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MAY 18 2006
RESUBMIT _____ APPROVED ✓
BY _____ DATE 6-2-06
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**HEAT CAMBERING AND
CORRECTIVE HEAT CAMBERING PROCEDURE**

1. Support girder, with web in vertical 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. The beam being cambered shall be supported or braced to prevent deflection laterally and overturning during the heating process.
4. Heating shall be performed using a properly sized rosebud style heating tip. Heating shall be confined to areas described in Step 5 and shall be performed so as to bring the steel in these areas to a temperature not exceeding 1,150F as rapidly as possible without overheating the steel.
5. Heating patterns shall be marked on the girders prior to heating. Heat patterns will be located at even distances in a quantity sufficient to produce the desired camber. Whenever possible heating patterns shall be centered on stiffener locations. Additional blank stiffeners may be required at panel midpoints to provide sufficient heating sites in an effort to prevent or reduce web distortion. Patterns shall be truncated triangles with the base of the triangle being that flange which shall be concave in the finished girder. The apex of the triangle shall be located in the web at a point not less than 75% of the depth of the beam from the base of the triangle. The total included angle of the triangle shall not exceed 20 degrees and the base of the triangle shall not exceed 10".
6. Heating shall begin at the apex of the triangle and not proceed toward the base until the truncated area is brought up to a temperature not exceeding 1,150F. Once heating begins to progress towards the base of the triangle it shall not return to the apex. The torch operator shall have 1,000 F, 1,100 F, and 1,150 F temperature indicating crayons. The steel surface temperature shall be monitored frequently during the heating process.
7. No weight shall be applied without prior approval of the state.
8. After application of heating patterns the member being cambered shall stay in the vertical position until the heated areas cool to below 200F, to check and record results.
9. The heated areas shall be allowed to cool to below 600F in ambient conditions. After which time, the areas may be cooled in an accelerated manner using dry, compressed air.
10. The QA representative for the state shall be notified prior to implementation of this procedure.

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