

CONTRACT CHANGE ORDER NO. 41 SUPPL. NO. ---
ROAD 04-SF-80-13.2, 13.9 SHEET 2 OF 18 SHEETS
FEDERAL NO.(S) _____ CONTRACT NO.: 04-0120F4

Revise Section 8-3.01, "WELDING," to include a new subsection "Welding Padeyes" to appear at the end of the GENERAL subsection:

8-3.01 WELDING

GENERAL

Welding Padeyes

Weld Crosby No. 4 or equivalent padeyes to steel structures in accordance with AWS D1.5, as modified by this specification. Use a Welding Procedure Specification (WPS) approved for welding the type and thickness of base material to which the padeye is welded. Qualification of a procedure for welding to padeyes is required for each supplier with padeyes attached to their work. Qualify the procedure as follows for each supplier:

1. Fabricate three test samples of a padeye welded to a plate.
 - a) If a supplier's work includes Seismic Performance Critical Member (SPCM) material, use the thinnest SPCM plate material to which padeyes will be welded. If a supplier's work does not include SPCM material, use the thinnest plate material to which padeyes will be welded.
 - b) Weld the padeye to the plate using a WPS approved for welding the base metal. A separate WPS for the padeye to plate weld is not required.
2. Test the three samples as follows. Test machinery must be capable of loading the samples to failure. Apply the force at the circular end of the padeyes.
 - a) Sample #1 - Load in shear direction. Failure must occur at a force greater than 22.2 kN.
 - b) Sample #2 - Load in tension to destruction. Failure must occur at a force greater than 22.2 kN.
 - c) Sample #3 - Take three subsized Charpy V-Notch specimens per ASTM A 370 from the course grained area of the Heat affected zone in the base metal. Perform Charpy V-Notch test in accordance with Special Provisions, Section 10-1.59 "Steel Structures," subsection "Materials".

Submit a test method to the Engineer for approval prior to performing the procedure qualification.