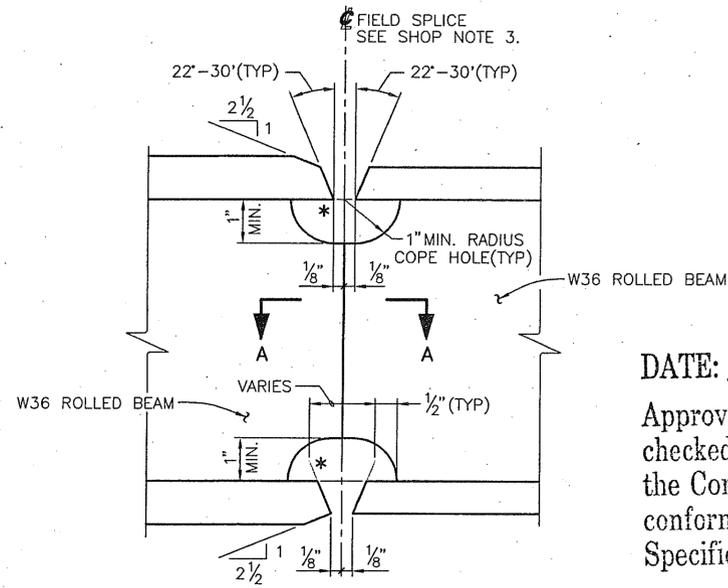


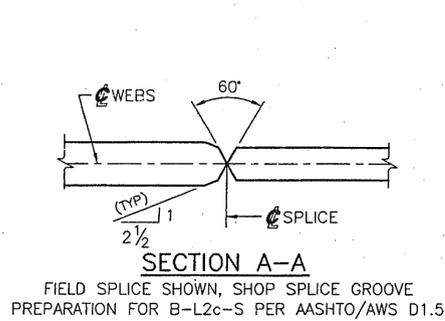
SHOP PREPARATION



ELEVATION

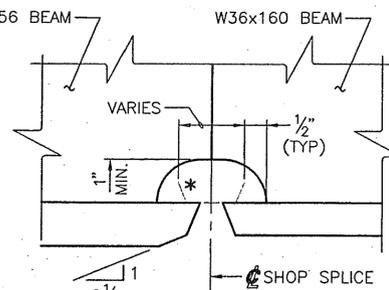
FIELD SPlice SHOWN, SHOP SPlice SIMILAR EXCEPT FOR BOTTOM FLANGE JOINT PREPARATION.

* DURING OXYFUEL CUTTING, THE CUT MAY PROTRUDE UP TO 1/2" INTO THE WEB TO ENSURE AN ADEQUATE COPE HOLE OPENING. THE MINIMUM HEIGHT OF THE COPE IS 1".

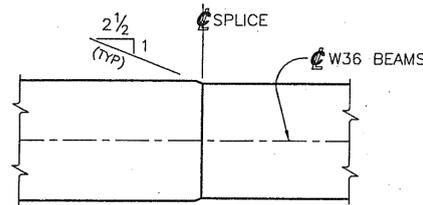


SECTION A-A

FIELD SPlice SHOWN, SHOP SPlice GROOVE PREPARATION FOR B-L2c-S PER AASHTO/AWS D1.5



BTM FLANGE @ SHOP SPlice



TOP & BOTTOM FLANGE
UNEQUAL WIDTH (12" to 12 1/4")

SHOP NOTES:

- WHERE FLANGES OR WEBS OF DIFFERENT THICKNESS OR WIDTHS ARE TO BE SPliced, THEY SHALL BE PREPARED IN THE SHOP FOR A TRANSITION OF 1 IN 2 1/2 (SEE DETAILS ABOVE).
- MITER CUTS AT SHOP & FIELD SPlice ENDS OF BEAMS SHALL BE MADE DURING SHOP BLOCKING. SEE SHEET W2.
- DO NOT PAINT WITHIN 9" FROM THE FIELD SPlice ENDS OF ALL BEAMS.
- SEE BEAM DETAIL SHEETS FOR SHOP & FIELD SPlice LOCATIONS.

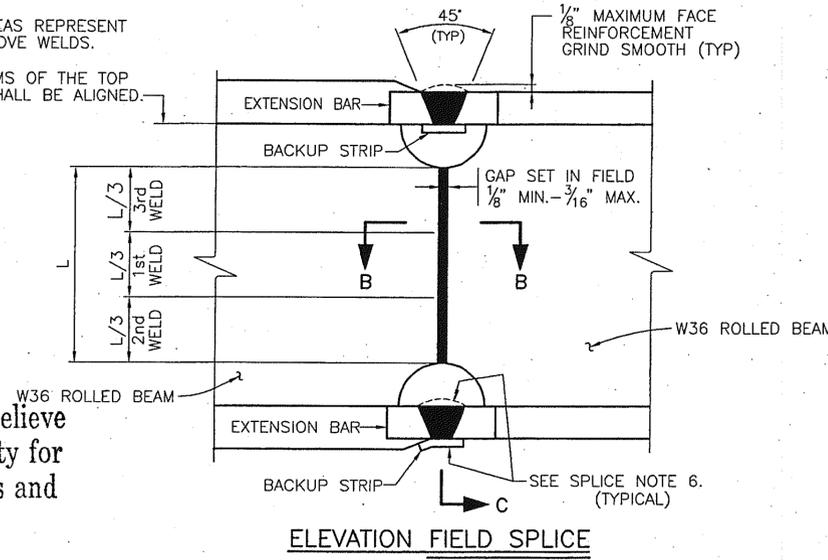
WELDING PROCEDURES

FIELD WELD NOTES:

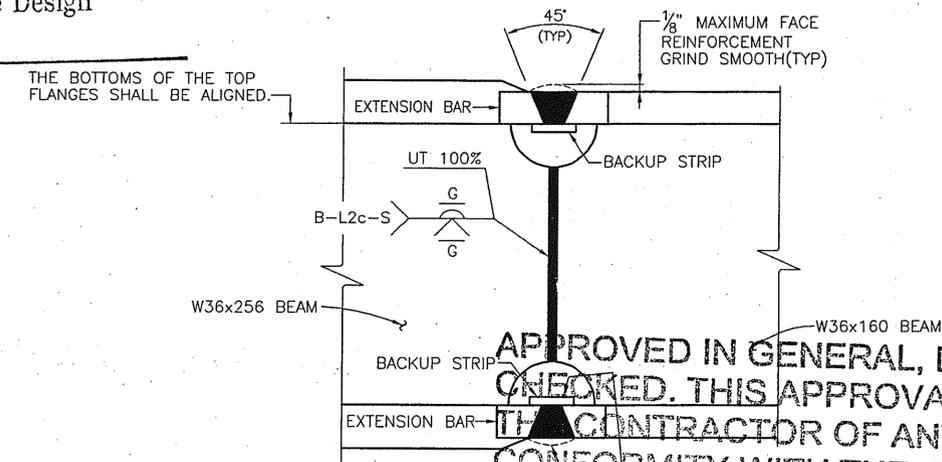
WEBS SHALL BE WELDED VERTICALLY IN THE SEQUENCE SHOWN.

SHADED AREAS REPRESENT THE V-GROOVE WELDS.

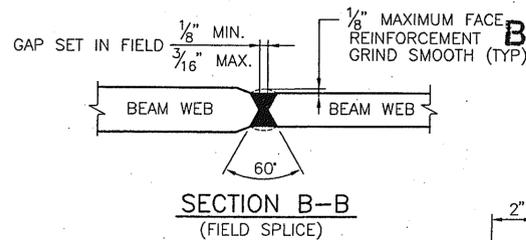
THE BOTTOMS OF THE TOP FLANGES SHALL BE ALIGNED.



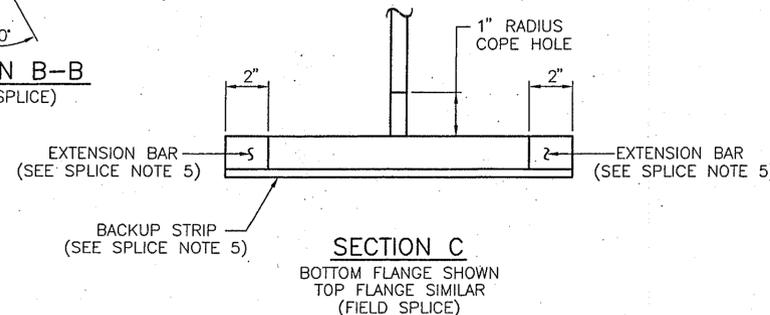
ELEVATION FIELD SPlice



ELEVATION SHOP SPlice



SECTION B-B
(FIELD SPlice)



SECTION C

BOTTOM FLANGE SHOWN
TOP FLANGE SIMILAR
(FIELD SPlice)

SPlice NOTES:

- WELDING SHALL BE IN ACCORDANCE WITH SUB-SECTION 501.3.04.H OF THE GEORGIA STANDARD SPECIFICATIONS, 2001 EDITION. ONLY E70XX (EXCLUDING E7014 AND E7024) LOW HYDROGEN ELECTRODES SHALL BE USED FOR MANUAL SHIELDED METAL ARC WELDING.
- WORK SHALL BE PROTECTED FROM MOISTURE, FROM ANY SOURCE, DURING WELDING AND AFTERWARDS, UNTIL PARTS WELDED HAVE COOLED TO ATMOSPHERIC TEMPERATURE.
- THE BOTTOMS OF THE TOP FLANGES SHALL BE ALIGNED.
- SEQUENCE OF WELDS: WEB FIRST, BOTTOM FLANGE SECOND, AND TOP FLANGE LAST. USE TWIN ARC TECHNIQUE ON WEB AND BOTTOM FLANGE OF FIELD SPlices.
- BACKUP STRIPS AND EXTENSION BARS SHALL BE USED ON WELDED SPlices. BACKUP STRIPS SHALL BE PLATE 3/16" x 1" x (FLANGE+4"). EXTENSION BARS SHALL BE 2" LONG AND THE SAME THICKNESS AS THE FLANGE ON WHICH THEY ARE TO BE USED, WITH THE SAME EDGE BEVELED AS THE FLANGE PLATE, AS APPLICABLE.
- AFTER COMPLETION OF THE SPlice, REMOVE THE EXTENSION BARS AND BACKUP STRIPS, GRIND SMOOTH TOP, BOTTOM, AND EDGES OF TOP AND BOTTOM FLANGES AND BOTH SIDES OF WEB. GRINDING SHALL BE DONE PARALLEL TO LENGTH OF THE BEAM.
- CLEANING AND PAINTING OF WELD AREA, AFTER WELDING, SHALL BE DONE IN ACCORDANCE WITH SECTION 535 OF THE STANDARD SPECIFICATIONS.
- THE MINIMUM RADIUS OF THE COPE HOLE IS 1". THE FABRICATOR WILL DETERMINE THE RADIUS OF THE COPE HOLES IN SUCH A MANNER AS TO PROVIDE A SMOOTH TRANSITION BETWEEN COPE HOLES. LEAVE COPE HOLES OPEN AFTER WELDING.
- SPlice SHALL BE FURNISHED IN CONFORMANCE WITH SECTION 501 OF THE GEORGIA DOT SPECIFICATIONS.

MINIMUM PREHEAT AND INTERPASS TEMPERATURE

THICKNESS OF THICKEST PART AT POINT OF WELDING

TEMPERATURE	TEMPERATURE
A709 GR.36	A709 GR.50
NONE	NONE
150° F	50° F
225° F	150° F
300° F	225° F

APPROVED IN GENERAL, DETAILS NOT CHECKED. THIS APPROVAL SHALL NOT RELIEVE THE CONTRACTOR OF ANY RESPONSIBILITY FOR CONFORMITY WITH THE CONTRACT PLANS AND SPECIFICATIONS.

AECOM TECHNICAL SERVICES, INC.

BY: *[Signature]* 10-11-12

SEE SHEET GN1 FOR GENERAL NOTES

FIELD BOLTS	
OPEN HOLES AS NOTED	
TYPE WELDING FIELD WELDS PER CONTRACTOR	



AUGUSTA IRON & STEEL WORKS, Inc.
P.O. BOX 212479 (30917) Phone 706-860-7719
3781 MARTINEZ BLVD. AUGUSTA, GA 30907

REV.	DATE	DESCRIPTION
△		
△		
△		

DESIGNED BY: AECOM	DATE: 08/2012	CONTRACT: 1374
DRAWN BY: GB	CHECKED BY: JWJ	DATE: 09/2012
STEEL SPEC: ASTM A709 GR.50		SHEET W1 OF 2