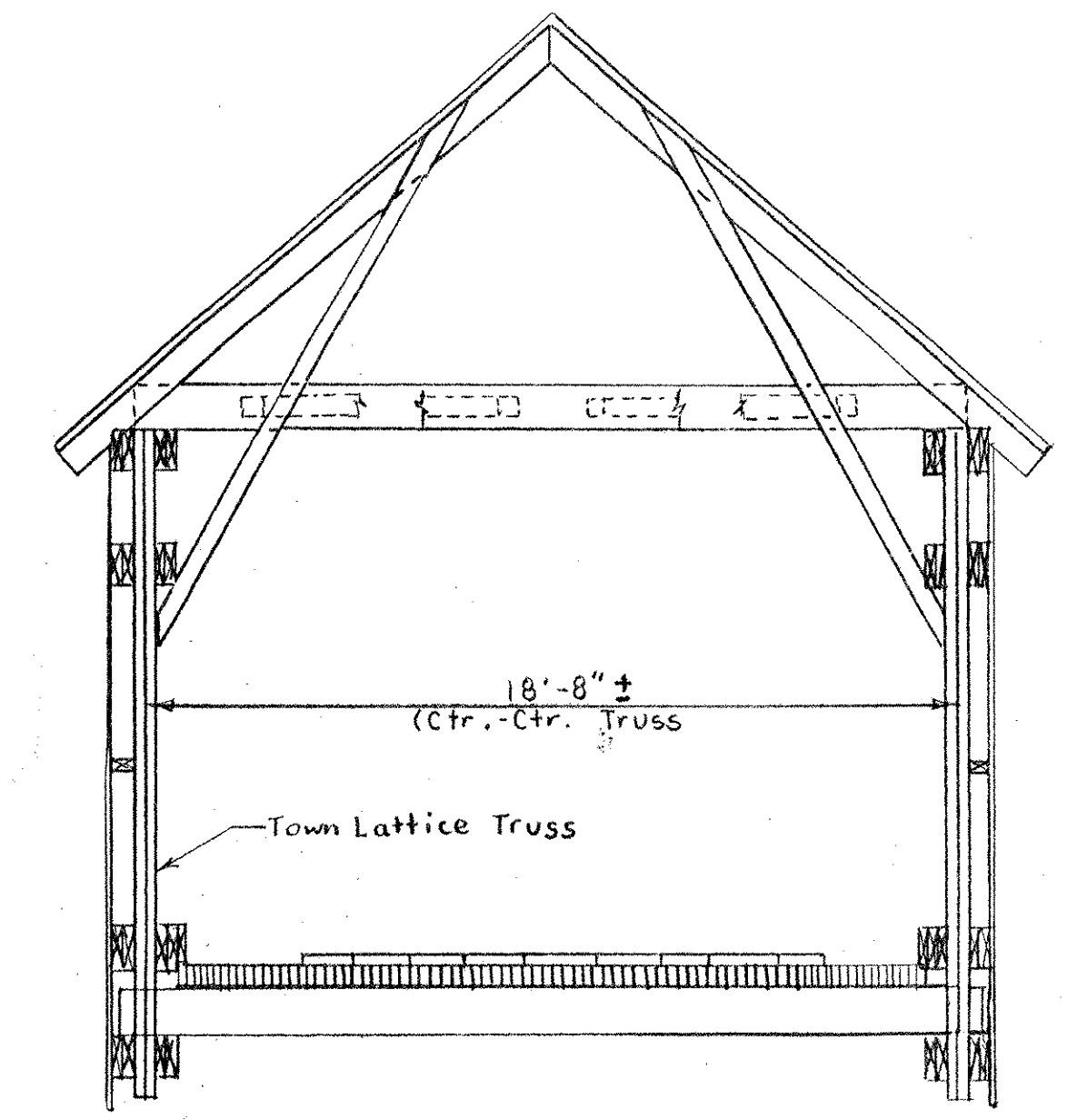


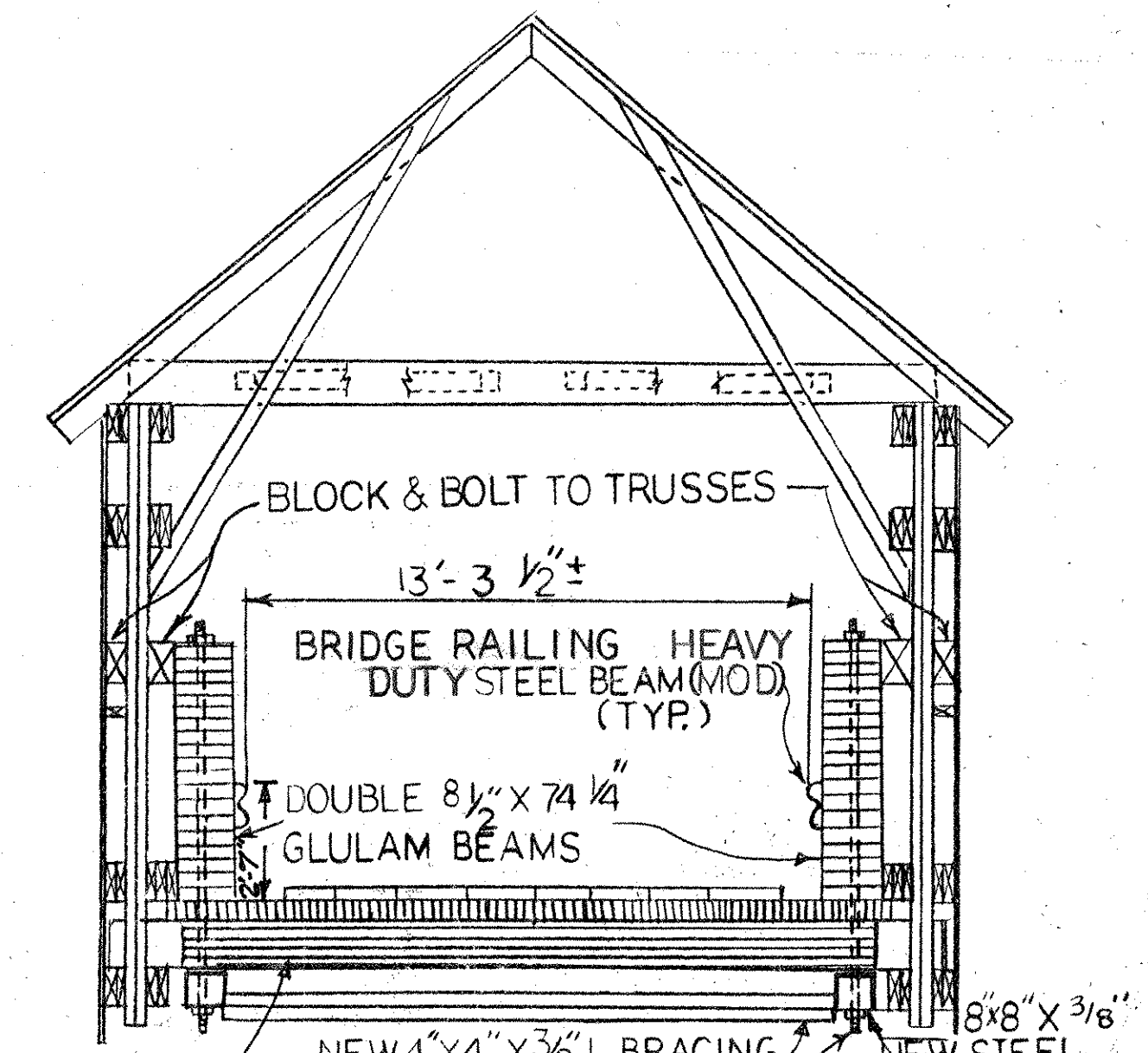
BRIDGE QUANTITY SHEET

STATE OF VERMONT
AGENCY OF TRANSPORTATION
STRUCTURES DIVISION

NO.	ITEM	UNIT	QUANTITY BREAKDOWN										TOTAL	FINAL	
			RDWY.		SUPER STRUC.		EROS. CONT.								
204.20	TRENCH EXCAVATION OF EARTH	C.Y.					1								
301.15	SUBBASE OF GRAVEL	C.Y.	30												30
406.27	MEDIUM DUTY BITUM. CONCR. PVMT	TON	14												14
502.10	SHORING SUPERSTRUCTURE	L.S.			1										1
506.60	STRUCTURAL STEEL	LBS.			16,900										16,900
522.20	STRUCTURAL LUMBER & TIMBER-UNTREATED	MFBM			2										2
522.30	NON-STRUCTURAL LUMBER-UNTREATED	MFBM			1										1
522.40	STRUCTURAL GLUED LAMINATED TIMBER (TREATED)	LS			1										1
525.41	BRIDGE RAILING-HDS BZ FASCIA MOUNTED (MOD)	LF			240										240
529.20	PARTIAL REMOVAL OF STRUCTURE	EA.			1										1
608.25	ALL PURPOSE EXCAVATOR RENTAL TYPE 1	HR.						1							1
608.37	TRUCK RENTAL	HR.	1												1
613.10	STONE FILL, TYPE 1	C.Y.						1							1
621.75	REMOVING AND RESETTNG GUARDRAIL	LF	95												95
635.10	MOBILIZATION	LS.	1												1
649.51	GEOTEXTILE FOR SILT FENCE	SY.						10							10
651.15	SEED	LB.						10							10
651.18	FERTILIZER	LB.						50							50
651.20	AGRICULTURAL LIMESTONE	TON						1							1
651.25	HAY MULCH	TON						1							1
651.35	TOP SOIL	CY.						5							5
654.10	ERROSION MATTING	SY						10							10
675.20	TRAFFIC SIGN TYPE A	SF.	30												30
675.30	FLANGED CHANNEL SIGN POSTS	LB.	150												150



EXISTING CROSS SECTION
1/4" = 1'-0"



NEW 10 1/2" x 16 1/2" GLULAM FLOOR BEAMS

NEW CROSS SECTION
1/4" = 1'-0"

**STATE OF VERMONT
AGENCY OF TRANSPORTATION**

Town Of NEWFANE Bridge No. 17
Highway No. TH 2 CL. 2 Log Sta. Surv. Sta.

QUANTITY SHEET

Designed By J.WEAVER Drawn By S.FUGERE
Checked By J.WEAVER Date 6-30-98 Bridge Design Supervisor J.WEAVER Date 6-30-98

PROJECT NEWFANE PROJECT NO. BHF 0106 (4) S

I.G.C. Info. Bridge Sheet No. Sheet 2 of 8 orig.

GENERAL NOTES

1. ALL MATERIALS AND CONSTRUCTION SHALL CONFORM TO STATE OF VERMONT AGENCY OF TRANSPORTATION STANDARD SPECIFICATIONS FOR CONSTRUCTION ADOPTED 1990, AND ITS LATEST REVISIONS AND THE AASHTO STANDARD SPECIFICATIONS FOR HIGHWAY BRIDGES, 16TH EDITION, DATED 1996, AND ITS LATEST REVISIONS.
2. DESIGN OF THE REHABILITATED STRUCTURE IS FOR AASHTO H20-44 LANE LOAD OR TRUCK LOAD.
3. ALL DIMENSIONS SHOWN ON THE PLANS SHALL BE CHECKED IN THE FIELD PRIOR TO COMMENCING THE WORK. ACTUAL WORK SHALL MATCH FIELD CONDITIONS.
4. ALL NEW SAWN STRUCTURAL LUMBER AND TIMBER OR NON-STRUCTURAL LUMBER SHALL BE SPRUCE-PINE-FIR NO. 1 OR NO.2, FULL SAWN, EXCEPT AS NOTED, AND UNTREATED.
5. NEW STRUCTURAL GLUED LAMINATED MEMBERS SHALL BE AS FOLLOWS:
 FLOOR BEAMS: SOUTHERN PINE 16F-V1 SP/SP.
 MAIN BEAMS: SOUTHERN PINE 22F-V3 SP/SP.
 TREATMENT SHALL COMPLY WITH STANDARD SPECIFICATION 726.01, TYPE II, IF TREATED AFTER GLUING, OR STANDARD SPECIFICATION 726.01, TYPE III, IF TREATED PRIOR TO GLUING.
6. ITEM 529.20 'PARTIAL REMOVAL OF STRUCTURE' SHALL INCLUDE BUT NOT BE LIMITED TO REMOVING LATERAL BRACING, TIE RODS AND SIDING (WHERE REQUIRED). PAYMENT FOR ITEM 529.20 TO INCLUDE SALVAGE AND REUSE OF SIDING; THAT IS, PUTTING SIDING BACK IN PLACE. PAYMENT SHALL ALSO INCLUDE ALL LABOR, EQUIPMENT AND INCIDENTALS NECESSARY TO DRILL ONE AND ONE QUARTER INCH DIAMETER HOLES IN THE WOODEN DECK IN ORDER TO ACCOMMODATE THE ONE INCH DIAMETER VERTICAL SUPPORT RODS FROM THE MAIN CARRYING BEAMS, AND TO DRILL ALL HOLES REQUIRED FOR THE NEW FLOOR BEAM LAG SCREWS.
7. BRIDGE NO. 17 SHALL BE CLOSED TO ALL PEDESTRIAN AND VEHICULAR TRAFFIC DURING CONSTRUCTION. THE CONTRACTOR SHALL BE RESPONSIBLE FOR ALL ON-PROJECT SITE SIGNS AND BARRICADES (REQUIRED BY THE TOWN) TO CONTROL TRAFFIC DURING CONSTRUCTION. ALL COSTS OF MATERIALS AND WORK (INSTALL, MAINTAIN AND REMOVE) ASSOCIATED WITH CONSTRUCTION SIGNING AND BARRICADES SHALL BE PAID FOR SUBSIDIARY TO ITEM 635.10, 'MOBILIZATION'. THE TOWN SHALL BE RESPONSIBLE FOR ALL OFF-SITE DETOUR SIGNING.
8. ALL NEW BOLTS, ONE INCH DIAMETER RODS AND LAG SCREWS SHALL CONFORM TO ASTM SPECIFICATION A 307 AND SHALL BE GALVANIZED PER AASHTO SPECIFICATION M 232. THE ONE INCH DIAMETER RODS SHALL BE PAID FOR AS STRUCTURAL STEEL. ALL OTHER HARDWARE SHALL BE PAID SUBSIDIARY TO THE ITEMS TO WHICH IT IS ATTACHED.
9. OTHER STRUCTURAL STEEL ITEMS INCLUDE THE EIGHT INCH BY EIGHT INCH STEEL TUBING, CONFORMING TO ASTM SPECIFICATION A 500, GRADE A; THE FOUR INCH BY FOUR INCH BRACING ANGLES, AND NUMEROUS STRUCTURAL STEEL PLATES, CONFORMING TO AASHTO SPECIFICATION M 183M/ M 183. ALL STRUCTURAL STEEL SHAPES AND PLATES SHALL BE GALVANIZED PER AASHTO SPECIFICATION M 111.
10. BEFORE SHORING THE SUPERSTRUCTURE AT MID SPAN TO WITHSTAND CONSTRUCTION LIVE LOADS, THE CONTRACTOR SHALL SUBMIT SHORING PLANS TO THE STRUCTURES ENGINEER AT VAOT FOR APPROVAL.
11. THE MAIN CARRYING BEAMS (74 1/4" DEEP) SHALL BE FABRICATED WITH A TWO AND THREE QUARTER INCH CAMBER AT MID SPAN.

SEQUENCE OF CONSTRUCTION

1. REMOVE 'X' BRACING AND TIE RODS AT MID SPAN. INSTALL TEMPORARY SHORING AT MID SPAN AND ANY TEMPORARY WORK SCAFFOLDING.
2. REMOVE REMAINDER OF WOOD 'X' BRACING AND TIE RODS UNDER THE BRIDGE, EXCEPT THE TIE RODS AT THE END FLOOR BEAMS.
3. DRILL HOLES IN DECK AS REQUIRED. INSTALL MAIN CARRYING BEAMS AND ONE INCH DIAMETER HANGER RODS. BOLT MAIN BEAMS TOGETHER IN PAIRS. BRACING AT MID SPAN AND AT ENDS OF BEAMS SHALL BE BETWEEN MAIN CARRYING BEAMS, AS SHOWN ON THE PLANS. TEMPORARY BRACING MATERIALS AND WORK (INSTALL AND REMOVE) SHALL BE PAID SUBSIDIARY TO ITEM 502.10 'SHORING SUPERSTRUCTURE'.
4. INSTALL NEW STEEL TUBING AND NEW GLULAM FLOOR BEAMS. INSTALL NEW STEEL 'X' BRACING.
5. PULL TRUSS SUPERSTRUCTURE UP INTO PLACE BY TENSIONING THE ONE INCH DIAMETER VERTICAL HANGER RODS. PULL UP UNTIL THE TRUSSES ATTAIN A STRAIGHT TANGENT GRADE LINE.
6. BLOCK AND BOLT TOP FLANGES OF MAIN GLULAM BEAMS TO TRUSSES AT REMAINDER OF LATERAL SUPPORT CONNECTIONS. REMOVE TEMPORARY LATERAL SUPPORT CONNECTIONS AT MID SPAN AND ENDS AND BLOCK TOP FLANGES TO THE TRUSSES AT THESE LOCATIONS.
7. REMOVE TEMPORARY SHORING, INSTALL RAILING, COMPLETE PROJECT APPROACH WORK.

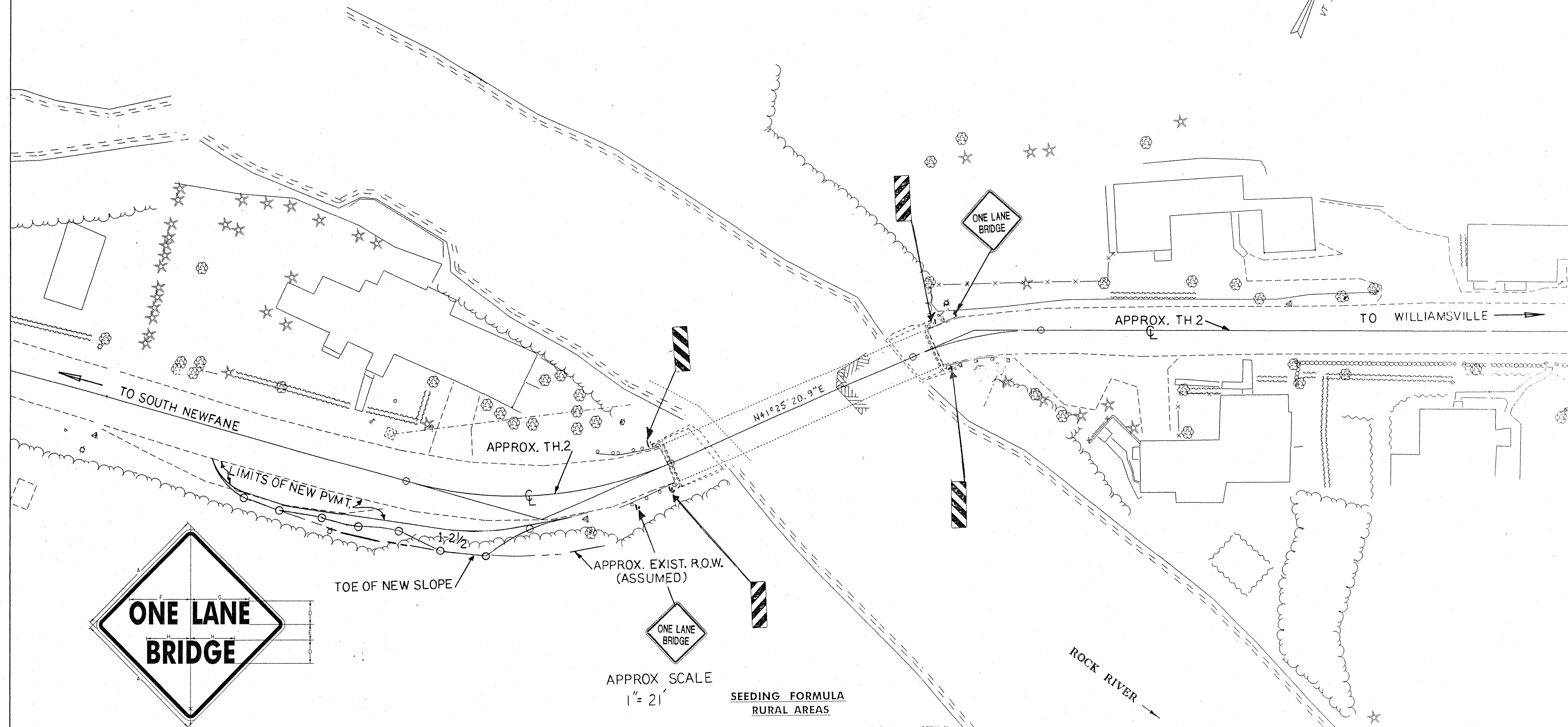
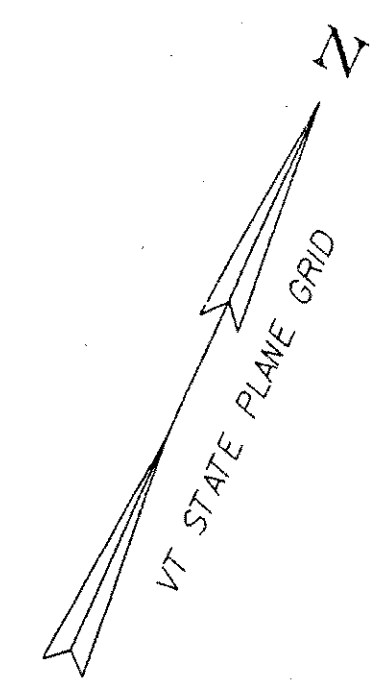
STATE OF VERMONT AGENCY OF TRANSPORTATION			
Town Of	NEWFANE	Bridge No.	17
Highway No.	TH 2, CL. 2	Log Sta.	
		Surv. Sta.	
GENERAL NOTES SHEET			
Designed By	J. WEAVER	Drawn By	S. FUGERE
Checked By	J. WEAVER	Date	6-30-98
		Bridge Design Supervisor	J. WEAVER Date 6-30-98
PROJECT	NEWFANE	PROJECT NO.	BHF 0106 (4)S
I.G.C. Info.			
Bridge Sheet No.		Sheet	3 of 8

REMOVE AND RESET GUARDRAIL

EAST APPROACH LT. 28'
 EAST APPROACH RT. 15'
 WEST APPROACH LT. 26'
 WEST APPROACH RT. 26'

SIGNS, FLANGED SIGN POST

EAST RT. ONE LANE BRIDGE SIGN
 EAST RT. OBJECT MARKER SIGN
 EAST LT. OBJECT MARKER SIGN
 WEST LT. ONE LANE BRIDGE SIGN
 WEST RT. OBJECT MARKER SIGN
 WEST LT. OBJECT MARKER SIGN



SIGN	DIMENSIONS (INCHES)									
	A	B	C	D	E	F	G	H	I	J
MIN.	30	1/2	3/4	5C	3/4	13 5/16	12 1/16	9 1/8	1 1/8	
STD.	36	5/8	7/8	6C	4	16	15 1/4	11 1/2	2 1/4	
SPECIAL	48	3/4	1 1/4	8C	5	21 1/4	20 1/4	15 3/8	3	

COLORS
 LEGEND-BLACK (NON - REFL)
 BACKGROUND - YELLOW (REFL)

DATUM	
VERTICAL	NAVD88
HORIZONTAL	NAD83 (92)

APPROX SCALE
 1" = 21'

**SEEDING FORMULA
 RURAL AREAS**

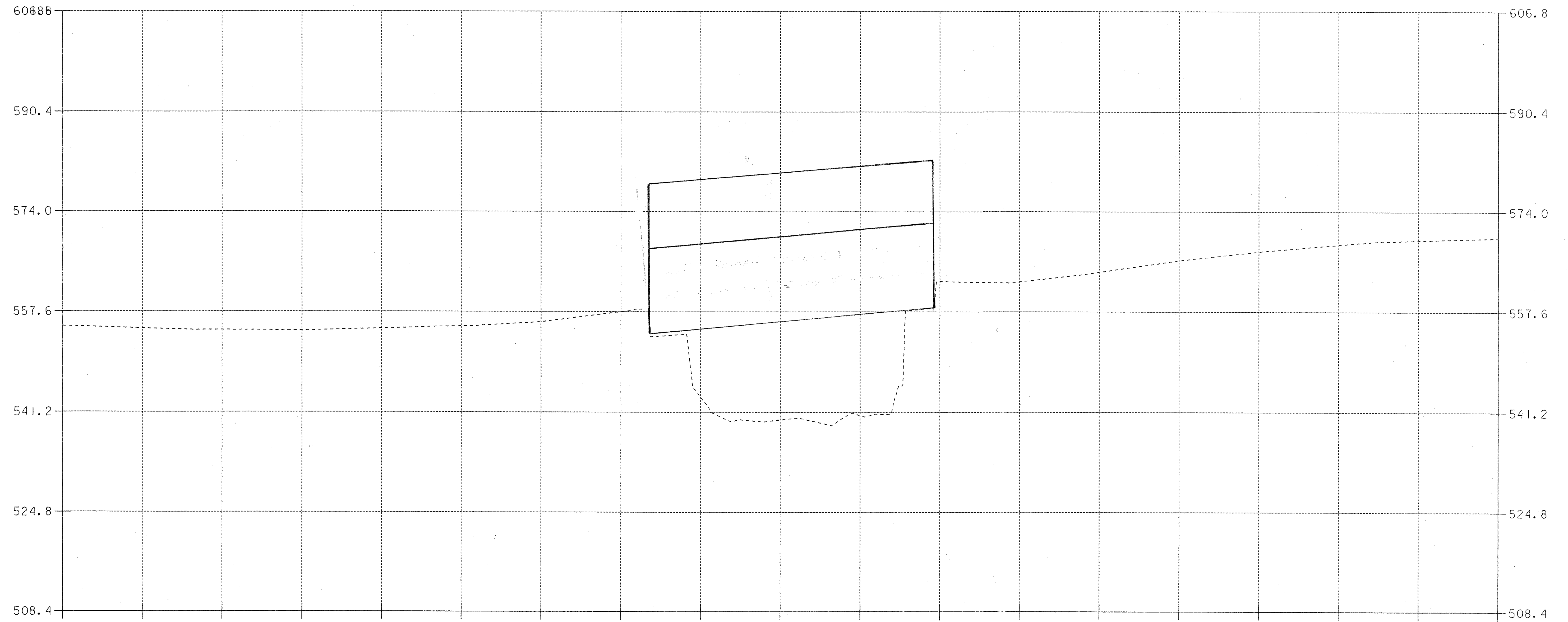
% WT.	LBS./A.	NAME	PUR %	GERM %
37.5	22.5	CREeping RED FESCUE	98	85
37.5	22.5	TALL FESCUE	95	90
5.0	3.0	RED TOP	95	90
15.0	9.0	BIRDSFOOT TREFoil	98	85
5.0	3.0	ANNUAL RYEGRASS	95	85
100.0	60.0			

GENERAL NOTES

SEED MIXTURE: SHALL NOT HAVE A WEED CONTENT EXCEEDING 0.40% BY WEIGHT AND SHALL BE FREE OF ALL NOXIOUS SEED.
 SEED: TO BE APPLIED PER SEEDING FORMULAS OR AS DIRECTED BY THE ENGINEER.
 FERTILIZER: FORMULA 10-20-10, TO BE USED WITH SEED, APPLIED AT THE RATE OF 500 LBS./ACRE. (HYDRO SEEDERS MAY USE 19-19-19 FORMULA).
 AGRICULTURAL LIMESTONE: TO BE APPLIED AT THE RATE OF 2 TONS/ACRE, OR AS DIRECTED BY THE ENGINEER.
 HAY MULCH: TO BE PLACED ON EARTH SLOPES AT THE RATE OF 2 TONS/ACRE, OR AS DIRECTED BY THE ENGINEER.
 TOPSOIL: TO BE USED WITH SEED AS INDICATED ON THE PLANS, OR AS DIRECTED BY THE ENGINEER.

PROJECT: NEWFANE	PROJECT NO.: BHF 0106 (4)S
DESIGN FILE NAME: c:\USERS\STR3\96J230\sj230bdr.dgn	PLOT DATE: 30-JUN-1998
IPARM FILE NAME: sj230102.1	SURVEY DATE: APRIL 1998
SURVEYED BY: R.D. GILMAN	DRAWN BY:
SQUAD LEADER:	SHEET: 4 OF 8

Profile Along TH 2 Centerline

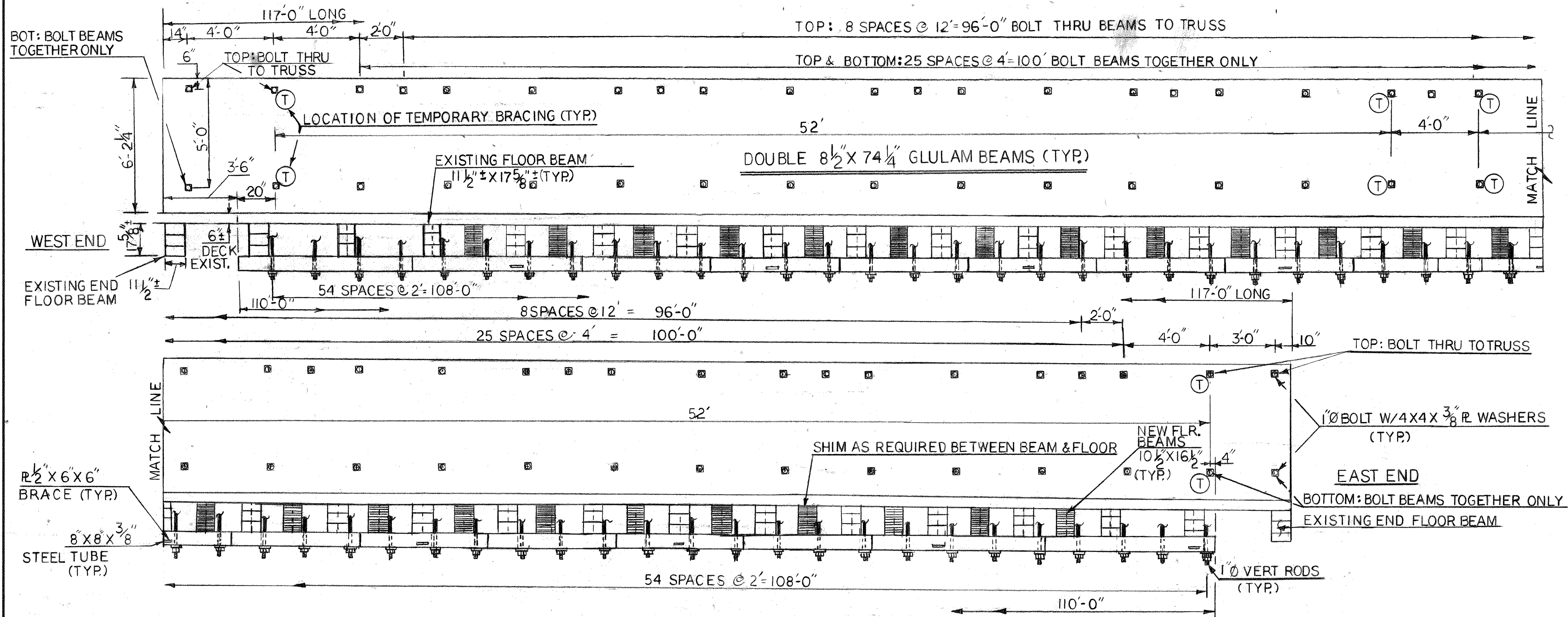


APPROX. SCALE 1" = 21' HORIZ.
1" = 8.5' VERT.

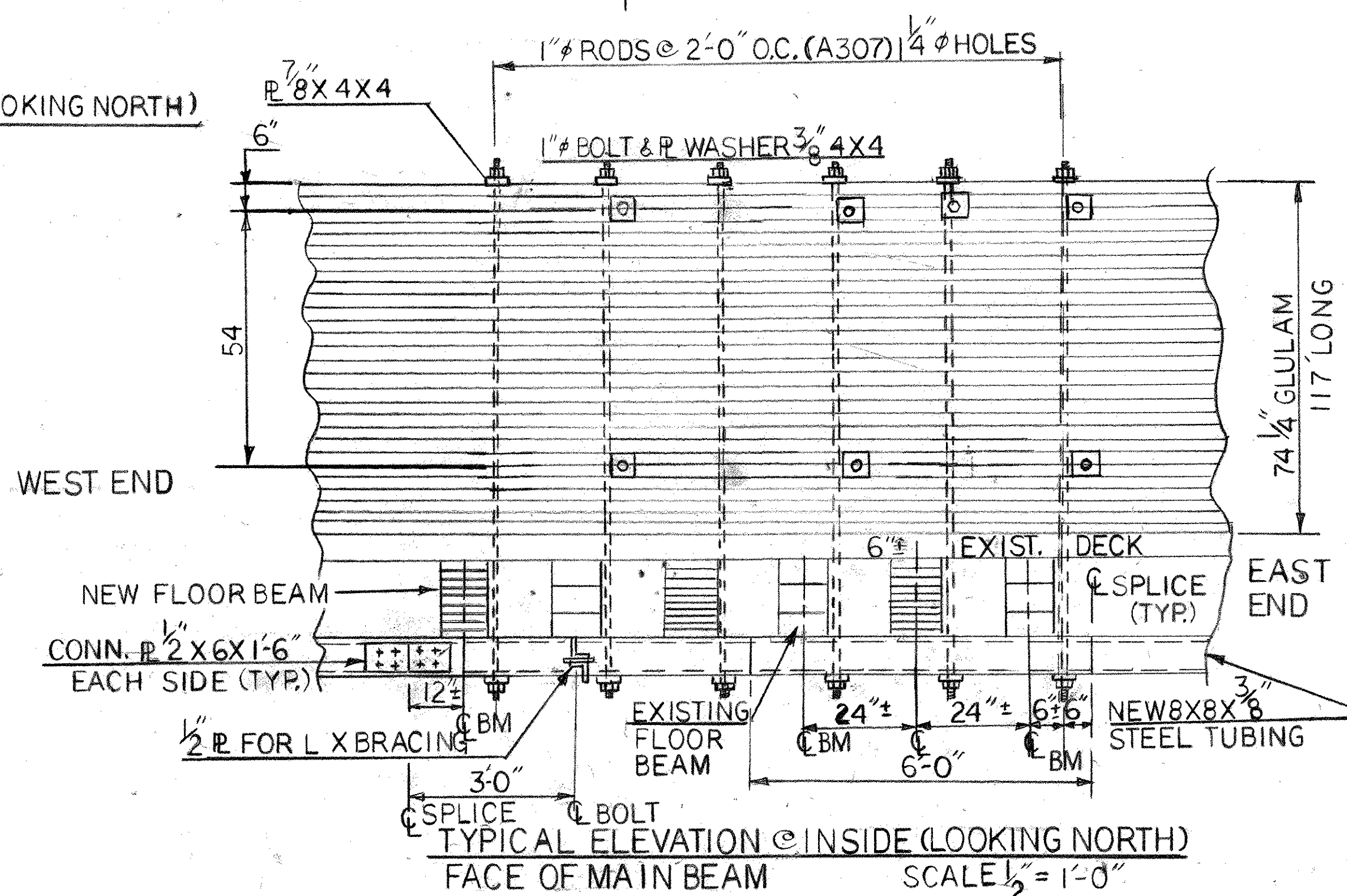
DATUM	
VERTICAL	NAVD88
HORIZONTAL	NAD83 (92)

PROJECT: NEWFANE	PROJECT NO.: BHF 0106 (4)S
DESIGN FILE NAME: c:\users\str3\sj230xsl.dgn	PLOT DATE: 30-JUN-1998
IPARM FILE NAME: sj230pf2.1	SURVEY DATE: APRIL 1998
SURVEYED BY: R.D. GILMAN	DRAWN BY:
SQUAD LEADER:	SHEET: 5 OF 8
PROFILE SHEET TWO	

orig

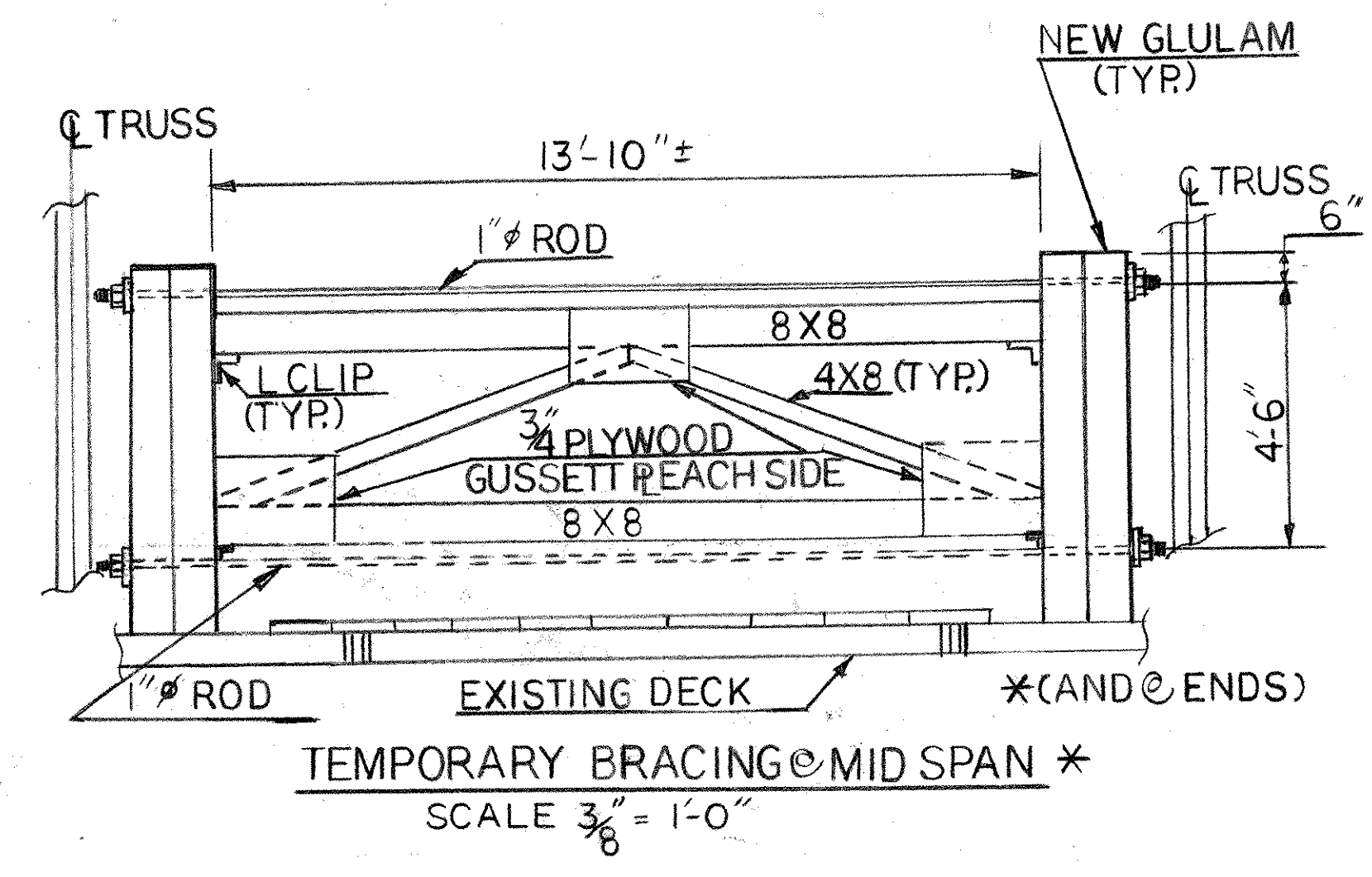
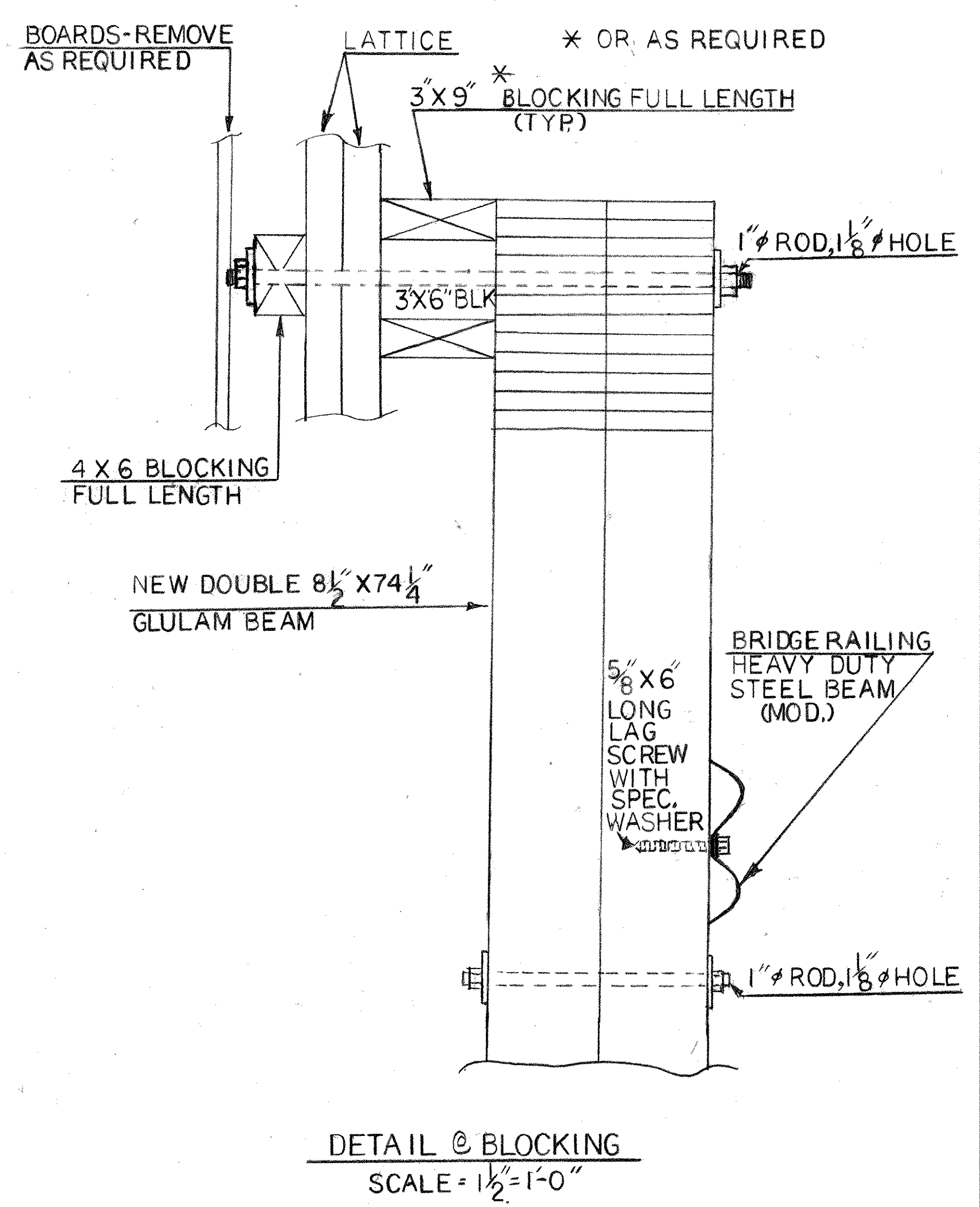
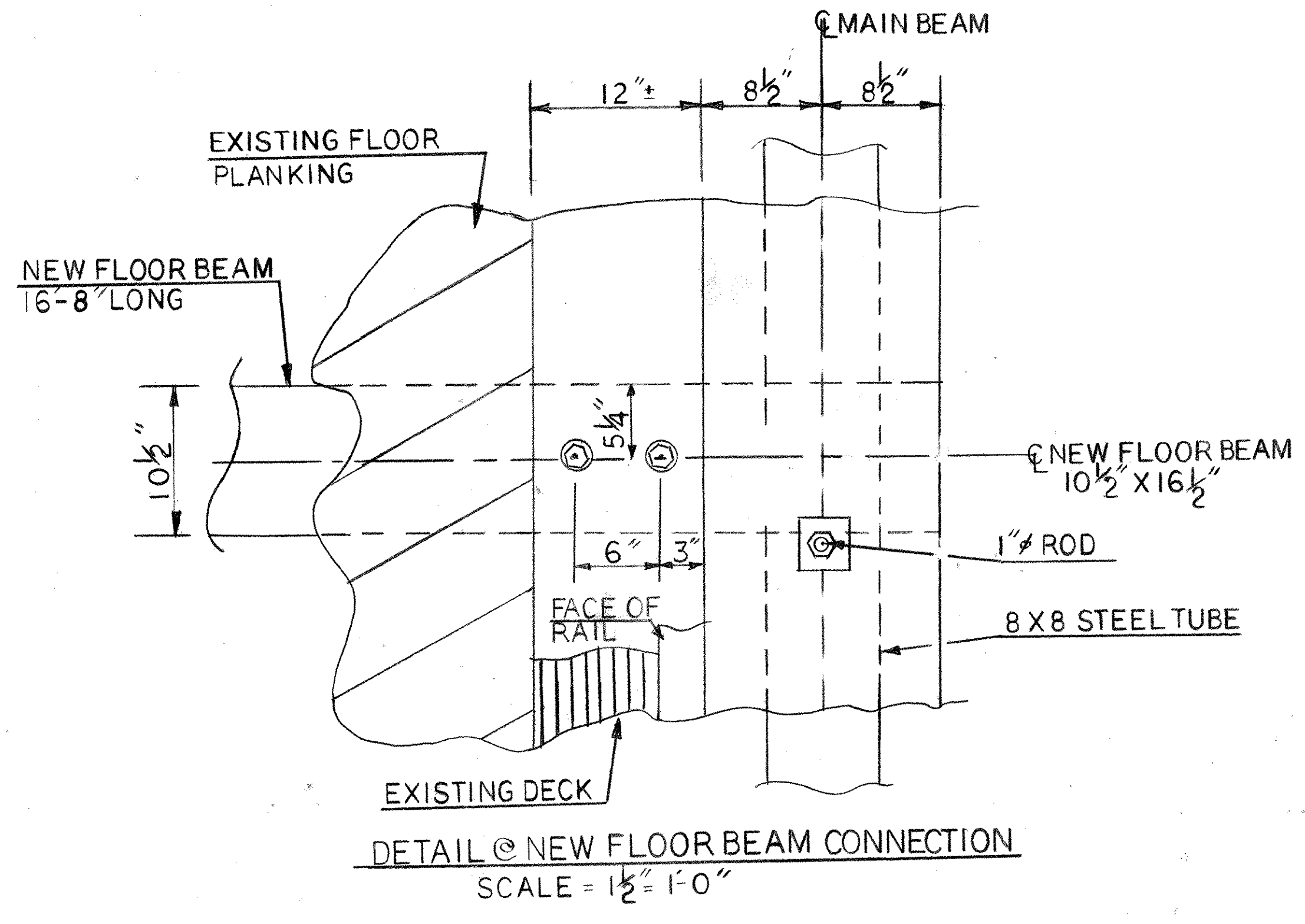
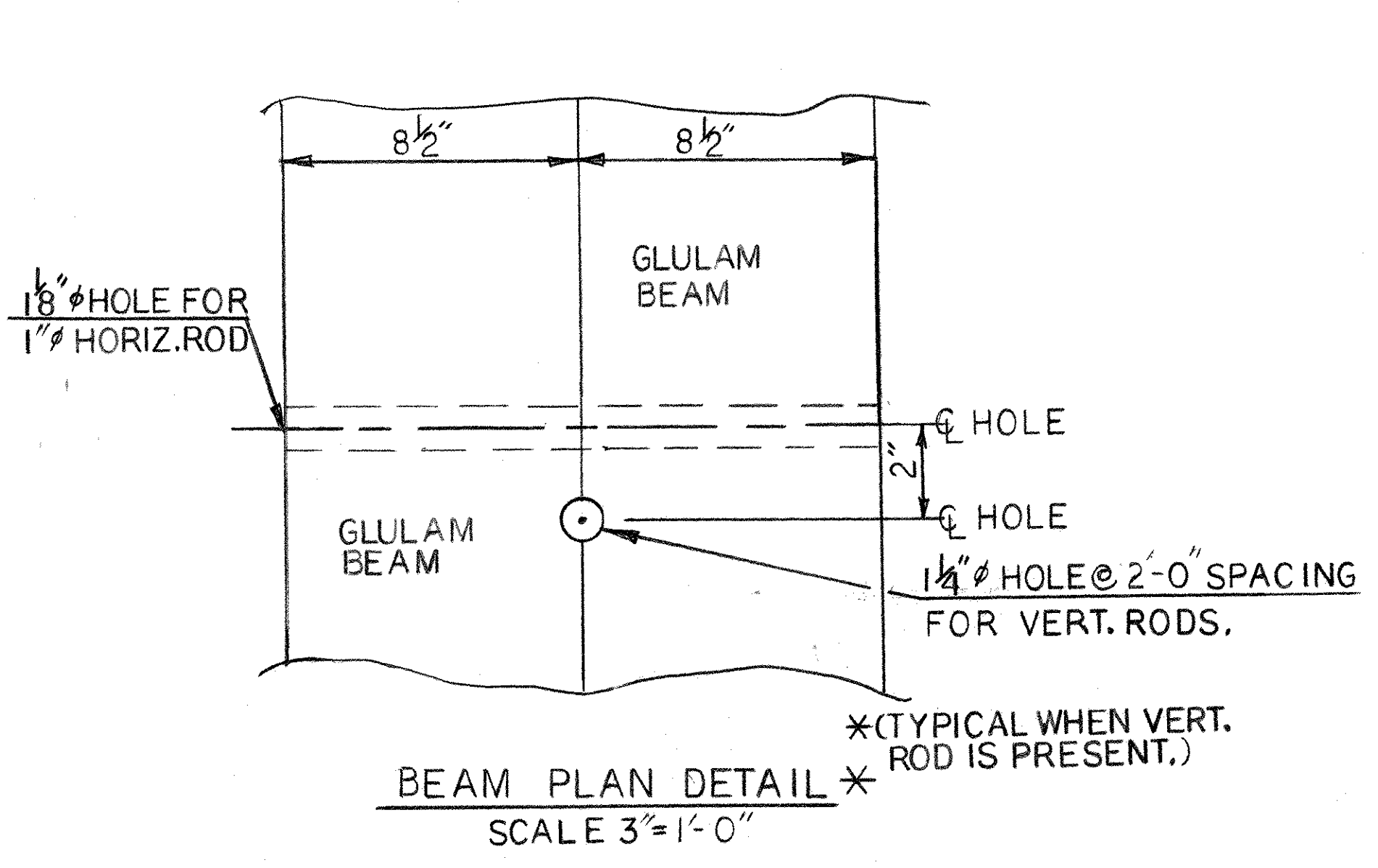


ELEVATION @ INSIDE FACE OF MAIN BEAM (LOOKING NORTH)
SCALE 3/8" = 1'-0"



TYPICAL ELEVATION @ INSIDE (LOOKING NORTH)
FACE OF MAIN BEAM SCALE 1/2" = 1'-0"

STATE OF VERMONT AGENCY OF TRANSPORTATION	
Town Of NEWFANE	Bridge No. 17
Highway No. TH 2, CL. 2	Log Sta. Surv. Sta.
BEAM ELEVATION	
Designed By J. WEAVER	Drawn By S. FUGERE
Checked By J. WEAVER Date 7-16-98	Bridge Design Supervisor J. WEAVER Date 7-20-98
PROJECT NEWFANE	PROJECT NO. BHF 0106 (4) S
I.G.C. Info.	
Bridge Sheet No.	Sheet 7 of 8



STATE OF VERMONT AGENCY OF TRANSPORTATION			
Town Of	NEWFANE	Bridge No.	17
Highway No.	TH 2, CL, 2	Log Sta.	
		Surv. Sta.	
MISC. DETAILS			
Designed By	J. WEAVER	Drawn By	S. FUGERE
Checked By	J. WEAVER	Bridge Design Supervisor	J. WEAVER
Date	7-24-98	Date	7-24-98
PROJECT	NEWFANE	PROJECT NO.	BHF 0106(4)S
I.G.C. Info.			
Bridge Sheet No.		Sheet	8 of 8

PART & MATERIAL LIST

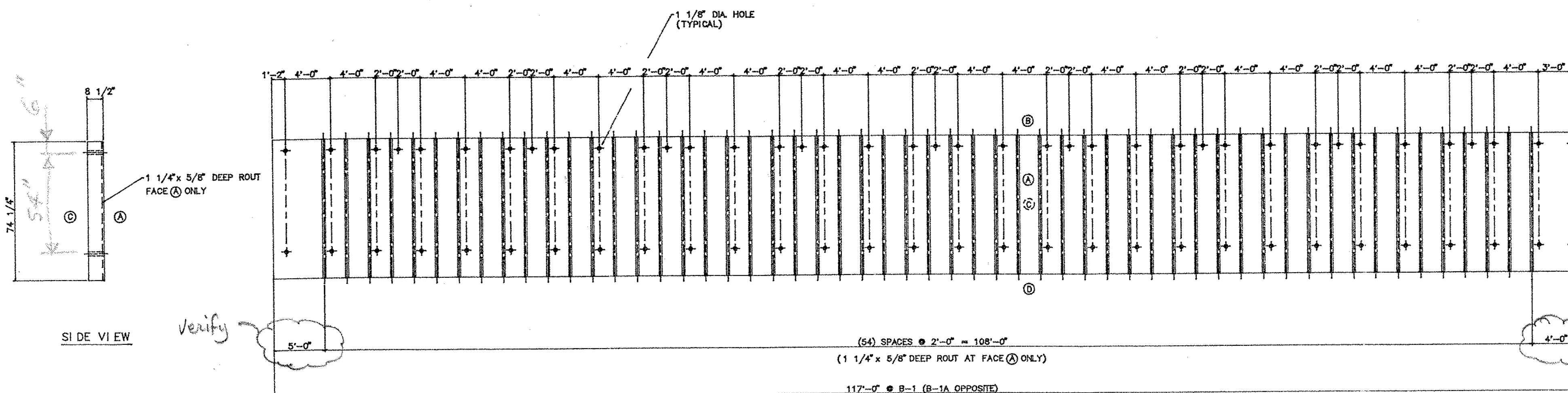
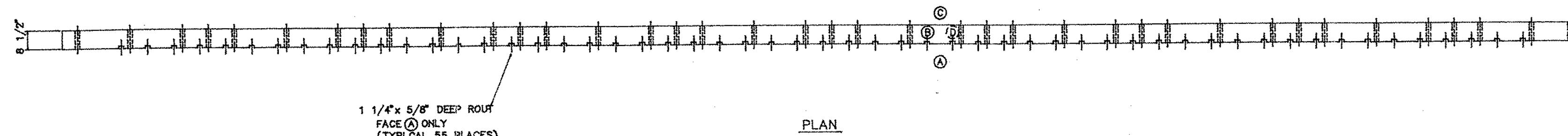
WOOD MATERIAL LIST										HARDWARE SCHEDULE								
NO. REQD	DESCRIPTION	MARK	SIZE	LENGTH	NOM. LAMS	LUMBER	CAMBER	DETAIL ON SHT.	NOTES	LOAD	MARK	CONN.	NO.	DESCRIPTION	DETAIL ON SHT.	NOTES	LOAD	
2	STRINGERS	B-1	8 1/2 x 74 1/4	117'-0"	2"	22F-V3	7,468' -10 1/8" R. (2 3/4" x 3)	1	1									
2	STRINGERS	B-1A	8 1/2 x 74 1/4	117'-0"	2"	22F-V3	7,468' -10 1/8" R. (2 3/4" x 3)	1	1									
24	FLOORBEAMS	FB-1	10 1/2 x 18 1/2	18'-0"	2"	18F-V2	NONE		1									

RECEIVED
 CK'D BY _____ OK'D BY _____

SEP 25 1998

RESUBMIT _____ APPROVED *A. Neta*
 BY *JHW* DATE *9/28/98*
 VAO

SHOP NOTE:
 1) FABRICATE WITH LUMBER TREATED 0.6 pcf PENTA TYPE C, BEFORE GLUING, IN ACCORDANCE WITH APPLICABLE AWPA STANDARDS.



Approved
 Approved As Noted
 Revise and Resubmit
 By: *Neil Daniels*
 Date: *9-28-98*

RADIUS: 7,468' -10 1/8"	
DI. STANCE TO C.L.	OFFSET (IN.)
0'-0"	0"
4'-0"	1/8"
8'-0"	1/16"
12'-0"	1/8"
16'-0"	3/16"
20'-0"	5/16"
24'-0"	7/16"
28'-0"	5/8"
32'-0"	13/16"
36'-0"	1 1/16"
40'-0"	1 1/4"
44'-0"	1 9/16"
48'-0"	1 13/16"
52'-0"	2 3/16"
56'-0"	2 1/2"

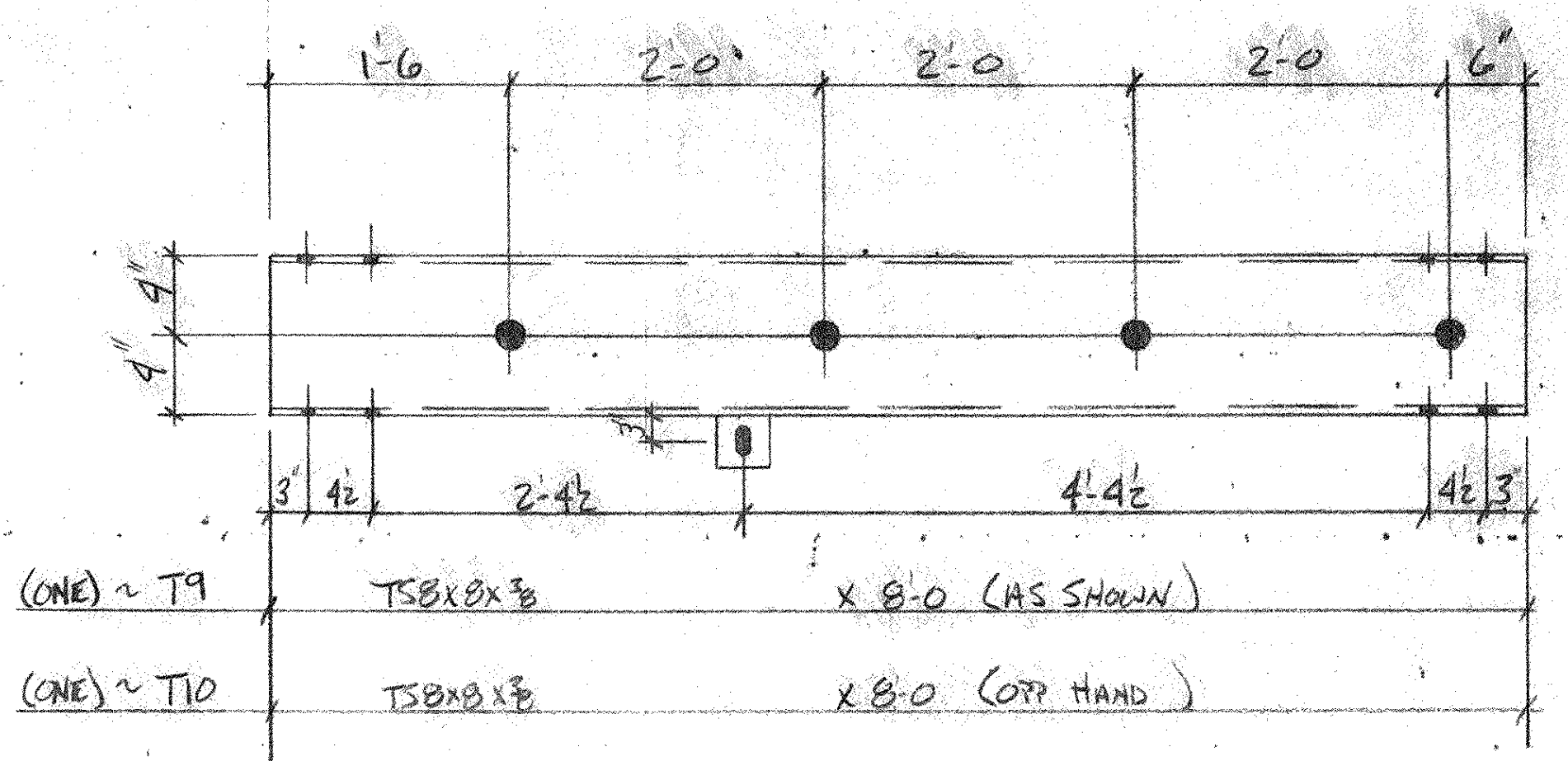
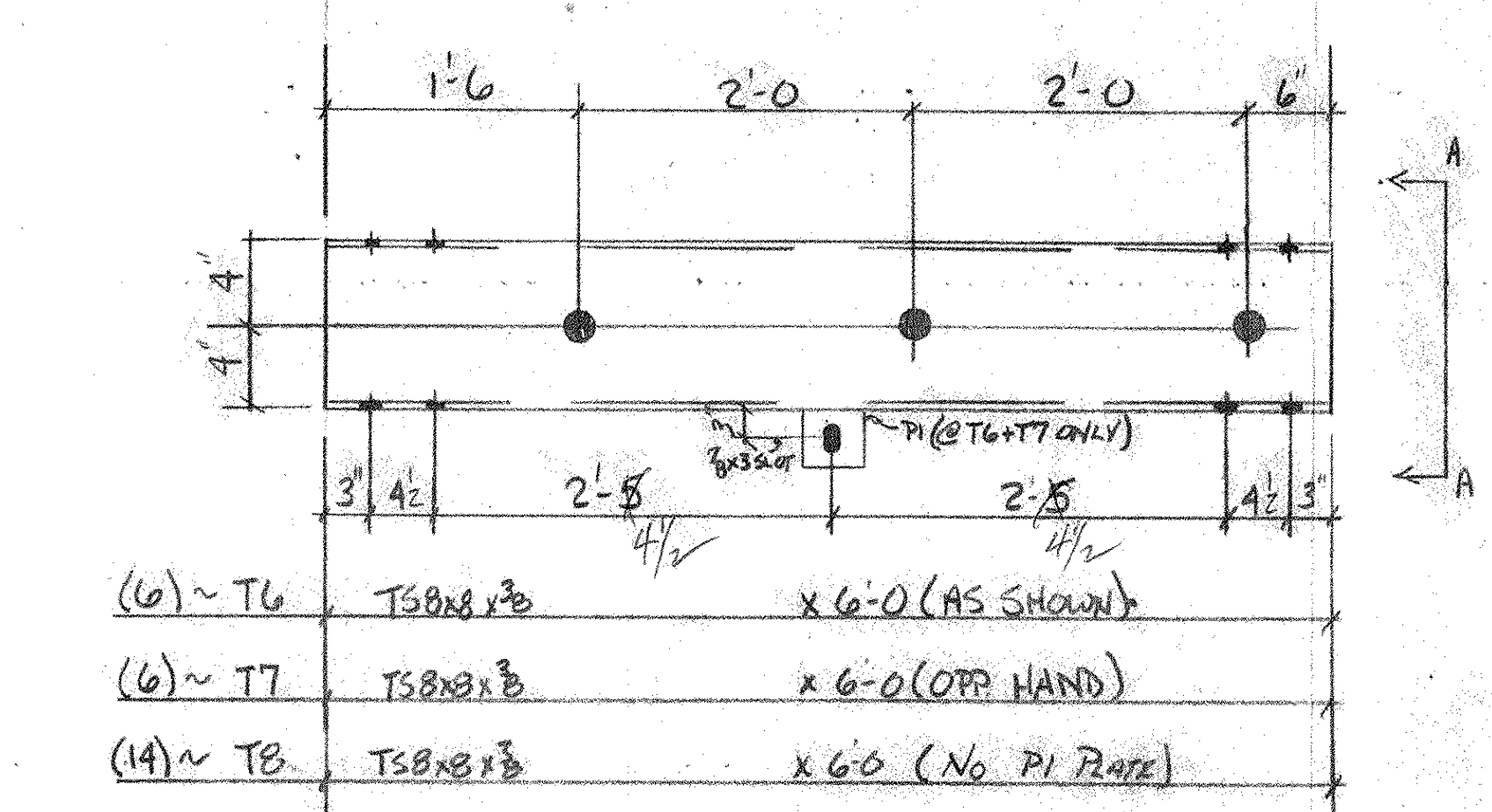
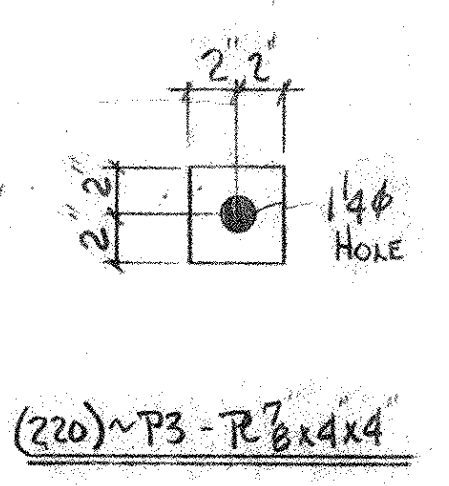
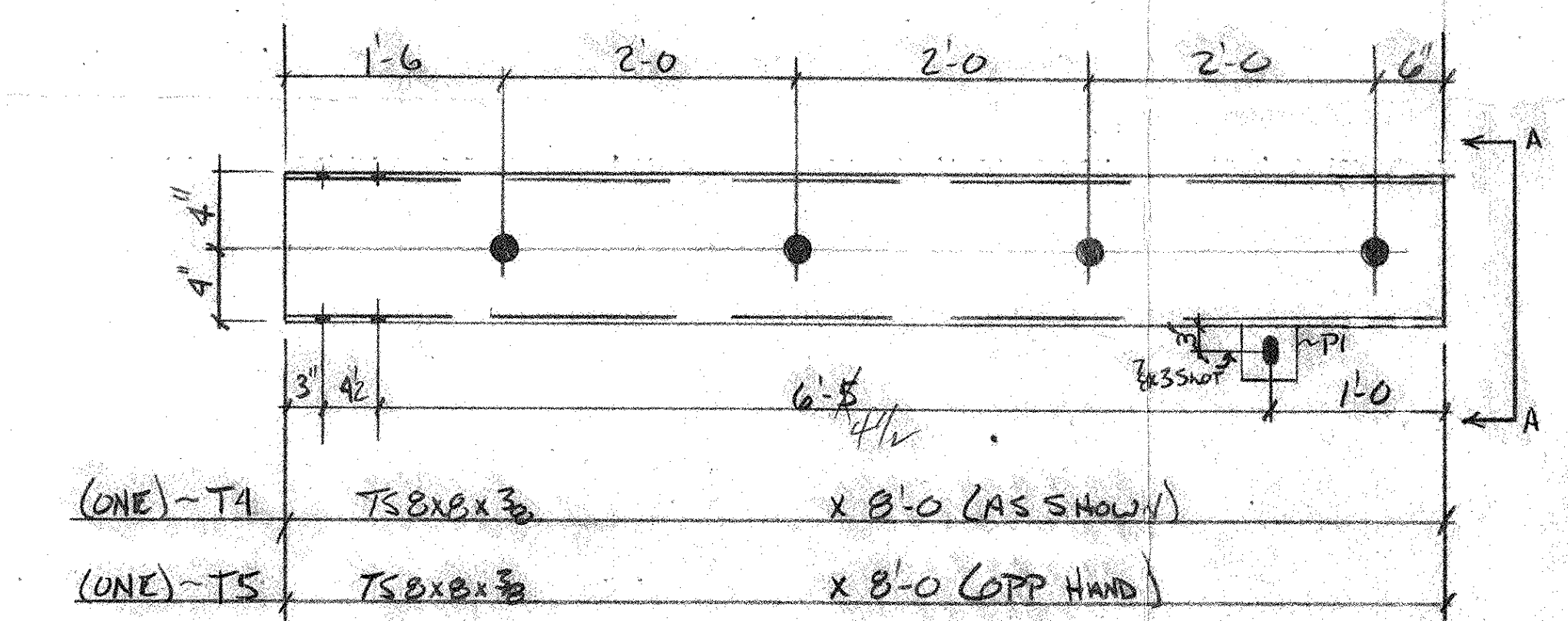
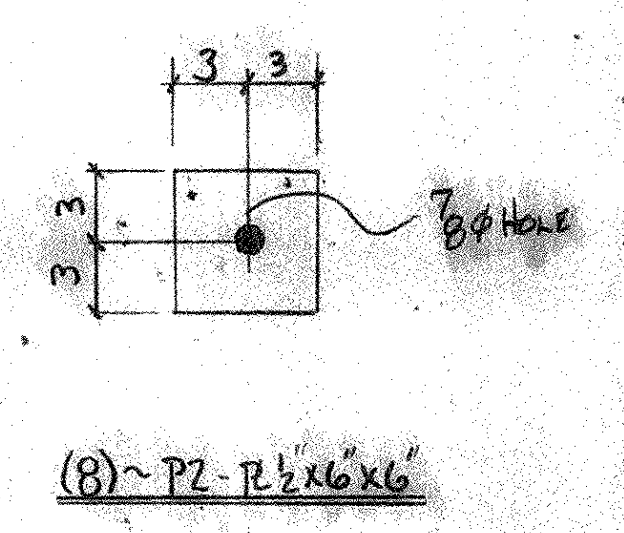
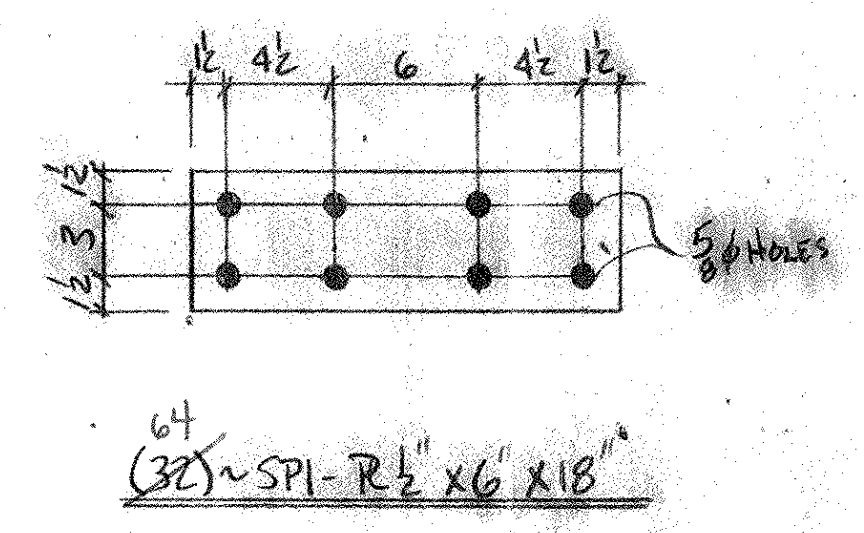
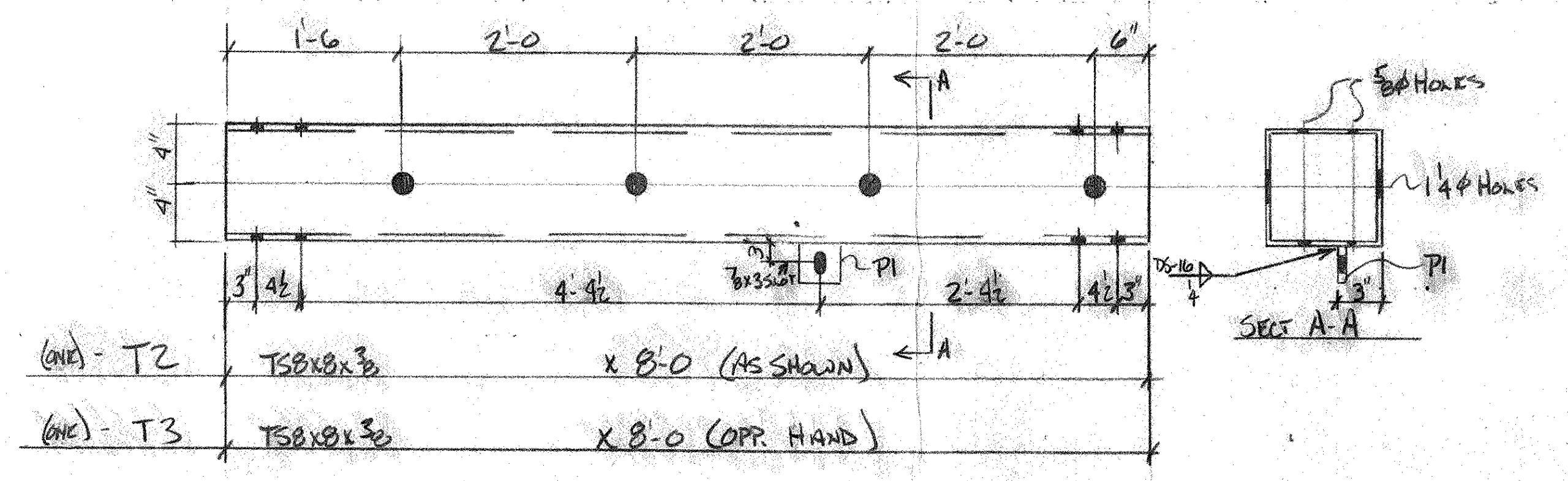
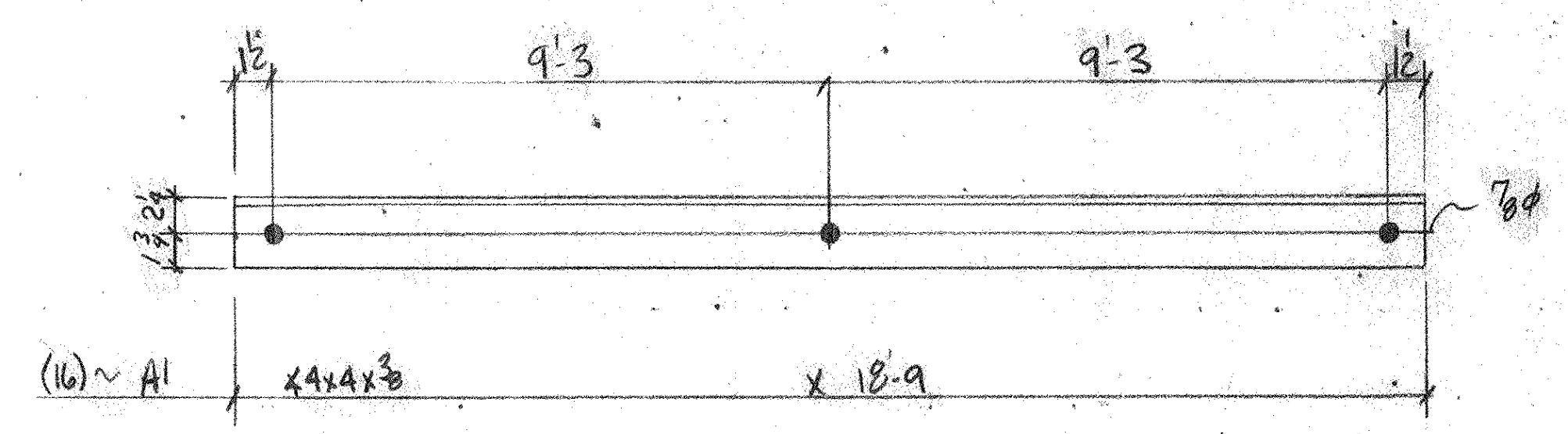
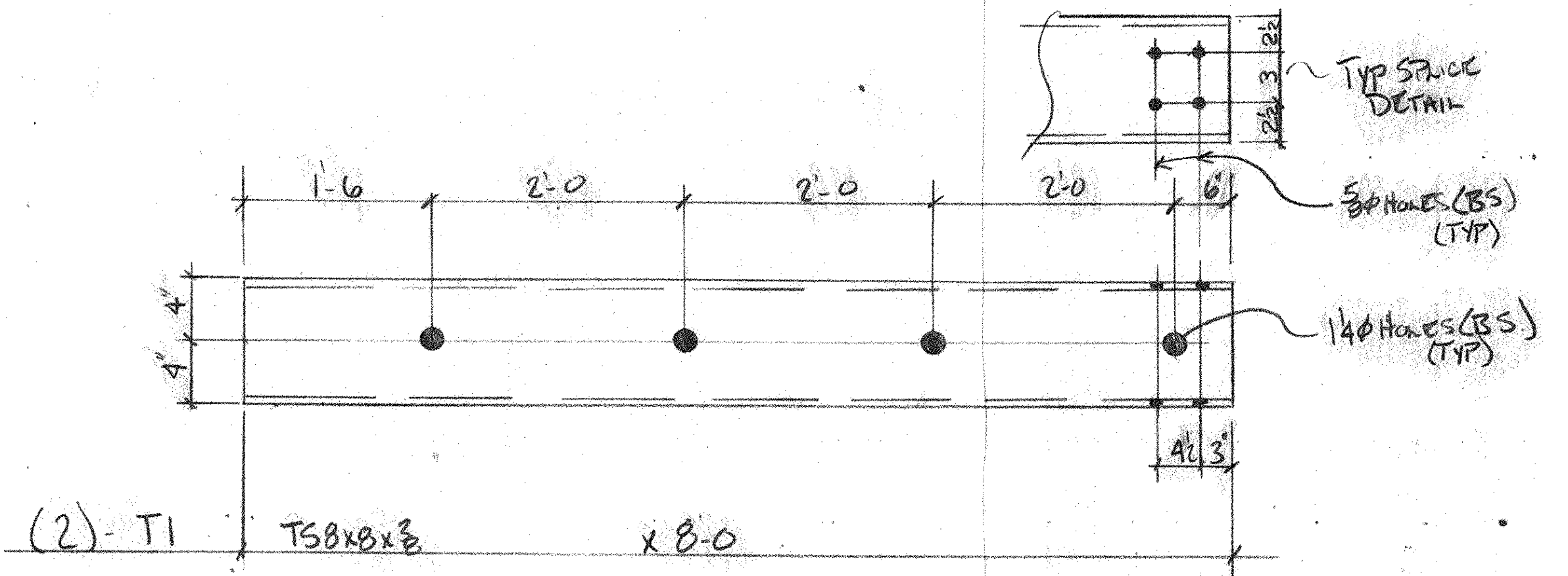
A.I.T.C. CERTIFICATE & MARKS

COPYRIGHT (C) ENWOOD STRUCTURES, LLC. - MORRISVILLE, N.C. - ALL RIGHTS RESERVED AND ENFORCED.

MATERIAL: STRESS GRADED, KILN DRIED SOUTHERN PINE LUMBER	DESIGN DATA: NO DESIGN BY ENWOOD STRUCTURES	CHARTER MEMBER A.I.T.C.	ENWOOD STRUCTURES MANUFACTURER OF ENGINEERED WOOD PRODUCTS	CLEARANCE DATA - MATERIAL: HEIGHT 117'-0", WIDTH	DRAWN: R. R. HAYES 9/22/98 CHECKED	OUR JOB NO. 98-HB-1190	BRI DGE #17 NEWFANE, VT.	SHEET 1 OF 1
ADHESIVE: WATERPROOF						APPROVED FOR FABRICATION	ARCHITECT: NEIL H. DANIELS, INC.	

IN EVENT OF ERROR, DEFECTIVE MATERIAL, AND/OR WORKMANSHIP, PLEASE NOTIFY THE NEAREST ENWOOD SALES OFFICE IMMEDIATELY. ENWOOD RESERVES THE RIGHT TO INVESTIGATE AND CORRECT ALL ALLEGED ERRORS AND DEFECTS

(Structures Copy)



BILL OF MATERIALS				
QUAN	MARK	SHAPE	LENGTH	REMARK
2	T1	TSBx8x3	8'-0	
ONE	T2	TSBx8x3	8'-0	
ONE	T3	TSBx8x3	8'-0	
2	P1	R 1/2 x 6	0'-6	
ONE	T4	TSBx8x3	8'-0	
ONE	T5	TSBx8x3	8'-0	
2	P1	R 1/2 x 6	0'-6	
6	T6	TSBx8x3	6'-0	
6	T7	TSBx8x3	6'-0	
14	T8	TSBx8x3	6'-0	
12	P1	R 1/2 x 6	0'-6	
16	A1	x 4x4x3	18'-9	
64	S1	R 1/2 x 6	1'-6	
8	P2	R 1/2 x 6	0'-6	
220	P3	R 7/8 x 4	0'-4	
ONE	T9	TSBx8x3	8'-0	
ONE	T10	TSBx8x3	8'-0	
2	P1	R 1/2 x 6	0'-6	

NOTES:
 - ALL TUBES TO BE ASTM A500 GR. A (MIN.)
 - ALL OTHER STEEL TO BE ASTM GR30
 - ALL MATERIAL TO BE GUARANTEED PER ASTM A123
 - ALL HARDWARE BY OTHERS

RECEIVED
 CKD BY JLD OKD BY JLD
 10/25/98
 OCT 21 1998
 RESUBMIT BY JLD APPROVED JLD DATE 10-20-98

Approved
 Approved As Noted
 Revise and Resubmit

DRAWING COVERS:

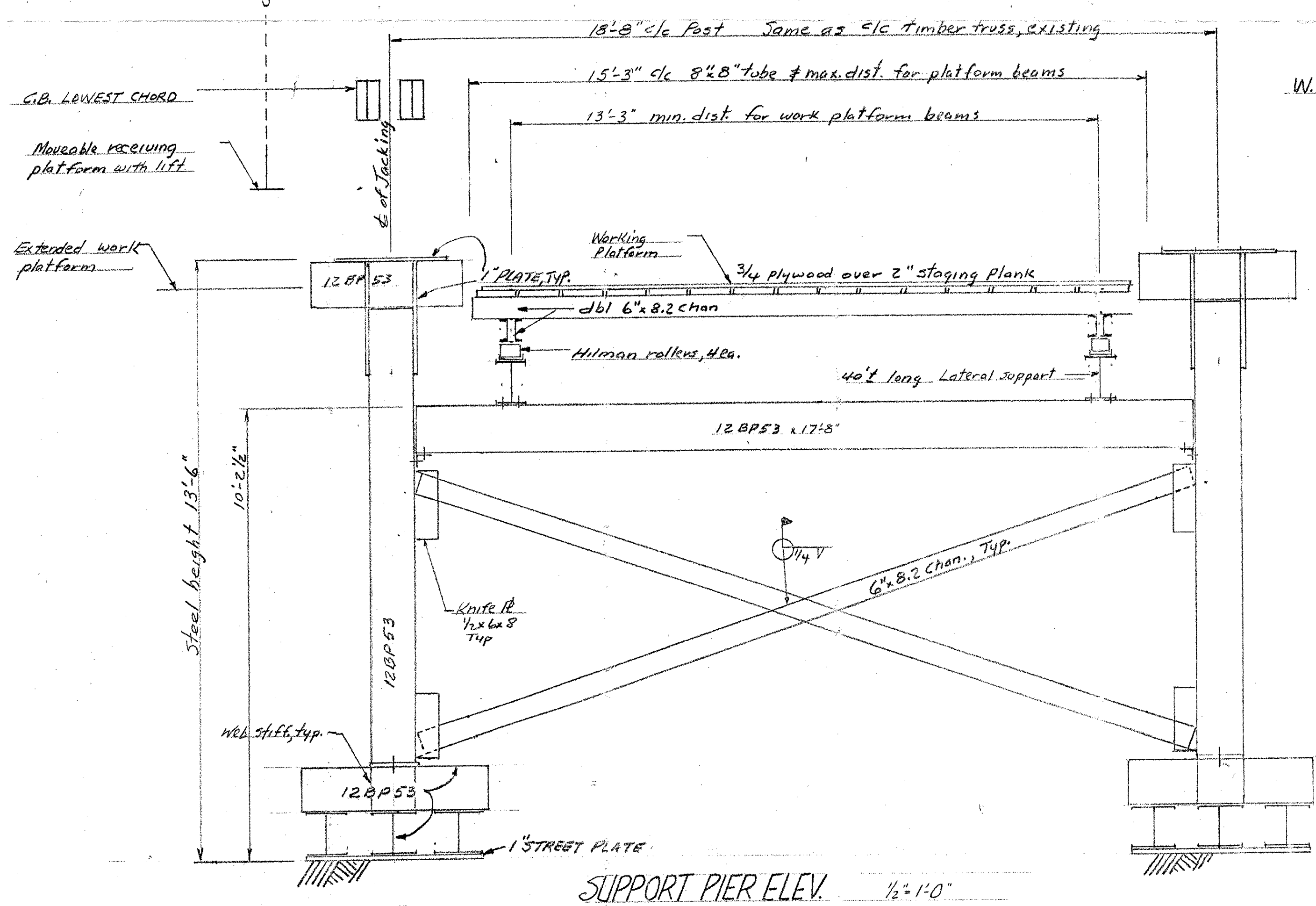
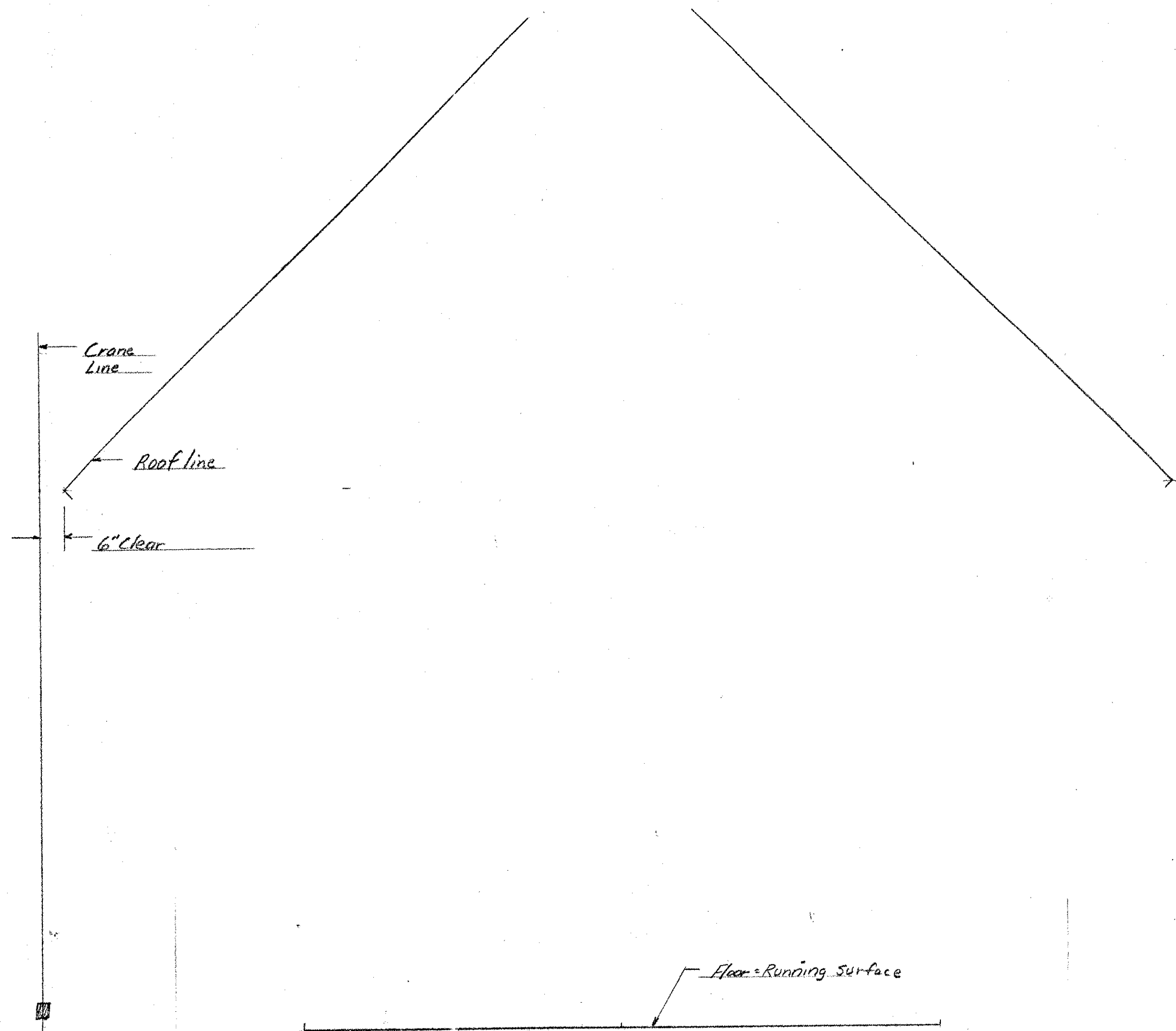
STEEL DETAILS

DATE SUB.	PROJECT	TH 2 QUEE ROCK RIVER
	LOCATION	# RHE-0106 (A) S
	ARCHITECT	NEWFANE, VT.
	ENGINEER	Vt. A.O.T.
DATE APP.	CUSTOMER	NEIL DANIELS CONST
DATE DIST.		

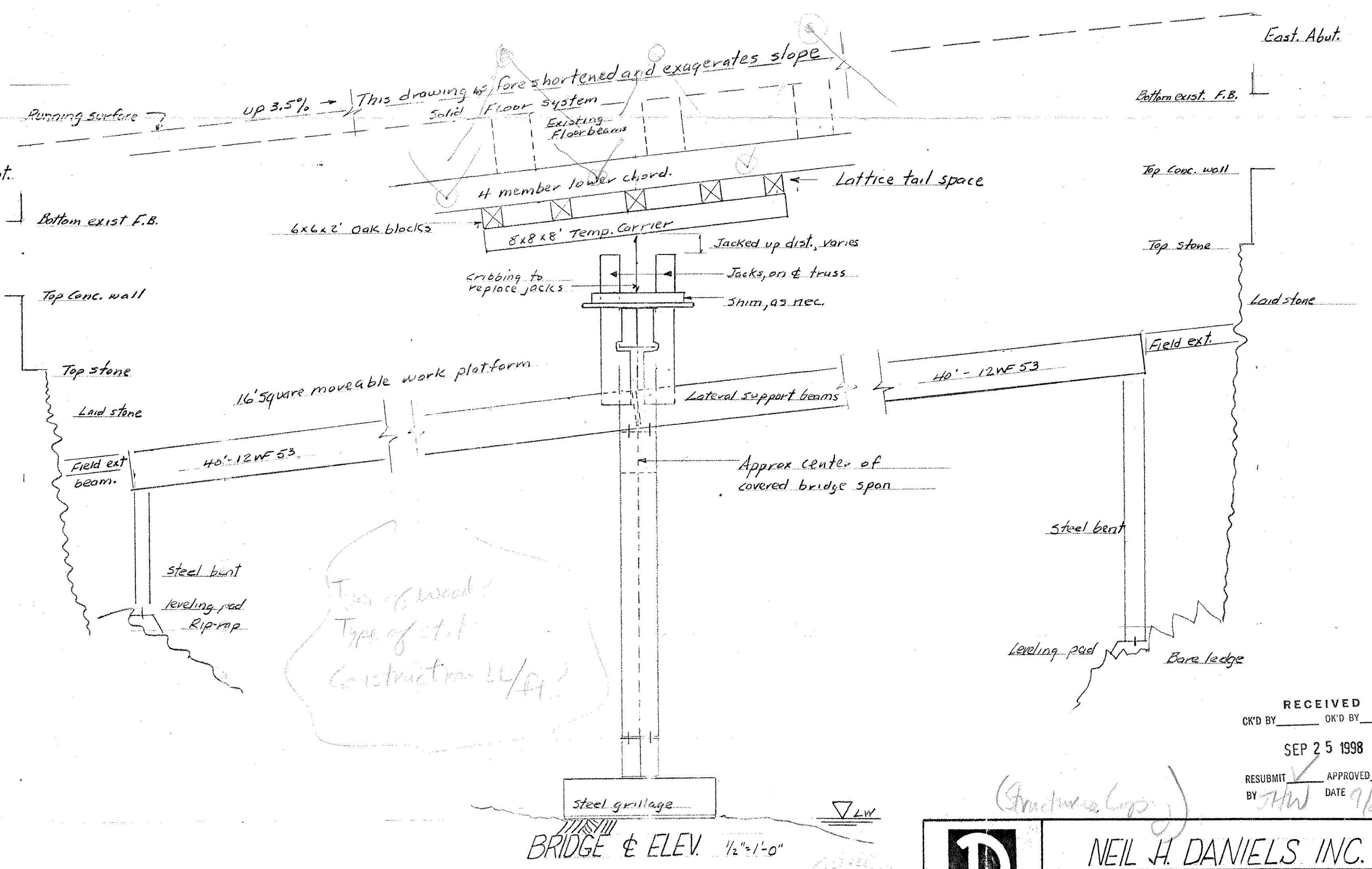
MERRIMACK SHEET METAL
 119 HALL ST.
 CONCORD N.H. 03301
 Tel. (603)224-7766
 Fax (603)224-7925

DRAWN BY: JLD
 CKD. BY: JLD
 JOB NO. 4501
 DWG. NO. F1

REV. NO.	DATE	DESCRIPTION
1	10/16/98	T9/T10
		HOLES AS NOTED
		PAINT GALV



Note: Steel supportworks shown here is existing structure previously used as launch pier for 240 Mabey. *with chat*



Temp. wood type of steel construction 11/98

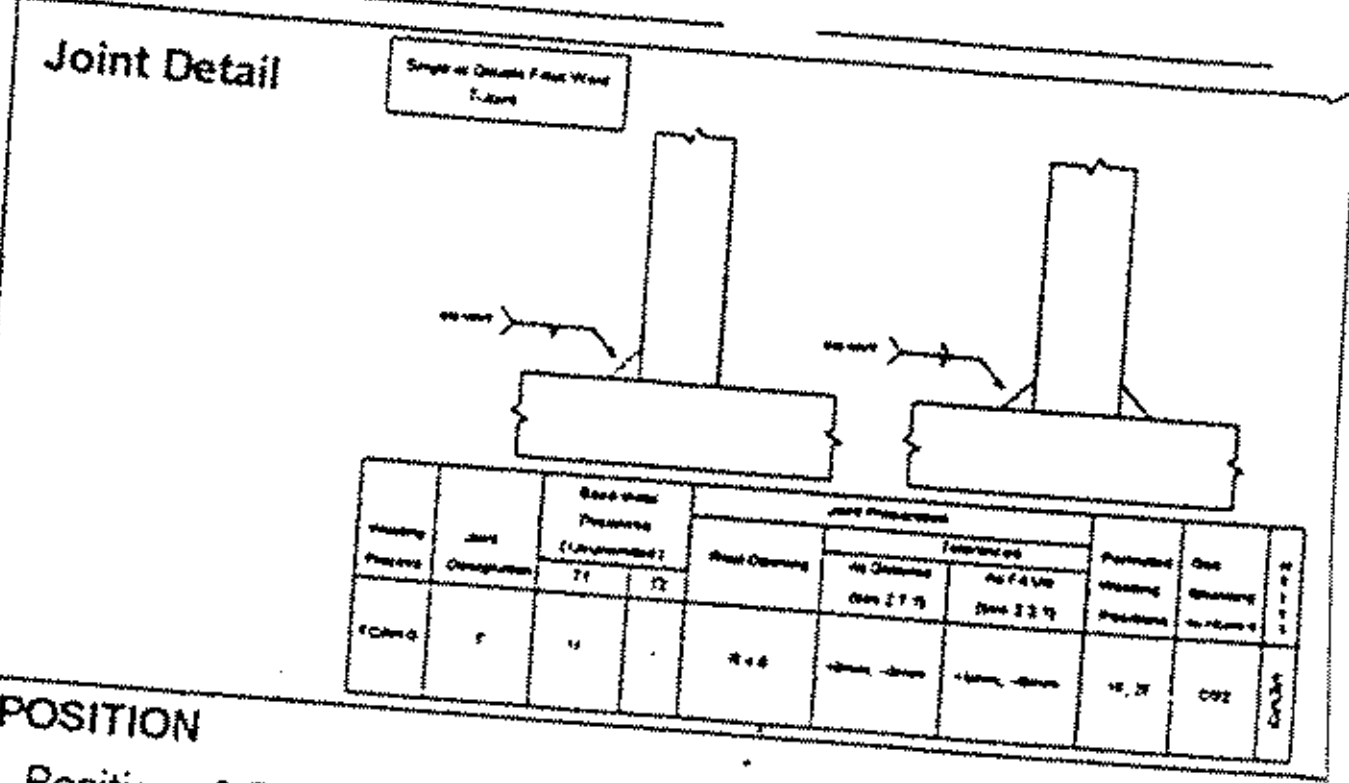
RECEIVED
OK'D BY _____ OK'D BY _____
SEP 25 1998
RESUBMIT APPROVED
BY *HW* DATE *9/25/98*

 DANIELS CONSTRUCTION ASCUTNEY, VT 05030	SCALE: 1/2" = 1'-0" DATE: 9-24-98	APPROVED BY _____ DRAWN BY <i>NHD</i>
	NEIL H. DANIELS, INC. WILLIAMSVILLE COVERED BR. TEMPORARY SUPPORT DRAWING NUMBER 8738-1	

Welding Procedure Specification

WPS No. DS-16VT Date 8/28/97 By Glenn A. Myrick, CWI, CWE, CW Type Manual Machine
 Authorized By James Dussault Date 12/30/94 Revision m1 Semi-Auto Auto
 Welding Process(es) FCAW-G N/A Prequalified
 Supporting PQR(s) 007 008

JOINT
 Type T-Joint
 Backing Yes No Single Weld Double Weld
 Backing Material N/A
 Root Opening None Root Face Dimension N/A
 Groove Angle N/A Radius (J-U) N/A
 Back Gouge Yes No
 Method N/A



BASE METALS
 Material Spec. A709M to A709M
 Type or Grade 250,345,345W to 250,345,345W
 Thickness: Groove (mm) _____
 Fillet (mm All) _____ - Unlimited
 Diameter (Pipe, mm) _____

POSITION
 Position of Groove N/A Fillet 1F, 2F
 Vertical Progression: Up Down

FILLER METALS
 AWS Specification A5.20 N/A
 AWS Classification E71T-1 N/A
N/A N/A

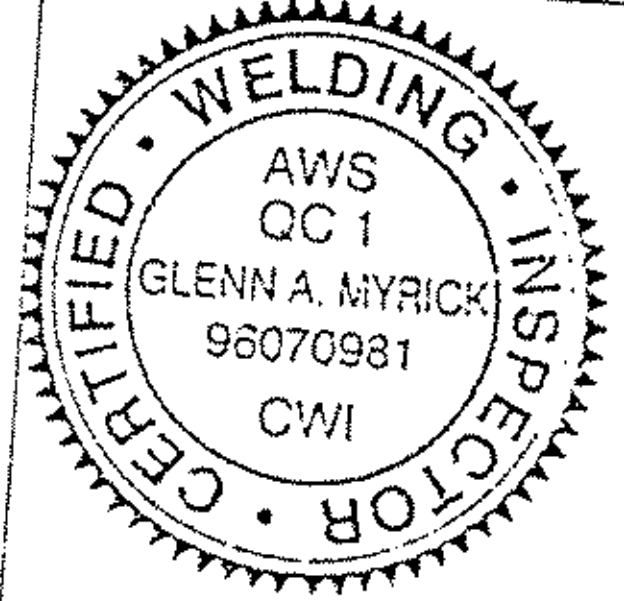
ELECTRICAL CHARACTERISTICS
 Transfer Mode (GMAW):
 Short-Circuiting Globular Spray
 Current: AC DCEP DCEN Pulsed
 Other N/A
 Tungsten Electrode (GTAW):
 Size N/A Type N/A

SHIELDING
 Flux N/A Gas CO2
 Composition 100%
 Electrode-Flux (Class) E71T-1 Flow Rate 14-16L/min
 Gas Cup Size 13MM

TECHNIQUE
 Stringer or Weave Bead Both
 Multi-pass or Single Pass (per side) Both
 Number of Electrodes 1
 Electrode Spacing: Longitudinal N/A
 Lateral N/A
 Angle N/A
 Contact Tube to Work Distance 10mm-20mm
 Peening NOT ALLOWED
 Interpass Cleaning Mechanical Only

PREHEAT
 Preheat Temp., Min. 10C
 Thickness Up to 3/4" Temperature 10c} <20mm
 Over 3/4" to 1-1/2" 20c} <40mm
 Over 1-1/2" to 2-1/2" 65c} <60mm
 Over 2-1/2" 110c} >60mm
 Interpass Temp., Min. 10C Max. 210C

POSTWELD HEAT TREATMENT PWHT Required
 Temp. NOT QUALIFIED Time N/A



STRUCTURES
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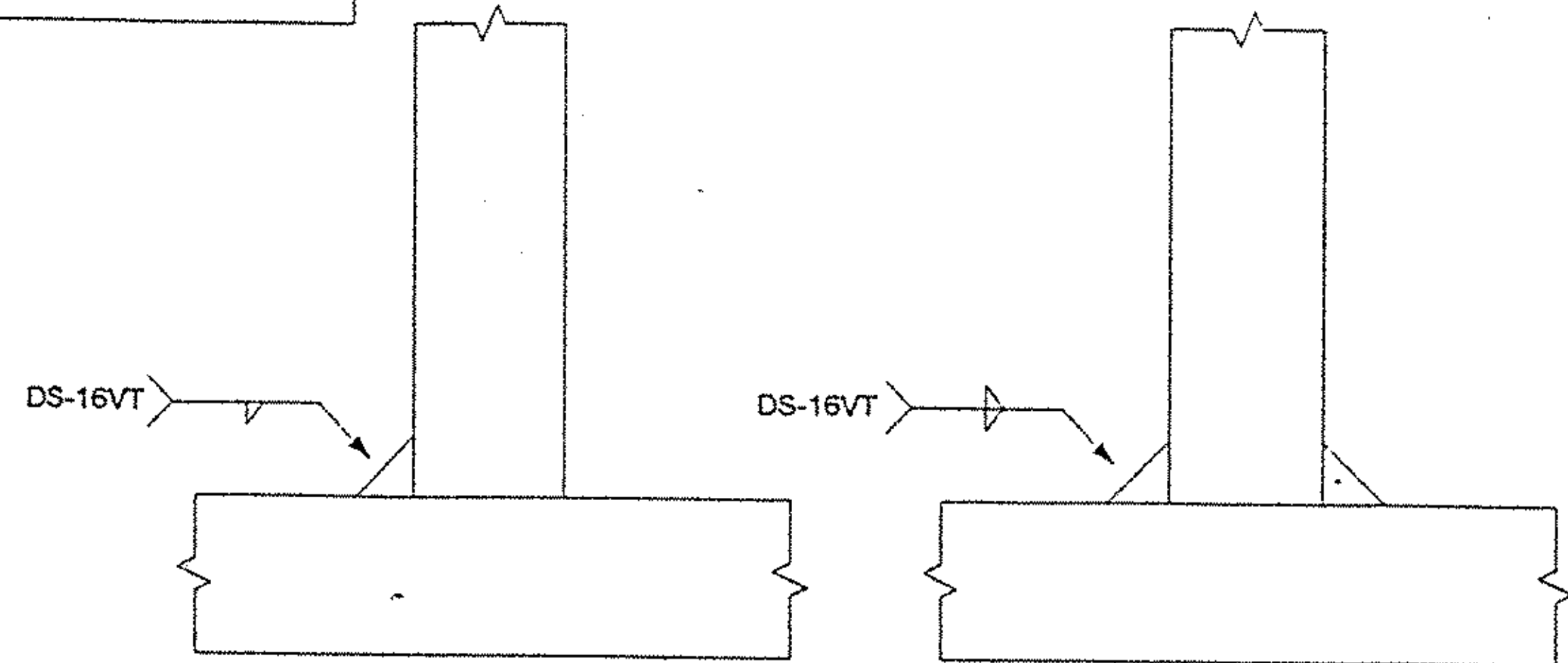
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Welding Procedure Specification

Joint Detail

Single or Double Fillet Weld
T-Joint



Welding Process	Joint Designation	Base Metal Thickness (U=unlimited)		Joint Preparation			Permitted Welding Positions	Gas Shielding for FCAW-G	Notes
		T1	T2	Root Opening	Tolerances				
					As Detailed (see 2.7.1)	As Fit Up (see 3.3.1)			
FCAW-G	T	U	-	R = 0	+0mm, -0mm	+5mm, -0mm	1F, 2F	CO2	MEMO

MEMO

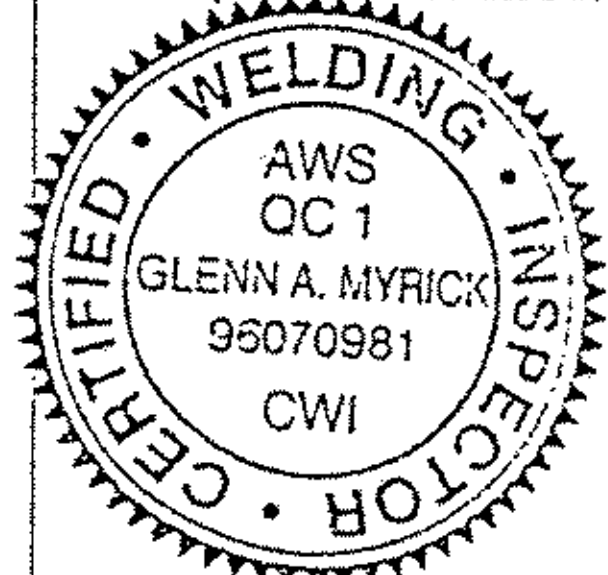
(3.3.1) Tolerances as Fit Up

If the root opening is greater than 2mm, the leg of the fillet weld shall be increased by the amount of the root opening or the contractor shall demonstrate that the required weld size has been obtained.

(4.1.5.4) Flux Cored Arc Welding (FCAW)

Single pass fillet welds up to 8mm maximum, may be made with a single pass or single pass each side, using an E7XT-X electrode conforming to Table 4.1 or 4.2.

Travel speed is calculated in millimeters per minute. D1.5, section 5.12.



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