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Route VT 17 over Mill Brook
 Bridge Number 36 Improvement
 Project Number: BHF 0200 (9)
 Washington County, Vermont
 High Steel Structures Shop Number: VT-06062

OK'D BY _____ OK'D BY JLK
 RESUBMIT _____ APPROVED
 BY _____ DATE 9-14-06

VTRANS
 RECEIVED

**HEAT STRAIGHTENING/CAMBER ADJUSTMENT
 PROCEDURE**

ALL HEATING OPERATIONS MUST BE WITNESSED BY THE VERMONT AGENCY OF TRANSPORTATION SHOP INSPECTOR

Heating Process and Equipment

- Heating shall be performed using large, approximately one inch diameter, multi-orifice heating torches.
- Our torch handle selected is the Victor HD 310C. Torch tip is type SS15n (1-132 inch diameter).
- The heating pattern will be brought to a temperature range of 800 - 1125° F as rapidly as possible without overheating.
- Steel temperatures greater than 1125° F shall be considered destructive heating.
- Temperature indicating crayons shall be used to insure the metal is not heated more than 1125° F. Heat measurements shall be made after the heating flame had been removed from the steel.

Heating Patterns for Minor Sweep Adjustments

- When small adjustments are required to correct sweep, the application of heat to a continuous strip along the appropriate flange edge for short lengths not to exceed twelve inches may be used. When flange thickness exceeds 1-1/4 inches, both flange surfaces shall be heated concurrently.

Heating Procedure for Camber Adjustment

- Heating to increase or decrease camber may be done with the girder web in the vertical position at any time after the web to flange welds are completed.
- If the girder is to be heated with the web in a vertical position:
 - a. Support the girder at each end.
 - b. Supply a catch block to prevent too much downward vertical movement.
 - c. Secure the girder to prevent lateral movement.
- For minor camber adjustments, a strip along the outside surface of the flange where it intersects the web shall be heated at predetermined locations.
- V type heats shall be used to increase/decrease camber when the required correction exceeds 1/8 inch. V type heat patters shall have a base not exceeding ten inches in length and the tip shall not exceed 75% of the web depth.

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