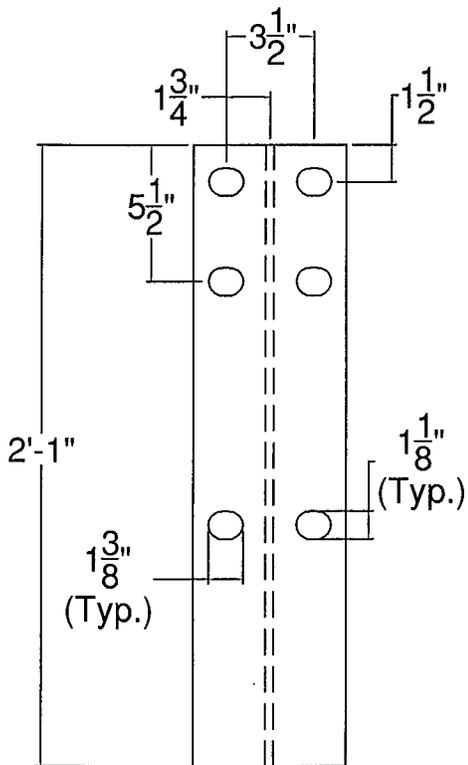
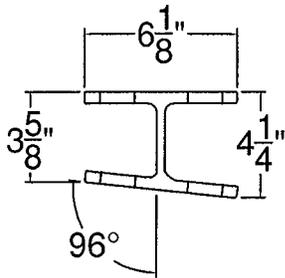
Side

Front

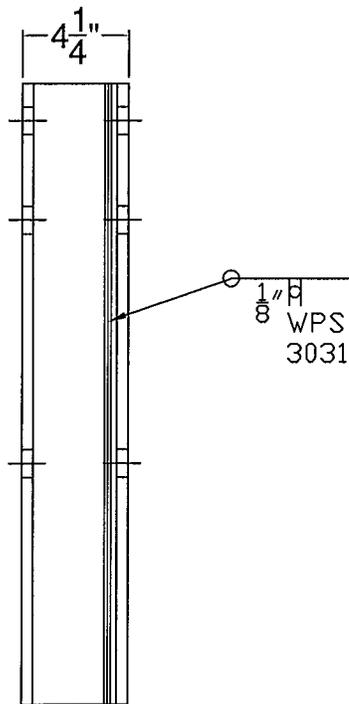
Southeast Corner
 for Post #1

REVISED on 10/27/2015
 State of Vermont
 Rochester Bridge 19
 Cut from W6x25 I-Beam
 ASTM A572, Grade 50
 Item: #0033.903953

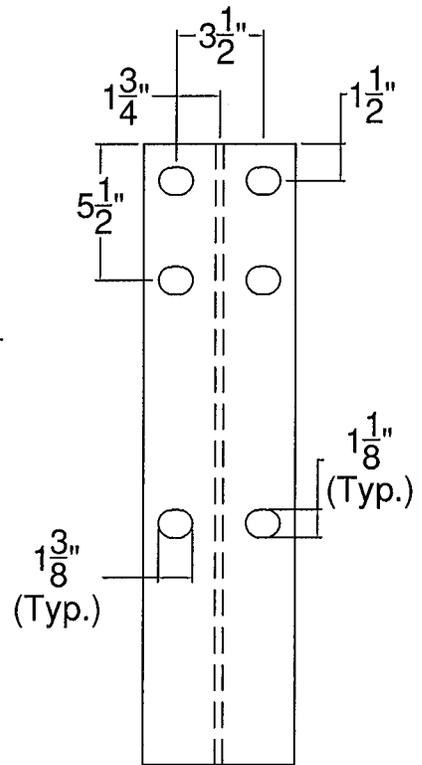
Quantity: 1
 WPS 3031 = Full Penetration Weld
 The Flange Angle will be Cold
 Formed on a press break



Back

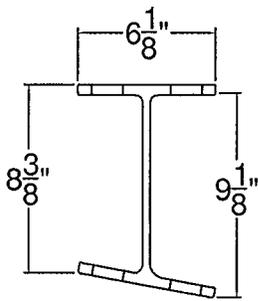


Side



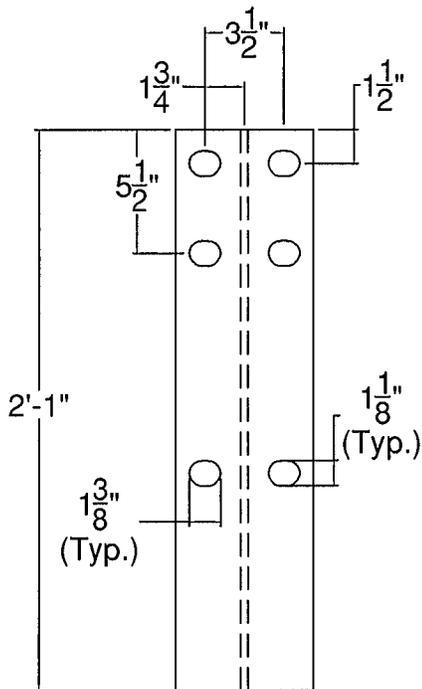
Front

Southeast Corner
 for Post #2

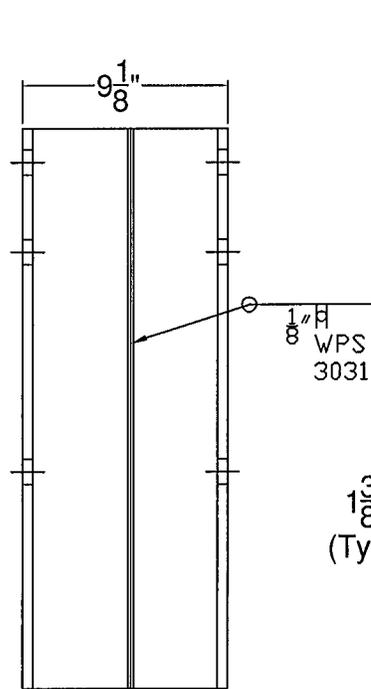


REVISED on 10/27/2015
 State of Vermont
 Rochester Bridge 19
 Cut from W6x25 I-Beam
 ASTM A572, Grade 50
 Item: #0033.903954

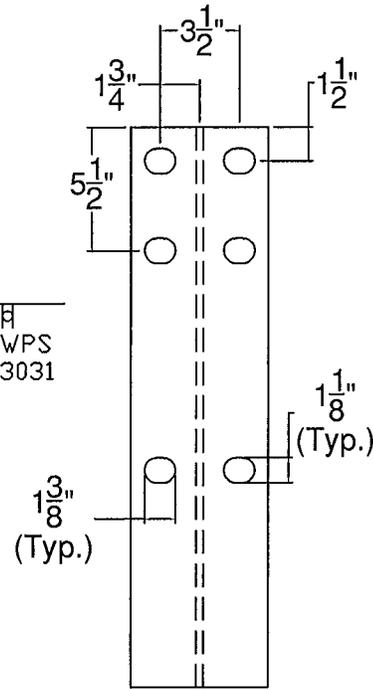
Quantity: 1
 WPS 3031 = Full Penetration Weld
 The Flange Angle will be Cold
 Formed on a press break



Back

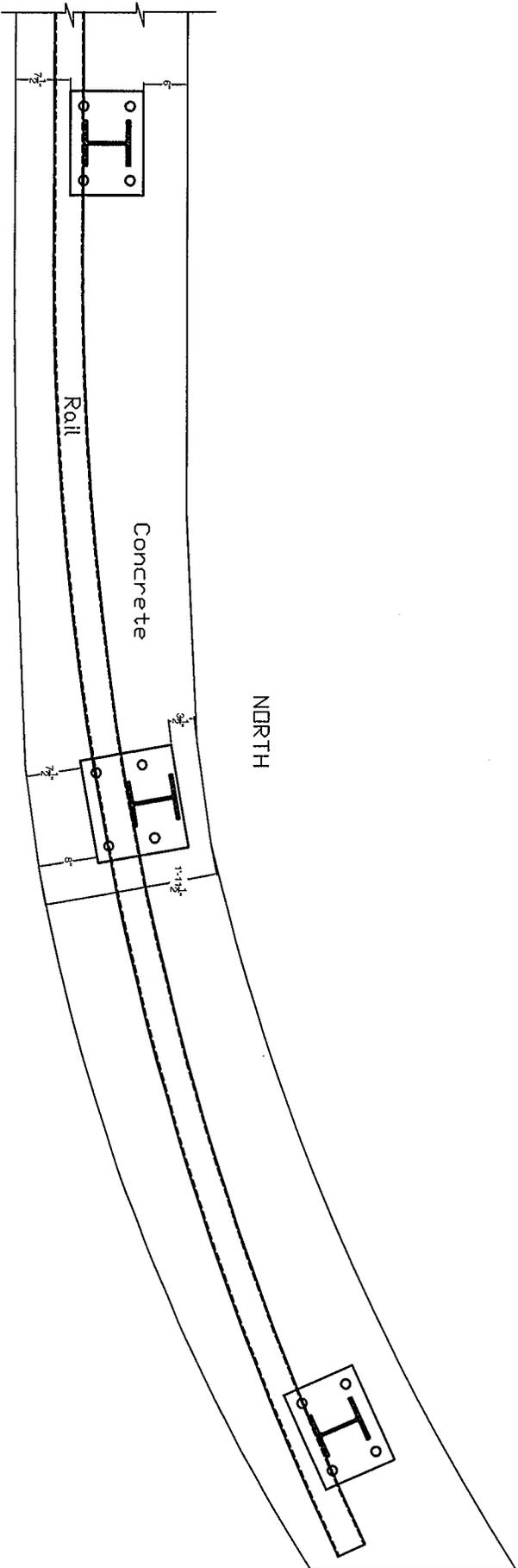


Side

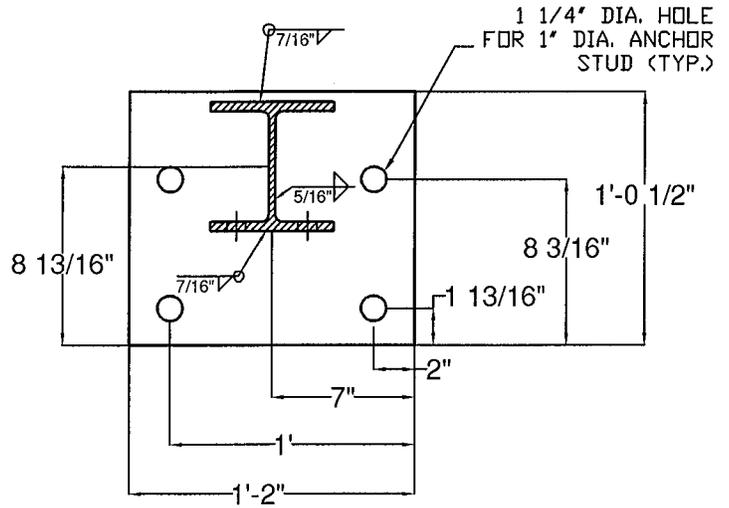


Front

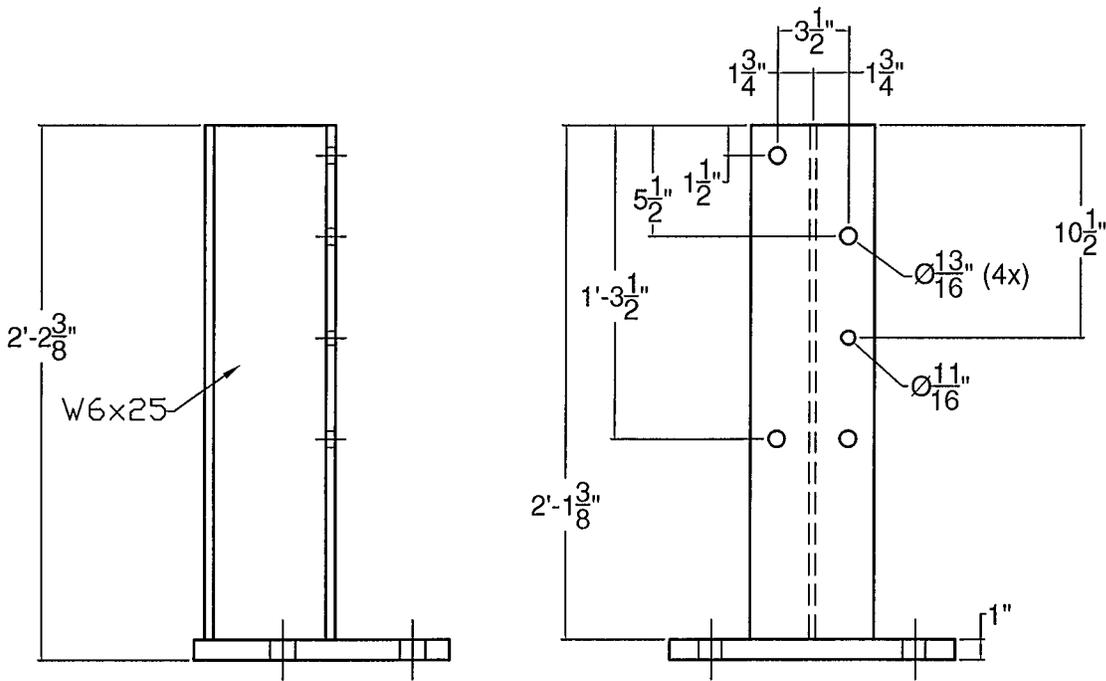
Southeast Corner
 for Post #3



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



WPS 3024



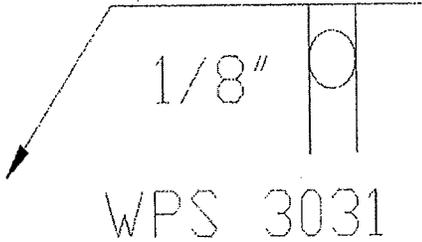
NORTH

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		
Variable	1/16	310	25	11	
	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

WELDING PROCEDURE SPECIFICATION

Material Specification	A572 GRD. 50 /A992-06a		
Welding Process	FCAW		
Manual or Machine	SEMAUTOMATIC		
Position of Welding	FLAT		
Filler Metal Specification	A5.20		
Filler Metal Classification	E70 LINCOLN OUTERSHEILD		
Flux	N/A		
Shielding Gas	CO2	Dew Point	-40DEG F Flow Rate 50 CFM
Single or Multiple Pass	SINGLE		(45 TO 63 CFM)
Single or Multiple Arc	N/A		
Welding Current	DC		
Polarity	DCEP		
Welding Progression	STRINGER		
Root Treatment	PER D1.5		
Preheat and Interpass Temperature	PER DI.5		
Postheat Temperature	NONE		
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	25	11	
		TO 429	TO 29	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