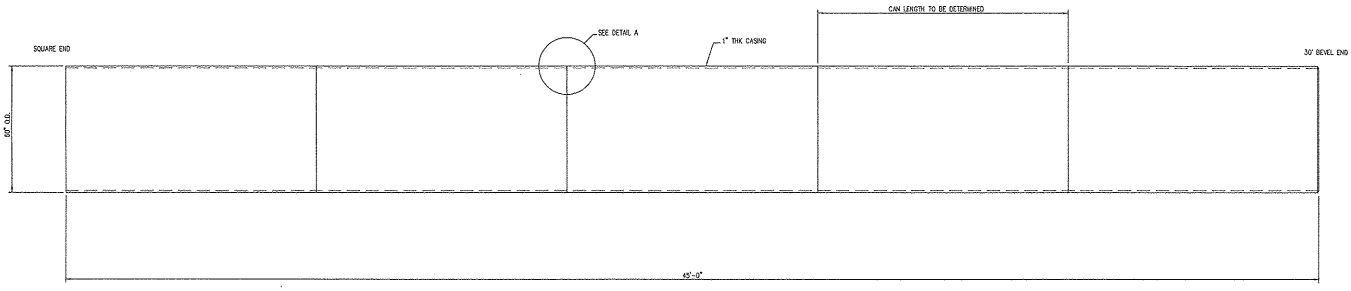
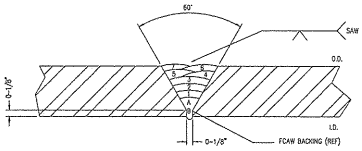


SPOOL No/ 60100-4

60" O.D. x 1.00 WALL



FCAW- SAW- WPS- D1
A. FCAW (HAND WELD FROM OUTSIDE)
B. FCAW (BACKGOUGE THEN HAND WELD FROM INSIDE)
1 thru 7 SAW (MACHINE WELD, MULTIPLE LAYERS REQ'D TO COMPLETE WELD)

DETAIL A

TYPICAL WELD JOINT
CIRCUMFERENTIAL & LONGITUDINAL
NO SCALE
(SECTION CUT FOR CLARITY)

VTrans
Received
CK'D_____ OK'd BY JWC

MAY 11 2012

Resubmit_____ APPROVED ✓
BY_____ DATE 5/14/12

GENERAL NOTES:

1. ALL WELDS TO BE CONTINUOUS WITH FULL PENETRATION, PERFORMED BY CERTIFIED WELDERS PER AWS D1.1
2. PIPE TO BE MANUFACTURED IN ACCORDANCE WITH ASTM A139 GR. B WITH THE EXCEPTION OF THE TESTS WAIVED BY THE STATE OF VERMONT AS DOCUMENTED IN WRITEN ORDER #18.

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REV. NO.	DATE	BY	DESCRIPTION

PROJECT NUMBER	IM CULV (23)
COMPANY	Bore Tech LLC, St. Johnsbury, VT.
PROJECT NAME	South Burlington- Colchester
DRAWN MBE	SCALE NONE
DATE 4/26/12	CHK'D
REF.	
DWG. NO.	60100

Valiant Steel and Equipment, Inc.
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