

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 APPROVED AS NOTED

CORRECTIONS OR COMMENTS MADE ON THE SHOP DRAWINGS DURING THIS REVIEW DID 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 THEIR WORK WITH THAT OF ALL OTHER TRADES, AND PERFORMING THEIR WORK IN A SAFE AND SATISFACTORY MANNER.

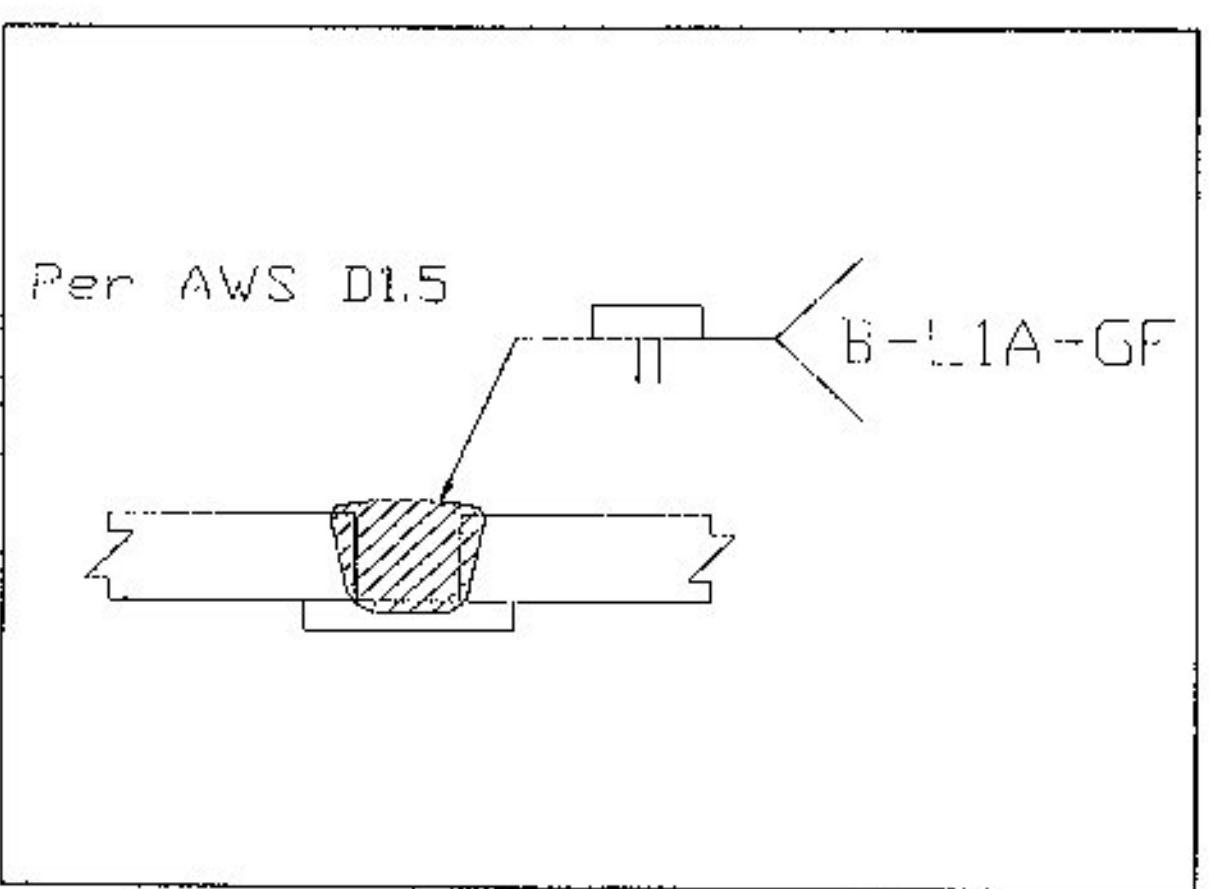
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Job Number: 1207124
Reviewed by: SRB
Date: 3/23/2015

WELDING PROCEDURE SPECIFICATION
PQR ELDERLEE #3

Material Specification: A500 TO A36
 Welding Process: FCAW-G
 Manual or Machine: SEMIAUTOMATIC
 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. 3026 Contractor Elderlee, Inc.
 Revision No. _____ Authorized By RANDY SCOTT
 Date 3/24/2014

Did not see this procedure referenced on shop drawings

Vermont Agency of Transportation
RECEIVED
 ON: February 25, 2015
 and Checked for
CONFORMANCE
 BY: Rob Young DATE: 03/23/2015