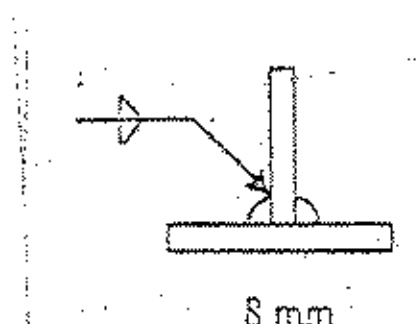
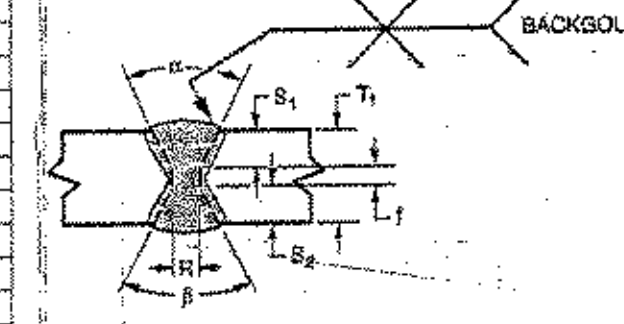
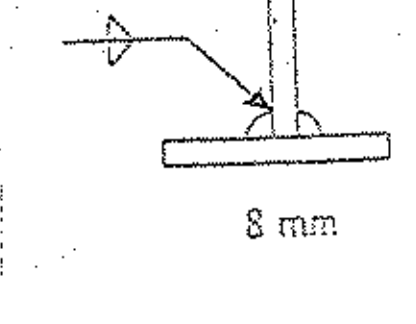


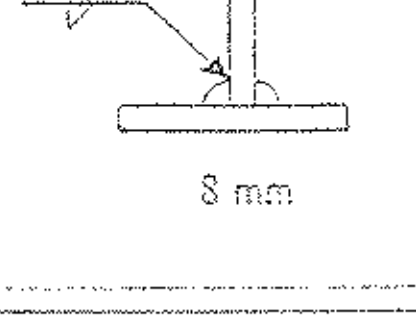
EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION FCM WELDS

WPS NUMBER:SAW PL#8-1				ISSUE DATE:5/9/03			
PROJECT:VT AOT NO.NH-010-2 (2)				EB JOB NO.:4015			
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				WPS QUALIFICATION:AWS D1.5 5.13			
PREHEAT AND INTERPASS TEMP.: AWS D1.5 TABLE 12.4				SUPPORTING PQR#:SAW A332-3 PL#8			
HEAT INPUT:50.88 - 73.92 KILOJOULES							
ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL AND AWS NUMBER		FILLET	
3/32"	398-440	28.8-31.5	11.25-13.5				
NOTES:							
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:							
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450F							
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, F ASTM A709 STEEL				
UP TO 3/4"			125F				
3/4" TO 1 1/2"			200F				
1 1/2" TO 2 1/2"			300F				
OVER 2 1/2"			350F				
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN APPLICABLE AWS CODES AND CONTRACT SPECIFICATIONS.							

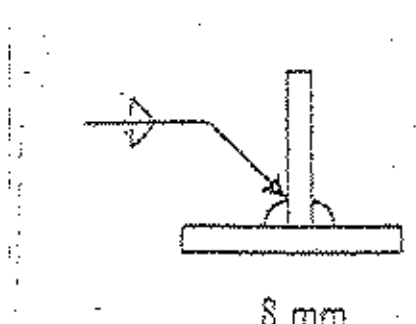
EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION FCM WELDS

WPS NUMBER:SAW PL#8-2				ISSUE DATE:5/9/03			
PROJECT:VT AOT NO.NH-010-2 (2)				EB JOB NO.:4015			
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:1G				WPS QUALIFICATION:AWS D1.5 5.13			
PREHEAT AND INTERPASS TEMP.: AWS D1.5 TABLE 12.4				SUPPORTING PQR#:SAW A332-3 PL#8			
HEAT INPUT:50.88 - 73.92 KILOJOULES							
ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL AND AWS NUMBER		FILLET	
3/32"	398-440	28.8-31.5	11.25-13.5				
NOTES:							
T1 = 102 MM							
R = 0 BACKGOUGE ROOT TO SOUND METAL BEFORE WELDING SECOND SIDE							
F = 6 MM - 12MM							
a-b = 60 degrees							
S1 = 70 MM							
S2 = 28MM							
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:							
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450F							
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, F ASTM A709 STEEL				
UP TO 3/4"			125F				
3/4" TO 1 1/2"			200F				
1 1/2" TO 2 1/2"			300F				
OVER 2 1/2"			350F				
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN APPLICABLE AWS CODES AND CONTRACT SPECIFICATIONS.							

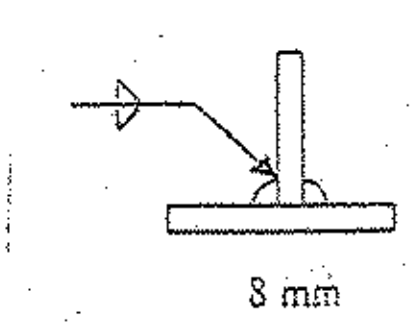
WPS NUMBER:SAW PL#8-3				ISSUE DATE:5/9/03			
PROJECT:VT AOT NO.NH-010-2 (2)				EB JOB NO.:4015			
BASE METAL:ASTM A709 GR36,50,50W				WELDING PROCESS:SUBMERGED ARC WELDING			
FILLER METAL SPEC.:AWS A5.13 LINCOLN LA75				FLUX / SHIELDING GAS:LINCOLN 960			
CURRENT AND POLARITY:DCEP				ELEC STICKOUT:1" +/- 1/4"			
WELDING POSITION:2F				WPS QUALIFICATION:AWS D1.5 5.13			
PREHEAT AND INTERPASS TEMP.: AWS D1.5 TABLE 4.4				SUPPORTING PQR#:SAW A332-3 PL#8			
HEAT INPUT:50.88 - 73.92 KILOJOULES							
ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL AND AWS NUMBER		FILLET	
3/32"	398-440	28.8-31.5	11.25-13.5				
NOTES:							
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:							
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450F							
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, F ASTM A709 STEEL				
UP TO 3/4"			50F				
3/4" TO 1 1/2"			70F				
1 1/2" TO 2 1/2"			150F				
OVER 2 1/2"			225F				
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN APPLICABLE AWS CODES AND CONTRACT SPECIFICATIONS.							

WPS NUMBER:FCAW PL#10-1				ISSUE DATE:5-9-03			
PROJECT:VT AOT NO.NH-010-2 (2)				EB JOB NO.:4015			
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				WPS QUALIFICATION:AWS D1.5 5.13			
PREHEAT AND INTERPASS TEMP.: AWS D1.5 TABLE 4.4				SUPPORTING PQR#:FCAW-SA116-1			
HEAT INPUT:35 - 44.2 KILOJOULES				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:							
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:							
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450F							
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, F ASTM A709 STEEL				
UP TO 3/4"			50F				
3/4" TO 1 1/2"			70F				
1 1/2" TO 2 1/2"			150F				
OVER 2 1/2"			225F				
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN APPLICABLE AWS CODES AND CONTRACT DOCUMENTS.							

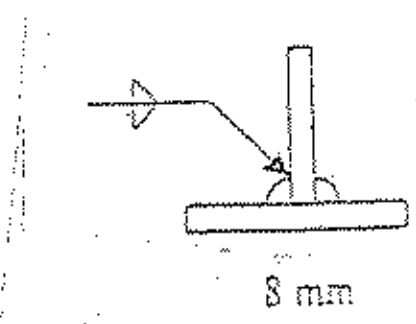
EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION
FCM WELDS

WPS NUMBER:SAW PL#11-1				ISSUE DATE: 5-9-03			
PROJECT: VT AOT NO. NH-010-2 (2)				EB JOB NO.: 4015			
BASE METAL:ASTM A709 GR36,50,50W				WELDING PROCESS:SUBMERGED ARC WELDING			
FILLER METAL SPEC.:AWS A5.23 LINCOLN LA75				FLUX / SHIELDING GAS:LINCOLN 960			
CURRENT AND POLARITY:DCEP				ELEC STICKOUT:1" +/- 1/4"			
WELDING POSITION:2F				WPS QUALIFICATION:AWS D1.5 5.13			
PREHEAT AND INTERPASS TEMP.: AWS D1.5 TABLE 12.4				SUPPORTING PQR#:SAW LA75H-3 PL#11			
HEAT INPUT:50.5 - 73.2 KILOJOULES							
ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL AND AWS NUMBER		FILLET	
3/32"	550-610	37-40	20-24.2				
NOTES:							
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:							
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450F							
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, F ASTM A709 STEEL				
UP TO 3/4"			125F				
3/4" TO 1 1/2"			200F				
1 1/2" TO 2 1/2"			300F				
OVER 2 1/2"			350F				
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN APPLICABLE AWS CODES AND CONTRACT SPECIFICATIONS.							

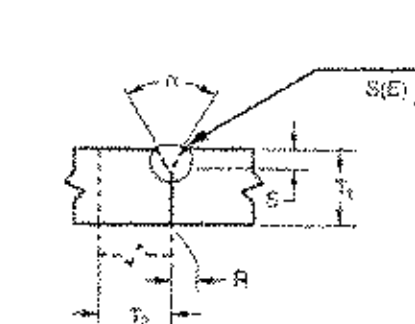
EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION

WPS NUMBER:SAW PL#00-02				ISSUE DATE:5/9/03			
PROJECT:VT AOT NO.NH-010-2 (2)				EB JOB NO.:4015			
BASE METAL:A709 GR36,50,50W				WELDING PROCESS:SAW			
FILLER METAL SPEC.:A5.1 E7018				FLUX / SHIELDING GAS:N/A			
CURRENT AND POLARITY:DCEP				ELEC STICKOUT:N/A			
WELDING POSITION:2F				WPS QUALIFICATION:PREQUALIFIED			
PREHEAT AND INTERPASS TEMP.:AWS D1.5 TABLE 4.4				SUPPORTING PQR#:N/A			
HEAT INPUT:38 - 130 KILOJOULES							
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"	180-250	23-26	3-4.5 IPM				
NOTES:							
SINGLE PASS FILLET WELDS							
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:							
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450F							
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, F ASTM A709 STEEL				
UP TO 3/4"			50F				
3/4" TO 1 1/2"			70F				
1 1/2" TO 2 1/2"			150F				
OVER 2 1/2"			225F				
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
FCM WELDS

WPS NUMBER:SAW PL#00-03				ISSUE DATE:5/9/03			
PROJECT:VT AOT NO.NH-010-2 (2)				EB JOB NO.:4015			
BASE METAL:A709 GR36,50,50W				WELDING PROCESS:SAW			
FILLER METAL SPEC.:A5.1 E7018				FLUX / SHIELDING GAS:N/A			
CURRENT AND POLARITY:DCEP				ELEC STICKOUT:N/A			
WELDING POSITION:2F				WPS QUALIFICATION:PREQUALIFIED			
PREHEAT AND INTERPASS TEMP.:AWS D1.5 TABLE 12.4				SUPPORTING PQR#:N/A			
HEAT INPUT:38 - 130 KILOJOULES							
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"	180-250	23-26	3-4.5 IPM				
NOTES:							
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:							
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450F							
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, F ASTM A709 STEEL				
UP TO 3/4"			125F				
3/4" TO 1 1/2"			200F				
1 1/2" TO 2 1/2"			300F				
OVER 2 1/2"			350F				
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#00-12				ISSUE DATE:6/29/03			
PROJECT:VT AOT NO.NH-010-2 (2)				EB JOB NO.:4015			
BASE METAL:A709 GR36,50,50W				WELDING PROCESS:SAW			
FILLER METAL SPEC.:A5.1 E7018				FLUX / SHIELDING GAS:N/A			
CURRENT AND POLARITY:DCEP				ELEC STICKOUT:N/A			
WELDING POSITION:1G				WPS QUALIFICATION:PREQUALIFIED			
PREHEAT AND INTERPASS TEMP.:AWS D1.5 TABLE 4.4				SUPPORTING PQR#:N/A			
HEAT INPUT:38 - 130 KILOJOULES							
ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL AND AWS NUMBER		FILLET C-P2	
1/8"	125-150	23-26	3-4.5 IPM				
5/32"	140-190	23-26	3-4.5 IPM				
3/16"	180-250	23-26	3-4.5 IPM				
NOTES:							
T1=1/2"							
T2=1/2"							
R=0							
f=1/4"							
a=60 Degrees							
MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:							
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450F							
THICKNESS OF THICKEST PART AT POINT OF WELDING			TEMPERATURE, F ASTM A709 STEEL				
UP TO 3/4"			50F				
3/4" TO 1 1/2"			70F				
1 1/2" TO 2 1/2"			150F				
OVER 2 1/2"			225F				
THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN APPLICABLE AWS CODES AND CONTRACT DOCUMENTS.							

STEEL-ART, INCORPORATED
40 WEST MAIN STREET
GALETON, PA 16922
(814) 435-6997



EASTERN BRIDGE LLC
RURAL RTE 2, BOX 302
CLAREMONT, NH 03743
608-542-5202

NO.	DATE	DESCRIPTION
1	6-24-03	PER APPROVAL
2	8/4/03	Approval

STATE OF VERMONT
AGENCY OF TRANSPORTATION
CONTRACT: _____
PROPOSED IMPROVEMENT TO RR BRIDGE #6
OVER VT ROUTE 9 (PRINCIPAL ARTERIAL)
WINDHAM COUNTY, TOWN OF BRATTLEBORO
TITLE: _____

WELD PROCEDURES
DRAWN BY: RX
CHKD BY: JH
SHOP ORDER: 4015
BLOCK NO.: _____
DWC NO.: WPS
SHEET NO.: WPS1