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MAY 18 2006
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**HEAT CURVING AND SWEEP CORRECTION PROCEDURE
STRIP HEAT METHOD**

1. Support girder, with web in horizontal position, at girder ends and at intermediate points as necessary to produce a uniform curvature in the member.
2. Intermediate safety catch blocks shall be maintained at mid distance between supports of the member and not more than 2" below the flanges at all times.
3. Heating shall be performed using large (1") rosebud style MAPP gas heating torches. Heating shall be confined to areas described in Step 4 and shall be performed so as to bring the steel in these areas to a temperature between 1,000 F and 1,150 F as rapidly as possible without overheating the steel.
4. Heat shall be applied to those edges of the girder flanges, which shall be on the concave side after completion.
5. Heating shall be done beginning at the center of the girder and working out to either end. Care shall be taken to heat both top and bottom flange edges at the same time.
6. If heating torches are mounted on an automatic Bug-O type carriage; the torch head proximity and travel speed shall be set to achieve 1,000 F as measured on the flange edge at a distance of 6" behind the torch head. The steel temperature shall be checked frequently to see that the temperature achieves 1,000 F and does not exceed 1,150 F.
7. If heating is done manually, care shall be taken to ensure that the heating is done in a consistent manner to achieve predictable results. The torch operators shall monitor the steel temperature frequently to see that the temperature reaches 1000 F and does not exceed 1,150 F. The rate of progression along the flange edge shall likewise be carefully controlled.
8. Edge heats may be done continuously or intermittently, depending on the amount of final horizontal curvature required. If heats are done intermittently, the individual heats shall be allowed to cool below 200F before beginning the next heating cycle.
9. The heated areas shall be allowed to cool to below 600 F in ambient conditions. After which time, the areas may be cooled in an accelerated manner using dry, compressed air.
10. The intermediate safety catch blocks under the girder shall be monitored to maintain a space of no more than 2" during the heating process. It will be necessary to substitute different thickness catch blocks to maintain this space as the girder begins to contract and move.
11. The member being heated shall not be moved until the steel has reached ambient temperature.
12. The QA representative for the state shall be notified prior to implementation of this procedure.

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