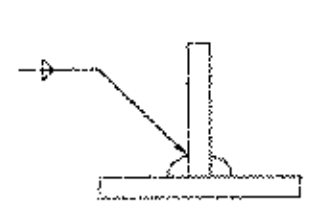
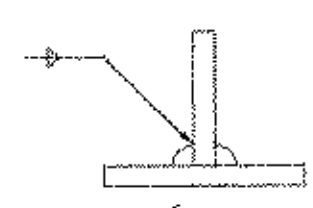


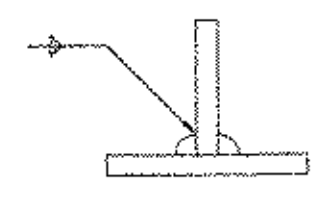
EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION

WPS NUMBER: FCAW PL#10-2				ISSUE DATE: 11-21-03			
PROJECT: VT AOT NO. BRP-0125-(135)				EB JOB NO.: 4065			
BASE METAL: ASTM A709 GR36,50,50W							
WELDING PROCESS: FCAW							
FILLER METAL SPEC: A5.29 ESAB 80-N1 DUAL SHIELD							
FLUX/SHIELDING GAS: 75% ARGON / 25% CO2							
CURRENT AND POLARITY: DCEP				ELEC STICKOUT: 1" ± 1/4"			
WELDING POSITION: 2F							
PREHEAT AND INTERPASS TEMP: AWS D1.5 TABLE 4.4				WPS QUALIFICATION: AWS D1.5, 5.13			
HEAT INPUT: 35 - 44.2 KILOJOULES							
SUPPORTING PQRP: FCAW-SA116-1 PL#10							
ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL AND AWS NUMBER: FILLET			
1/16"	290 - 320	24 - 26	11.3 - 12.0				
NOTES:				6MM FILLET			
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:							
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450°F							
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, °F				
UP TO 3/4"			50°F				
3/4" TO 1 1/2"			70°F				
1 1/2" TO 2 1/2"			150°F				
OVER 2 1/2"			225°F				
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN APPLICABLE AWS CODES AND CONTRACT DOCUMENTS.							

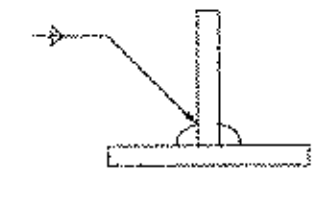
EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION

WPS NUMBER: SMAW PL# 00-03				ISSUE DATE: 11-21-03			
PROJECT: VT AOT NO. BRP-0125-(135)				EB JOB NO.: 4065			
BASE METAL: A709 GR36,50,50W							
WELDING PROCESS: SMAW							
FILLER METAL SPEC: A5.1 B5014 C3							
FLUX/SHIELDING GAS: N/A							
CURRENT AND POLARITY: DCEP				ELEC STICKOUT: N/A			
WELDING POSITION: 2F							
PREHEAT AND INTERPASS TEMP: AWS D1.5 TABLE 4.4				WPS QUALIFICATION: PREQUALIFIED			
HEAT INPUT: 38 - 110 KILOJOULES				SUPPORTING PQRP: N/A			
ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL AND AWS NUMBER: FILLET 2F			
1/8"	125 - 150	23 - 26	3 - 4.5 IPM				
5/32"	140 - 190	23 - 26	3 - 4.5 IPM				
3/16"	180 - 230	23 - 26	3 - 4.5 IPM				
NOTES:				6 mm & 8 mm			
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:							
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450°F							
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, °F				
UP TO 3/4"			50°F				
3/4" TO 1 1/2"			70°F				
1 1/2" TO 2 1/2"			150°F				
OVER 2 1/2"			225°F				
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN APPLICABLE AWS CODES AND CONTRACT DOCUMENTS.							

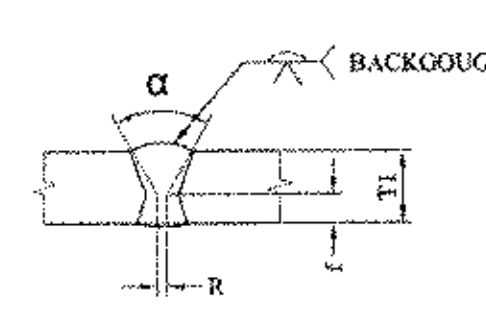
EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION

WPS NUMBER: FCAW PL#10-1				ISSUE DATE: 11-21-03			
PROJECT: VT AOT NO. BRP-0125-(135)				EB JOB NO.: 4065			
BASE METAL: ASTM A709 GR36,50,50W							
WELDING PROCESS: FCAW							
FILLER METAL SPEC: A5.29 ESAB 80-N1 DUAL SHIELD							
FLUX/SHIELDING GAS: 75% ARGON / 25% CO2							
CURRENT AND POLARITY: DCEP				ELEC STICKOUT: 1" ± 1/4"			
WELDING POSITION: 2F							
PREHEAT AND INTERPASS TEMP: AWS D1.5 TABLE 4.4				WPS QUALIFICATION: AWS D1.5, 5.13			
HEAT INPUT: 35 - 44.2 KILOJOULES							
SUPPORTING PQRP: FCAW - SA116-1 PL#10							
ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL AND AWS NUMBER: FILLET			
1/16"	290 - 320	24 - 26	11.3 - 12.0				
NOTES:				8 mm			
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:							
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450°F							
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, °F				
UP TO 3/4"			50°F				
3/4" TO 1 1/2"			70°F				
1 1/2" TO 2 1/2"			150°F				
OVER 2 1/2"			225°F				
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN APPLICABLE AWS CODES AND CONTRACT DOCUMENTS.							

EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION

WPS NUMBER: SAW PL#8-1				ISSUE DATE: 11-21-03			
PROJECT: VT AOT NO. BRP-0125-(135)				EB JOB NO.: 4065			
BASE METAL: ASTM A709 GR36,50,50W							
WELDING PROCESS: SUBMERGED ARC WELDING							
FILLER METAL SPEC: AWS A5.13 LINCOLN LA75							
FLUX/SHIELDING GAS: LINCOLN 960							
CURRENT AND POLARITY: DCEP				ELEC STICKOUT: 1" ± 1/4"			
WELDING POSITION: 2F							
PREHEAT AND INTERPASS TEMP: AWS D1.5 TABLE 4.4				WPS QUALIFICATION: AWS D1.5, 5.13			
HEAT INPUT: 50.68 - 73.92 KILOJOULES				SUPPORTING PQRP: SAW A332-3 PL#8			
ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL AND AWS NUMBER: FILLET			
3/32"	396 - 440	28.8 - 31.5	11.25 - 13.5				
NOTES:				8MM			
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:							
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450°F							
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, °F				
UP TO 3/4"			50°F				
3/4" TO 1 1/2"			70°F				
1 1/2" TO 2 1/2"			150°F				
OVER 2 1/2"			225°F				
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN APPLICABLE AWS CODES AND CONTRACT SPECIFICATIONS.							

EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION

WPS NUMBER: SAW PL#8-3				ISSUE DATE: 11-21-03			
PROJECT: VT AOT NO. BRP-0125-(135)				EB JOB NO.: 4065			
BASE METAL: ASTM A709 GR36,50,50W							
WELDING PROCESS: SUBMERGED ARC WELDING							
FILLER METAL SPEC: AWS A5.13 LINCOLN LA75							
FLUX/SHIELDING GAS: LINCOLN 960							
CURRENT AND POLARITY: DCEP				ELEC STICKOUT: 1" ± 1/4"			
WELDING POSITION: 2F							
PREHEAT AND INTERPASS TEMP: AWS D1.5 TABLE 4.4				WPS QUALIFICATION: AWS D1.5, 5.13			
HEAT INPUT: 50.68 - 73.92 KILOJOULES				SUPPORTING PQRP: SAW A332-3 PL#8			
ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL AND AWS NUMBER: B1.26-S			
3/32"	396 - 440	28.8 - 31.5	11.25 - 13.5				
NOTES:				BACKGOUGE			
R = 0							
I = 3.3" TO 5.5"							
α = 60°							
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:							
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450°F							
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, °F				
UP TO 3/4"			50°F				
3/4" TO 1 1/2"			70°F				
1 1/2" TO 2 1/2"			150°F				
OVER 2 1/2"			225°F				
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN APPLICABLE AWS CODES AND CONTRACT SPECIFICATIONS.							

REVISIONS			FRANK W. WHITCOMB CONSTRUCTION CO.	
NO.	DATE	DESCRIPTION	CONTRACT: -	STATE: -
1	11/21/03	Approval		
BRIDGE #12 VT 103-TH OVER WILLIAMS RIVER CHESTER, VERMONT				
TITLE: SHOP WELD PROCEDURES				
DRAWN BY: DA	SHOP ORDER: 4065	DWG. NO.:	WPS1	
20NOV03				
CRD BY: D.A. BAIN	BLOCK NO.:	SHEET NO.:	1 / 1	

