BILL OF MATERIAL

REV. NO:	SHIP MARK	PIECE MARK	QTY.	TYPE OF MATERIAL	SIZE OF MATERIAL	GRADE	LENGTH	FINISH	NOTES	WEIGHT

EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION

WPS NUMBER: SMAW PL400-03	ISSUE DATE: 3-11-02
PROJECT: CHESTER BHO 1442 (32)	EB JOB NO: 5025
BASE METAL: ASTM A709 GR36,50,50W	
WELDING PROCESS: SMAW	
FILLER METAL SPEC: AS 5 E8018 C3	
FLUX/SHIELDING GAS: N/A	
CURRENT AND POLARITY: DCEP	ELEC STICKOUT: N/A
WELDING POSITION: 2F	
PREHEAT AND INTERPASS TEMP: AWS D1.5 TABLE 4.4	WPS QUALIFICATION: PREQUALIFIED
HEAT INPUT: 50.68-73.92 KILOJOULES	SUPPORTING PQR#: N/A

ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL 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	

6mm & 8mm

NOTES:

MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450°F

THICKNESS OF THICKEST PART AT POINT OF WELDING	TEMPERATURE °F ASTM A709 STEEL, GR 50W
UP TO 3/4"	50°F
3/4" TO 1 1/2"	70°F
1 1/2" TO 2 1/2"	150°F
OVER 2 1/2"	255°F

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN APPLICABLE AWS CODES AND CONTRACT SPECIFICATIONS.

V.A.O.T.
RECEIVED
CK'D BY_____ OK'D BY JWC
JUL 20 2004
RESUBMIT_____ APPROVED ✓
BY _____ DATE 07-21-04

WELDING PROCEDURES WERE NOT REVIEWED BY BCA of DUBOIS & KING, INC.

EASTERN BRIDGE, LLC
WELDING PROCEDURE SPECIFICATION

WPS NUMBER: SAW PL48-1	ISSUE DATE: 3-11-02
PROJECT: CHESTER BHO 1442 (32)	EB JOB NO: 5025
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	
PREHEAT AND INTERPASS TEMP: AWS D1.5 TABLE 4.4	WPS QUALIFICATION: AWS D1.5, 5.13
HEAT INPUT: 50.68 - 73.92 KILOJOULES	SUPPORTING PQR#: SAW - A332-3 PL#8

ELECTRODE SIZE	WELDING AMPS	CURRENT VOLTS	TRAVEL SPEED	JOINT DETAIL AWS NUMBER : FILLET
3/32"	396 - 440	28.8 - 31.5	11.25 - 13.5	

8mm

NOTES:

MINIMUM PREHEAT AND INTERPASS TEMPERATURES SHALL BE AS FOLLOWS:
MAXIMUM INTERPASS TEMPERATURE SHALL BE 450°F

THICKNESS OF THICKEST PART AT POINT OF WELDING	TEMPERATURE °F ASTM A709 STEEL, GR 50W
UP TO 3/4"	50°F
3/4" TO 1 1/2"	70°F
1 1/2" TO 2 1/2"	150°F
OVER 2 1/2"	255°F

THIS PROCEDURE MAY VARY DUE TO FABRICATION SEQUENCE, FIT UP, PASS SIZE, ETC. WITHIN THE LIMITS PROVIDED IN APPLICABLE AWS CODES AND CONTRACT SPECIFICATIONS.

V.A.O.T.
RECEIVED
CK'D BY_____ OK'D BY JWC
JUL 20 2004
RESUBMIT_____ APPROVED ✓
BY _____ DATE 07-21-04

ITEM NO: 506.50

REVISIONS		
NO.	DATE	DESCRIPTION
	7/14/04	FOR APPROVAL

EASTERN BRIDGE LLC
RURAL RTE 2, BOX 302
CLAREMONT, NH 03743
603-542-5202

FRANK W. WHITCOMB CONSTRUCTION CORP.
CONTRACT : BHO 1442 (32) VT AOT

CHURCH STREET (TH 5) OVER WILLIAMS RIVER
BRIDGE NO. 11
CHESTER, VT

TITLE :
WELD PROCEDURES AND FABRICATION PROCEDURES

DRAWN BY 4/20/04 DANA BACON	SHOP ORDER 5025	DWG. NO. WPS1
CKD BY JH 7/15/04	BLOCK NO.	SHEET NO. 1 OF 1

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