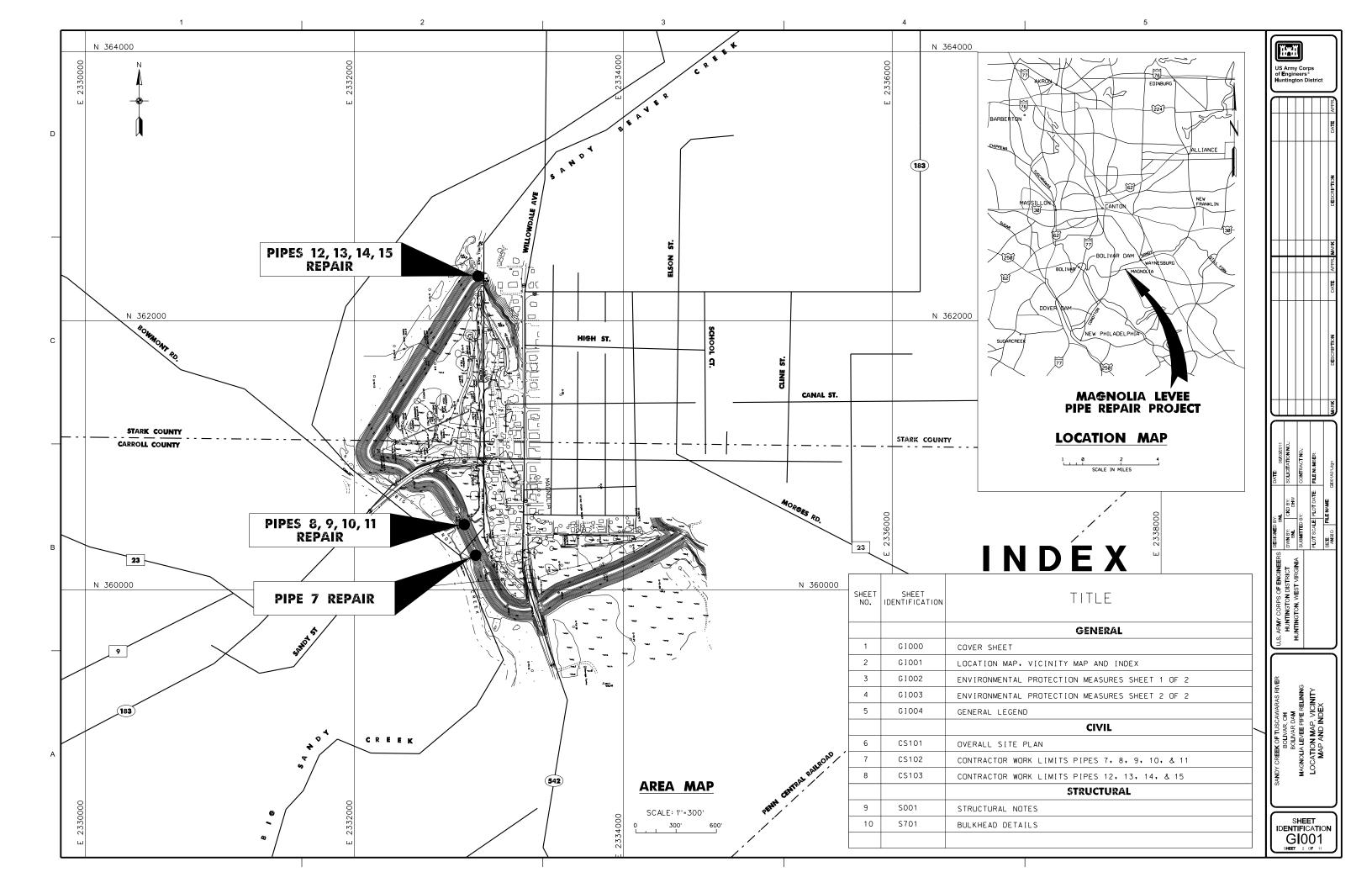
ENCLOSURE 6



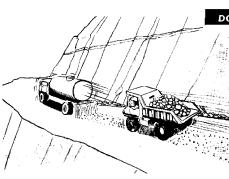
Construction Plans

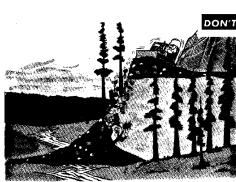
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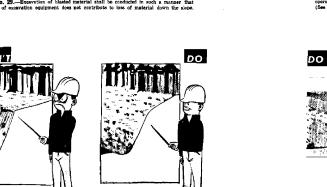




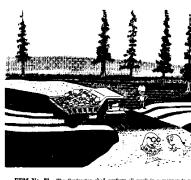


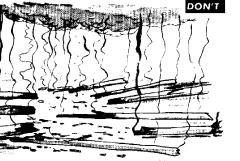


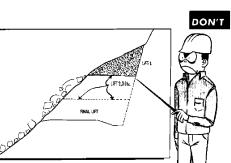




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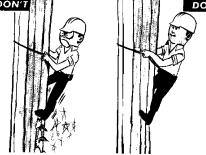


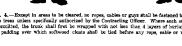


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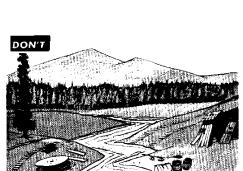
BPM No. 9.—All treated wounds and specified pruning cuts shall be painted with an approved tree pruning compound of a color approximately matching the color of the bark.



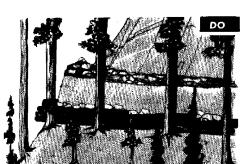








EPM No. 7.—Ropes, guys or other means shall be used where necessary to restrain materials from damaging trees or shrubs which are to remain.

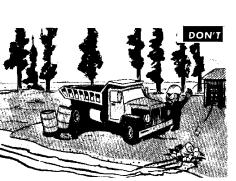


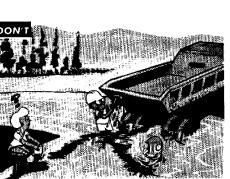


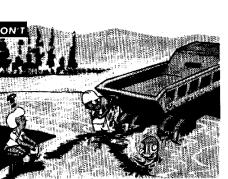


EPM No. 15.—Slopes of the borrow site shall be graded and dressed to blend with the adjacent terrain.



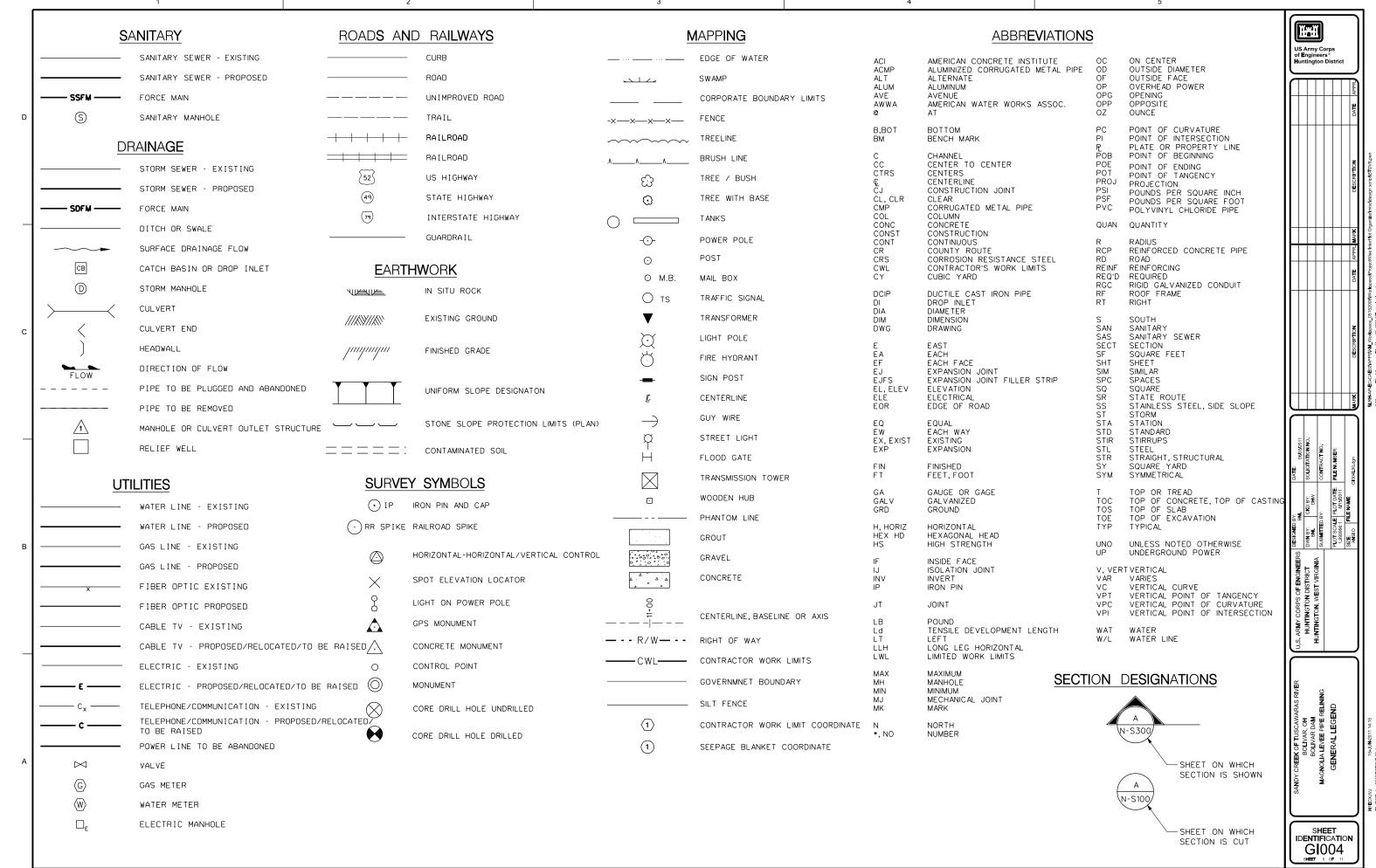


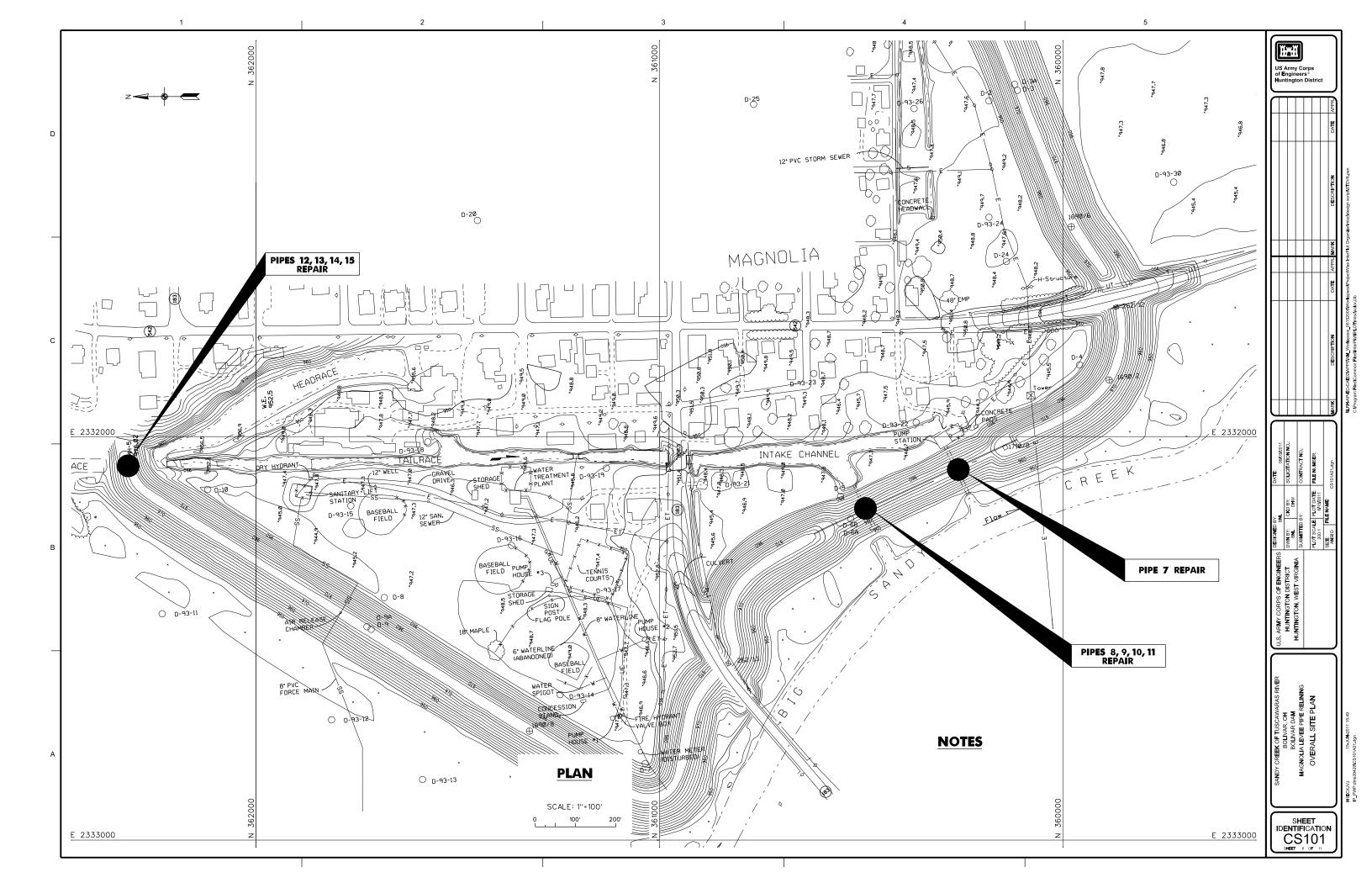


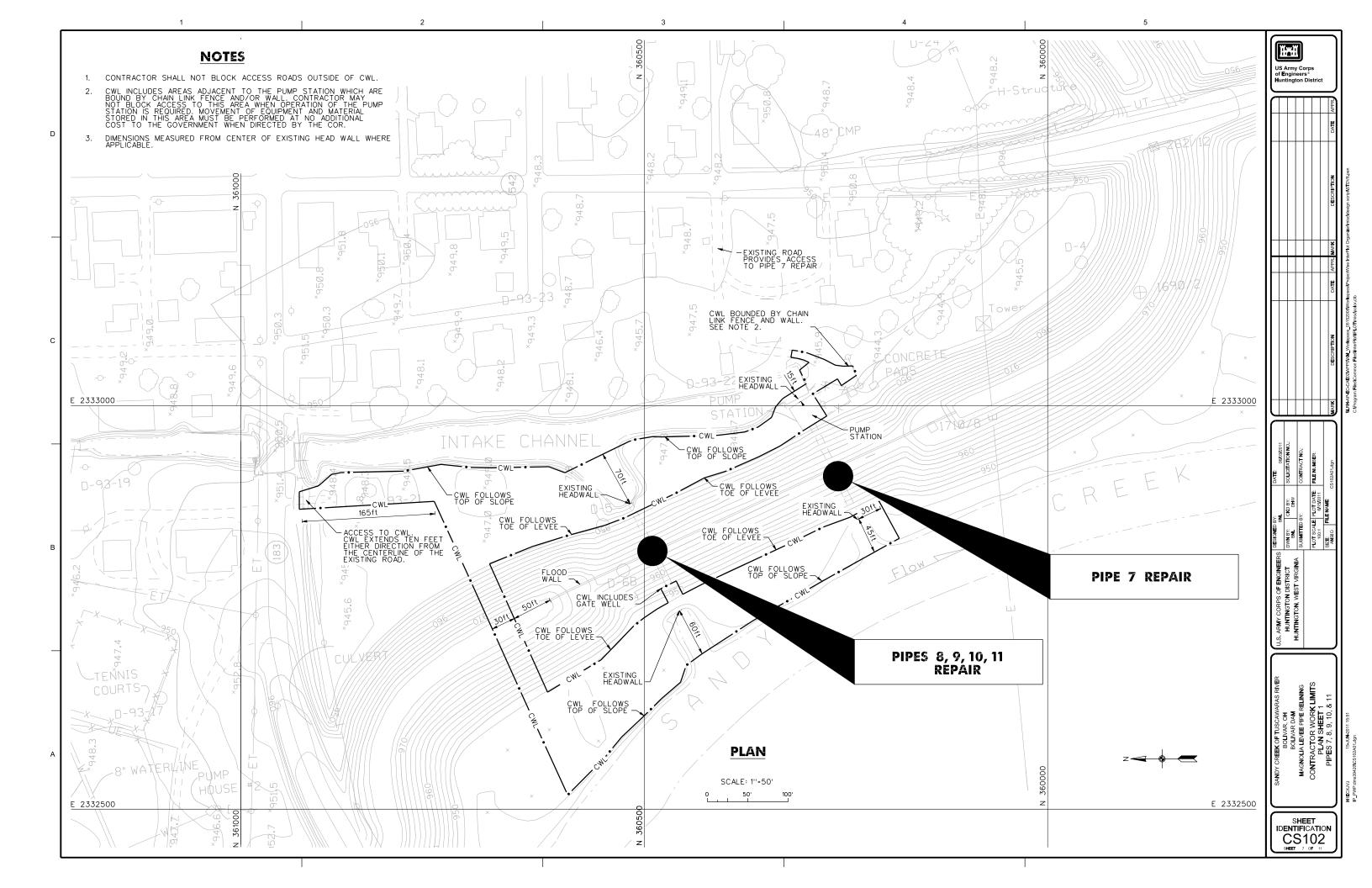


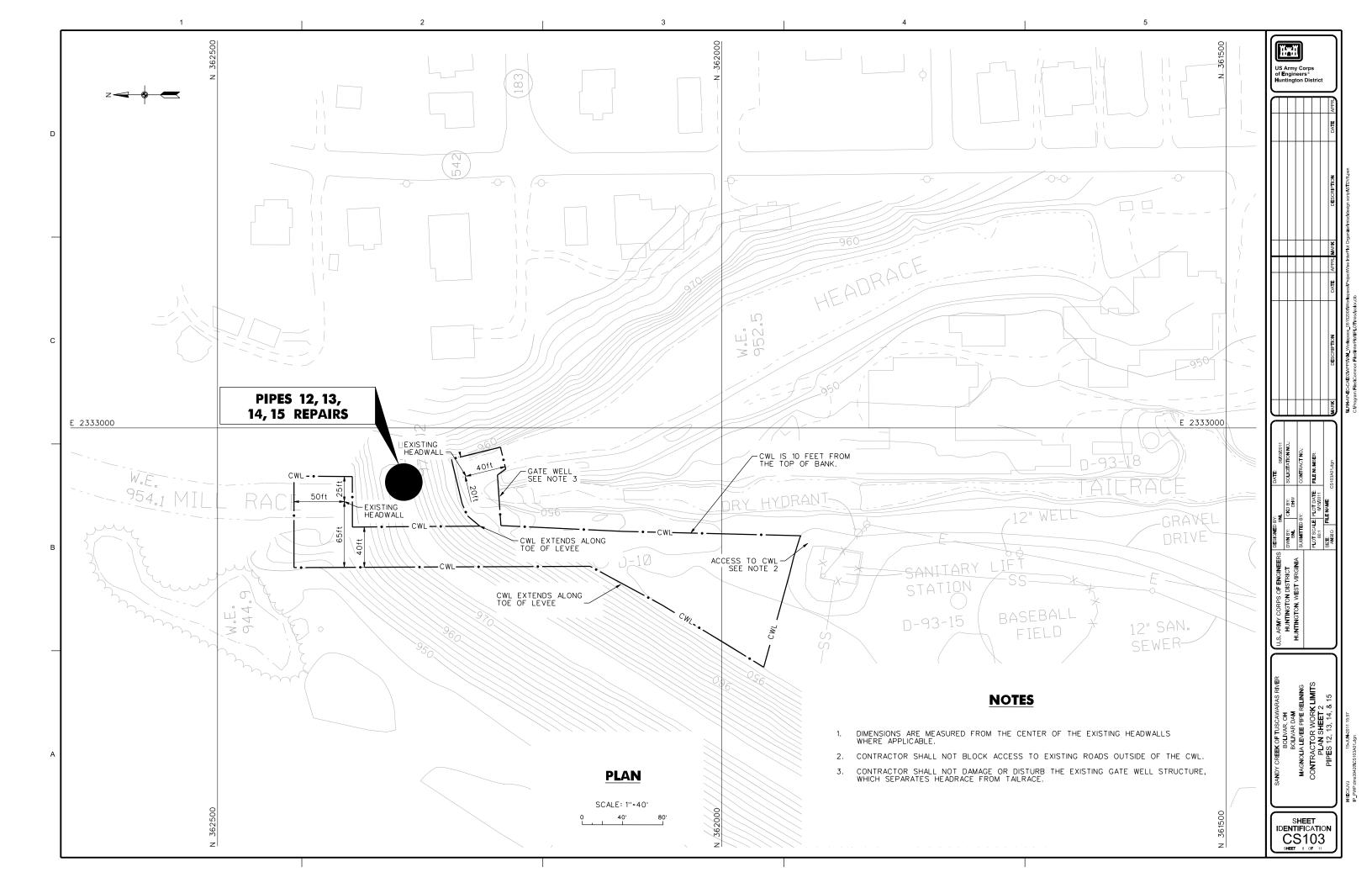












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- ALL SUBMITTALS SHALL BE SUBMITTED IN ACCORDANCE WITH PARAGRAPH 'SUBMITTAL PROCEDURES' IN SPECIFICATION SECTION 09 97 02, 'PAINTING, HYDRAULIC STRUCTURES'.
- THE COMPLETED STRUCTURES SHALL BE CLEANED AND PAINTIED IN ACCORDANCE WITH SPECIFICATION SECTION 09 97 02, 'PAINTING: HYDRAULIC STRUCTURE'.
- 3. ALL STRUCTURAL STEEL SHALL CONFORM TO ASTM A572, GR 50, UNLESS OTHERWISE NOTED.
- DRAWING REQUIREMENTS

SUBMIT FABRICATION DRAWINGS, ANSI 'D' SIZE, FOR APPROVAL PRIOR TO FABRICATION. PREPARED IN ACCORDANCE WITH AISC 326, AISC 316 AND AISC 317, FABRICATION DRAWINGS SHALL NOT BE REPRODUCTIONS OF CONTRACT DRAWINGS. INCLUDE COMPLETE INFORMATION FOR THE FABRICATION AND ERECTION OF THE STRUCTURE'S COMPONENTS, INCLUDING THE LOCATION, TYPE, AND SIZE OF BOLTS, WELDS, MEMBER SIZES AND LENGTHS, CONNECTION DETAILS, BLOCKS, COPES, AND CUTS, USE AWS A2.4 STANDARD WELDING SYMBOLS, MEMBER SUBSTITUTIONS OF DETAILS SHOWN ON THE CONTRACT DRAWINGS SHALL BE CLEARLY HIGHLIGHTED ON THE FABRICATION DRAWINGS. EXPLAIN THE REASONS FOR ANY DEVIATIONS FROM THE CONTRACT DRAWINGS.

- MATERIAL ORDERS THE CONTRACTOR SHALL FURNISH FOUR COPIES OF PURCHASE ORDERS, MILL ORDERS, SHOP ORDERS AND WORK ORDERS FOR ALL MATERIALS ORDERS AND ITEMS USED IN THE WORK, WHERE MILL TESTS ARE REQUIRED PURCHASE ORDERS SHALL CONTAIN THE TEST SITE ADDRESS AND THE NAME OF THE TESTING AGENCY.
- REPORTS OF MATERIAL THE CONTRACTOR SHALL FURNISH THE CONTRACTING OFFICER A CERTIFICATE FROM THE MILL STATING, FOR EACH ARTICLE (SHEET, PLATE, BAR, SHAPE, ETC.,) TO BE SUPPLIED TO THE FABRICATION, THE HEAT NUMBER AND THE CHEMICAL AND PHYSICAL PROPERTIES OF THE METAL FROM WHICH THE ARTICLE IS TO DE MADE
- - STRUCTURAL FABRICATION MATERIAL MUST BE STRAIGHT BEFORE BEING LAID OFF OR WORKED. IF STRAIGHTENING IS NECESSARY IT SHALL BE DONE BY METHODS THAT WILL NOT IMPAIR THE METAL. SHARP KINKS OR BENDS SHALL BE CAUSE FOR REJECTION OF THE MATERIAL. MATERIAL WITH WELDS WILL NOT BE ACCEPTED EXCEPT WHERE WELDING IS DEFINITELY SPECIFIED. INDICATED OR OTHERWISE APPROVED. WHERE HEATING IS REQUIRED. PRECAUTIONS SHALL BE TAKEN TO AVOID OVERHEATING THE METAL AND IT SHALL BE ALLOWED TO COOL IN A MANNER THAT WILL NOT IMPAIR THE ORIGINAL PROPERTIES OF THE METAL. SHEARING SHALL BE ACCURATE AND ALL PORTIONS OF THE WORK SHALL BE NEATLY FINISHED. CORNERS SHALL BE SQUARE AND TRUE UNLESS OTHERWISE SHOWN. RE-ENTRANT CUTS SHALL BE FILLETED TO A MINIMUM RADIUS OF 3/4 INCH UNLESS OTHERWISE APPROVED. FINISHED MEMBERS SHALL BE FREE OF TWISTS. BENDS AND OPEN JOINTS.
 - DIMENSIONAL TOLERANCES FOR STRUCTURAL WORK DIMENSIONS SHALL BE MEASURED BY AN APPROVED CALIBRATED STEEL TAPE OF APPROXIMATELY THE SAME TEMPERATURE AS THE MATERIAL BEING MEASURED. THE OVERALL DIMENSIONS OF AN ASSEMBLED STRUCTURAL UNIT SHALL BE WITHIN AN ALLOWABLE VARIATION OF 3/32 INCH.
 - STRUCTURAL STEEL FABRICATION STRUCTURAL STEEL MAY BE CUT BY MECHANICALLY GUIDED OR HAND-GUIDED TORCHES. PROVIDED AN ACCURATE PROFILE WITH A SURFACE THAT IS SMOOTH AND FREE FROM CRACKS AND NOTCHES IS OBTAINED. SURFACES AND EDGES TO BE WELDED SHALL BE PREPARED IN ACCORDANCE WITH AWS DI.I. SUBSECTION 5.15. WHERE STRUCTURAL STEEL IS NOT TO BE WELDED. CHIPPING OR GRINDING WILL NOT BE REQUIRED EXCEPT AS NECESSARY TO REMOVE SLAG AND SHARP EDGES OF MECHANICALLY GUIDED OR HAND-GUIDED CUTS NOT EXPOSED TO VIEW. HAND-GUIDED CUTS WHICH ARE TO BE EXPOSED OR VISIBLE SHALL BE CHIPPED. GROUND OR MACHINED TO SOUND METAL.
- DO NOT COMMENCE WELDING UNTIL WELDING PROCEDURES, INSPECTORS, NONDESTRUCTIVE TESTING PERSONNEL. WELDERS, WELDING OPERATORS, AND TACKERS HAVE BEEN QUALIFIED AND THE SUBMITTALS APPROVED BY THE CONTRACTING OFFICER AND THE DESIGN ENGINEER OF RECORD.
- WELDER, WELDING OPERATOR, AND TACKER QUALIFICATION
 - EACH WELDER, WELDING OPERATOR, AND TACKER ASSIGNED TO WORK ON THIS CONTRACT MUST BE QUALIFIED IN ACCORDANCE WITH THE APPLICABLE REQUIREMENTS OF AWS DI.I. WELDERS, WELDING OPERATORS, AND TACKERS WHO MAKE ACCEPTABLE PROCEDURE QUALIFICATION TEST WELDS WILL BE CONSIDERED QUALIFIED FOR THE WELDING PROCEDURE USED.
 - PREVIOUS PERSONNEL QUALIFICATIONS AT THE DISCRETION OF THE CONTRACTING OFFICER, WELDERS, WELDING OPERATORS, AND TACKERS QUALIFIED BY TEST WITHIN THE PREVIOUS 6 MONTHS MAY BE ACCEPTED FOR THIS CONTRACT WITHOUT RE-QUALIFICATION IF ALL THE FOLLOWING CONDITIONS ARE MET:
 - COPIES OF THE WELDING PROCEDURE SPECIFICATIONS, THE PROCEDURE OUALIFICATION TEST RECORDS. AND THE WELDER, WELDING OPERATOR, AND TACKER DUALIFICATION TEST RECORDS ARE SUBMITTED AND APPROVED IN ACCORDANCE WITH THE SPECIFIED REQUIREMENTS FOR DETAIL DRAWINGS.
 - TESTING WAS PERFORMED BY AN APPROVED TESTING LABORATORY, TECHNICAL CONSULTANT, OR THE CONTRACTOR'S APPROVED QUALITY CONTROL ORGANIZATION.
 - THE PREVIOUSLY QUALIFIED WELDING PROCEDURE CONFORMS TO THE REQUIREMENTS OF THIS SPECIFICATION AND IS APPLICABLE TO WELDING CONDITIONS ENCOUNTERED UNDER THIS CONTRACT.
 - THE WELDER. WELDING OPERATOR, AND TACKER QUALIFICATION TESTS CONFORM TO THE REQUIREMENTS OF THIS SPECIFICATION AND ARE APPLICABLE TO WELDING CONDITIONS ENCOUNTERED UNDER THIS CONTRACT.
 - CERTIFICATES. BEFORE ASSIGNING ANY WELDER, WELDING OPERATOR, OR TACKER TO WORK UNDER THIS CONTRACT. SUBMIT THE NAMES OF THE WELDERS, WELDING OPERATORS, AND TACKERS TO BE EMPLOYED. AND CERTIFICATION THAT EACH INDIVIDUAL IS QUALIFIED AS SPECIFIED. THE CERTIFICATION MUST STATE THE TYPE OF WELDING AND POSITIONS FOR WHICH THE WELDER. WELDING OPERATOR. OR TACKER IS QUALIFIED. THE CODE AND PROCEDURE UNDER WHICH THE INDIVIDUAL IS QUALIFIED. THE DATE QUALIFIED. AND THE NAME OF THE FIRM AND PERSON CERTIFYING THE QUALIFICATION TESTS. KEEP THE CERTIFICATION CURRENT, ON FILE, AND FURNISH 3 COPIES.

- RENEWAL OF QUALIFICATION RE-QUALIFICATION OF A WELDER OR WELDING OPERATOR IS REQUIRED UNDER ANY OF THE FOLLOWING CONDITIONS:
 - IT HAS BEEN MORE THAN 6 MONTHS SINCE THE WELDER OR WELDING OPERATOR HAS USED THE SPECIFIC WELDING PROCESS FOR WHICH HE IS QUALIFIED.
 - THERE IS SPECIFIC REASON TO QUESTION THE WELDER OR WELDING OPERATOR'S ABILITY TO MAKE WELDS THAT MEET THE REQUIREMENTS OF THESE SPECIFICATIONS.
 - THE WELDER OR WELDING OPERATOR WAS QUALIFIED BY AN EMPLOYER OTHER THAN THOSE FIRMS PERFORMING WORK UNDER THIS CONTRACT. AND A QUALIFICATION TEST HAS NOT BEEN TAKEN WITHIN THE PAST 12 MONTHS. SUBMIT AS EVIDENCE OF CONFORMANCE ALL RECORDS SHOWING PERIODS OF EMPLOYMENT, NAME OF EMPLOYER WHERE WELDER. OR WELDING OPERATOR, WAS LAST EMPLOYED, AND THE PROCESS FOR WHICH QUALIFIED.
 - A TACKER WHO PASSES THE QUALIFICATION TEST IS CONSIDERED ELIGIBLE TO PERFORM TACK WELDING INDEFINITELY IN THE POSITIONS AND WITH THE PROCESSES FOR WHICH HE IS QUALIFIED, UNLESS THERE IS SOME SPECIFIC REASON TO QUESTION THE TACKER'S ABILITY. IN SUCH A CASE, THE TACKER IS REQUIRED TO PASS THE PRESCRIBED TACK WELDING TEST.
- 10. INSPECTOR QUALIFICATION

ALL PERSONNEL PERFORMING NON-DESTRUCTIVE INSPECTION SHALL BE CERTIFIED UNDER ASNT-RP SNT-TC-1A WITHIN A PERIOD OF 1 YEAR BEFORE THE DATE OF CONTRACT FOR LEVELS 1 OR 11 IN THE APPLICABLE NON-DESTRUCTIVE TESTING METHOD. THE INSPECTIOR MAY BE SUPPORTED BY ASSISTANT WELDING INSPECTIORS WHO ARE NOT OUALIFIED TO ASNT RP SNT-TC-1A. AND ASSISTANT INSPECTIORS MAY PERFORM SPECIFIC INSPECTION FUNCTIONS UNDER THE SUPERVISION OF THE OUALIFIED INSPECTOR. OTHER OUALIFICATIONS OF CERTIFICATION MAY BE ACCEPTED AT THE CONTRACTION OFFICER'S DISCRETION. QUALIFIED INSPECTORS SHALL BE ABLE TO JUDGE THE ACCEPTABILITY OR NON-ACCEPTABILITY OF WELDS IN CONFORMANCE WITH THE REQUIREMENTS OF AWS DI.5.

- - SAFE WELDING PRACTICES AND SAFETY PRECAUTIONS DURING WELDING MUST CONFORM TO AWS Z49.1.
- 12. WELDING EQUIPMENT AND MATERIALS ALL WELDING EQUIPMENT, ELECTRODES, WELDING WIRE, AND FLUXES MUST BE CAPABLE OF PRODUCING SATISFACTORY WELDS WHEN USED BY A QUALIFIED WELDEN OR WELDING OPERATOR PERFORMING QUALIFIED WELDING PROCEDURES, ALL WELDING EQUIPMENT AND MATERIALS SHALL COMPLY WITH THE APPLICABLE REQUIREMENTS OF AWS DI.S.
- 13. WELDING OPERATIONS
 - A. WELDING OF STRUCTURAL STEEL
 - WELDING PROCEDURES FOR STRUCTURAL STEEL WELDING PROCEDURES FOR STRUCTURAL STEEL SHALL BE PREQUALIFIED AS DESCRIBED IN AWS D1.5. THE CONTRACTOR SHALL SUBMIT A COMPLETE SCHEDULE OF WELDING PROCEDURES FOR EACH STEEL STRUCTURE TO BE WELDED. THE SCHEDULE 15. SHALL CONFORM TO THE REQUIREMENTS SPECIFIED IN THE PROVISIONS AWS D1.1. SUBSECTION 4.1 OR SHALL BE QUALIFIED BY TESTS AS PRESCRIBED IN AWS D1.1 SECTION 4. THE SCHEDULE SHALL PROVIDE DETAILED PROCEDURE SPECIFICATIONS AND TABLES OR DIAGRAMS SHOWING THE PROCEDURES TO BE USED FOR EACH REQUIRED JOINT. WELDING 16. PROCEDURES MINCHAEL STRUCTURE THE PROVIDED SPECIFICATIONS OF RECHEAT. AND INTERPASS TEMPERATURE REQUIREMENTS. EACH WELDING PROCEDURE SHALL BE CLEARLY IDENTIFIED AS BEING PREQUALIFIED OR REQUIRED TO BE QUALIFIED BY TESTS. WELDING PROCEDURES MUST SHOW TYPES AND LOCATIONS OF WELDS DESIGNATED OR IN THE SPECIFICATIONS TO RECEIVE NONDESTRUCTIVE EXAMINATION.
 - WELDING PROCESS WELDING OF STRUCTURAL STEEL SHALL BE BY AN ELECTRIC ARC WELDING PROCESS USING A METHOD WHICH EXCLUDES THE ATMOSPHERE FROM THE MOLITEN METAL AND SHALL CONFORM TO THE APPLICABLE PROVISIONS OF AWS DI.5. WELDING SHALL BE SUCH AS TO 17. MINIMIZE RESIDUAL STRESSES, DISTORTION AND SHRINKAGE.
 - WELDING TECHNIQUE
 - A. FILLER METAL THE ELECTRODE, ELECTRODE-FLUX COMBINATION AND GRADE OF WELD METAL SHALL CONFORM TO THE APPROPRIATE AWS SPECIFICATION FOR THE BASE METAL AND WELDING PROCESS BEING USED OR SHALL BE AS SHOWN WHERE A SPECIFIC CHOICE OF AWS SPECIFICATION ALLOWABLES IS REOUIRED. THE AWS DESIGNATION OF THE ELECTRODES TO BE USED SHALL BE INCLUDED IN THE SCHEDULE OF WELDING PROCEDURES, ONLY LOW HYDROGEN ELECTRODES SHALL BE USED FOR MANUAL SHIELDED METAL-ARC WELDING REGARDLESS OF THE THICKNESS OF THE STEEL, A CONTROLLED TEMPERATURE STORAGE OVEN SHALL BE USED AT THE JOB SITE 492. PRESCRIBED BY AWS DI.5, SUBSECTION 4.5 TO MAINTAIN LOW MOISTURE OF LOW HYDROGEN ELECTRODES.
 - PREHEAT AND INTERPASS TEMPERATURE PREHEATING SHALL BE 19. PERFORMED AS REQUIRED BY AWS DI.5. SUBSECTION 4.2 AND 5.6 OR AS OTHERWISE SPECIFIED EXCEPT THAT THE TEMPERATURE OF THE BASE METAL SHALL BE AT LEAST 70 DEGREES F. THE WELDMENTS TO BE PREHEATED SHALL BE SLOWLY AND UNIFORMLY HEATED BY APPROVED MEANS TO THE PRESCRIBED TEMPERATURE. HELD AT THAT TEMPERATURE UNTIL THE WELDING IS COMPLETED AND THEN PERMITTED TO COOL SLOWLY IN STILL AIR.
 - WORKMANSHIP . WORKMANSHIP FOR WELDING SHALL BE IN ACCORDANCE WITH AWS DIS. SECTION 3 AND OTHER APPLICABLE PROVISIONS OF THESE REGUIREMENTS.
 - PREPARATION OF BASE METAL PRIOR TO WELDING THE CONTRACTOR SHALL INSPECT SURFACES TO BE WELDED TO ASSURE COMPLIANCE WITH AWS 01.5, SUBSECTION 3.2.
 - TEMPORARY WELDS TEMPORARY WELDS REQUIRED FOR FABRICATION AND ERECTION SHALL BE MADE UNDER THE CONTROLLED CONDITIONS PRESCRIBED FOR PERMANENT WORK, TEMPORARY WELDS SHALL BE MADE USING LOW HYDROGEN WELDING ELECTRODES AND BY WELDERS QUALIFIED FOR PERMANENT WORK AS SPECIFIED IN THESE SPECIFICATIONS, PREHEATING FOR TEMPORARY WELDS SHALL BE AS REQUIRED BY AWS DI, I FOR PERMANENT WELDS EXCEPT THAT THE MINIMUM TEMPERATURE SHALL BE 120 DEGREES F IN ANY CASE. IN MAKING TEMPORARY WELDS ARCS SHALL NOT BE STRUCK IN OTHER THAN WELD LOCATIONS, EACH TEMPORARY WELD SHALL BE REMOVED AND GROUND FLUSH WITH ADJACENT SURFACES AFTER SERVING ITS PURPOSE.

- TACK WELDS TACKS WELDS THAT ARE TO BE INCORPORATED INTO THE PERMANENT WORK SHALL BE SUBJECT TO THE SAME QUALITY REQUIREMENTS AS THE PERMANENT WELDS AND SHALL BE CLEANED AND THOROUGHLY FUSED WITH PERMANENT WELDS. PREHEATING SHALL BE PERFORMED AS SPECIFIED ABOVE FOR TEMPORARY WELDS. MULTIPLE-PASS TACK WELDS SHALL HAVE CASCADED ENDS. DEFECTIVE TACK WELDS SHALL BE REMOVED BEFORE PERMANENT WELDING.
- IDENTIFICATION IDENTIFY ALL WELDS IN ONE OF THE FOLLOWING WAYS:
 - A. SUBMIT WRITTEN RECORDS TO INDICATE THE LOCATION OF WELDS MADE BY EACH WELDER, WELDING OPERATOR, OR TACKER.
 - IDENTIFY ALL WORK PERFORMED BY EACH WELDER, WELDING OPERATOR. OR TACKER WITH AN ASSIGNED NUMBER. LETTER, OR SYMBOL TO IDENTIFY WELDS MADE BY THAT INDIVIDUAL, THE CONTRACTING OFFICER MAY REQUIRE WELDERS. WELDING OPERATORS, AND TACKERS TO APPLY THEIR SYMBOL NEXT TO THE WELD BY MEANS OF RUBBER STAMP, FELT-TIPPED MARKER WITH WATERPROOF INK. OR OTHER METHODS THAT DO NOT CAUSE AN INDENTATION IN THE METAL. PLACE THE IDENTIFICATION MARK FOR SEAM WELDS ADJACENT TO THE WELD AT 3 FOOT INTERVALS, IDENTIFICATION WITH DIE STAMPS OR ELECTRIC ETCHERS IS NOT ALLOWED.

- NONDESTRUCTIVE EXAMINATION THE WELDING IS SUBJECT TO INSPECTION AND TESTS. WHEN MATERIALS OR WORKMANSHIP DO NOT CONFORM TO THE SPECIFICATION REQUIREMENTS, THE GOVERNMENT RESERVES THE RIGHT TO REJECT MATERIAL OR WORKMANSHIP OR BOTH AT ANY TIME BEFORE FINAL ACCEPTANCE OF THE STRUCTURE CONTAINING THE WELDMENT.
- PERFORM TESTING USING AN APPROVED INSPECTION OR TESTING LABORATORY OR TECHNICAL CONSULTANT, OR IF APPROVED. THE CONTRACTOR'S INSPECTION AND TESTING PERSONNEL MAY BE USED INSTEAD OF THE COMMERCIAL INSPECTION OR TESTING LABORATORY OR TECHNICAL CONSULTANT.
- PERFORM 100% VISUAL INSPECTION OF ALL COMPLETED WELDS. ALL COMPLETED WELDS SHALL BE CLEANED AND CAREFULLY EXAMINED FOR INSUFFICIENT THROAT OR LEG SIZES, CRACKS, UNDERCUTTING, OVERLAP, EXCESSIVE CONVEXITY OR REINFORCEMENT AND OTHER SUFFACE DEFECTS TO ENSURE COMPLIANCE WITH THE REQUIREMENTS OF AWS D1.5, SECTION 6.
- MAGNETIC PARTICLE INSPECTION OF THE WELDS AND EXTENT IDENTIFIED ON THE CONTRACT DRAWINGS TO DETERMINE CONFORMANCE WITH PARAGRAPH STANDARDS OF ACCEPTANCE. CONFORM PROCEDURES AND TECHNIQUES FOR INSPECTION WITH APPLICABLE REQUIREMENTS OF AWS DI.5 AND ASTM E 709.
- ULTRASONIC TESTING MAKING, EVALUATING AND REPORTING ULTRASONIC TESTING OF WELDS SHALL CONFORM TO THE REQUIREMENTS OF AWS DI.1. SECTION 6. PART C. THE ULTRASONIC COULTMENT SHALL BE CAPABLE OF MAKING A PERMANENT RECORD OF THE TEST INDICATIONS. A RECORD SHALL BE MADE OF EACH WELD TESTED.
- STANDARDS OF ACCEPTANCE DIMENSIONAL TOLERANCES FOR WELDED CONSTRUCTION.
 DETAILS OF WELDS. AND QUALITY OF WELDS WITH THE APPLICABLE REQUIREMENTS
 OF AWS D1.5 AND THE CONTRACT DRAWINGS. WELDS NOT PASSING SHALL
 BE REMOVED. REWELDED AND RETESTED TO ENSURE CONFORMANCE.
- GOVERNMENT INSPECTION AND TESTING IN ADDITION TO THE INSPECTION AND TESTS PERFORMED BY THE CONTRACTOR FOR QUALITY CONTROL. THE GOVERNMENT MAY PERFORM INSPECTION AND TESTING FOR ACCEPTANCE TO THE EXTENT DETERMINED BY THE CONTRACTING OFFICER. THE COSTS OF SUCH INSPECTION AND TESTING WILL BE BORNE BY THE CONTRACTOR IF UNSATISFACTORY WELDS ARE DISCOVERED, OR BY THE GOVERNMENT IF THE WELDS ARE SATISFACTORY. THE WORK MAY BE PERFORMED BY THE GOVERNMENT'S OWN FORCES OR UNDER A SEPARATE CONTRACT FOR INSPECTION AND TESTING. THE GOVERNMENT RESERVES THE RIGHT TO PERFORM SUPPLEMENTAL NONDESTRUCTIVE AND DESTRUCTIVE TESTS TO DETERMINE COMPLIANCE WITH PARAGRAPH STANDARDS OF ACCEPTANCE.
- STANDARDS OF ACCEPTANCE.

 CORRECTIONS AND REPAIRS IF INSPECTION OR TESTING INDICATES DEFECTS
 IN THE WELD JOINTS, REPAIR DEFECTIVE WELDS USING A QUALIFIED WELDER OR
 WELDING OPERATOR AS APPLICABLE. CONDUCT CORRECTIONS IN ACCORDANCE WITH
 AWS DI.1 AND THE PROVISIONS OF THESE REQUIREMENTS, REPAIR ALL DEFECTS
 IN ACCORDANCE WITH THE APPROVED PROCEDURES. WHEREVER A DEFECT IS REMOVED
 AND REPAIR BY WELDING IS NOT REQUIRED. BLEND THE AFFECTED AREA INTO THE
 SURROUNDING SURFACE TO ELIMINATE SHARP NOTCHES. CREVICES. OR CORNERS. AFTER
 A DEFECT IS THOUGHT TO HAVE BEEN REMOVED, AND BEFORE RE WELDING, EXAMINE
 THE AREA BY SUITABLE METHODS TO ENSURE THAT THE DEFECT HAS BEEN ELIMINATED,
 REPAIRED WELDS SHALL MEET THE INSPECTION REQUIREMENTS FOR THE ORIGINAL
 WELDS. ANY INDICATION OF A DEFECT IS REGARDED AS A DEFECT, UNLESS

 RE-EVALUATION BY NONDESTRUCTIVE METHODS OR BY SURFACE CONDITIONING SHOWS
 THAT NO UNACCEPTABLE DEFECT IS PRESENT.

ANY MODIFICATIONS OR ADDITIONS TO THE CONTRACT PLANS SHALL BE SUBMITTED TO THE CONTRACTING OFFICER FOR APPROVAL.

FRACTURE CRITICAL MEMBERS (DENOTED F.C.M.)

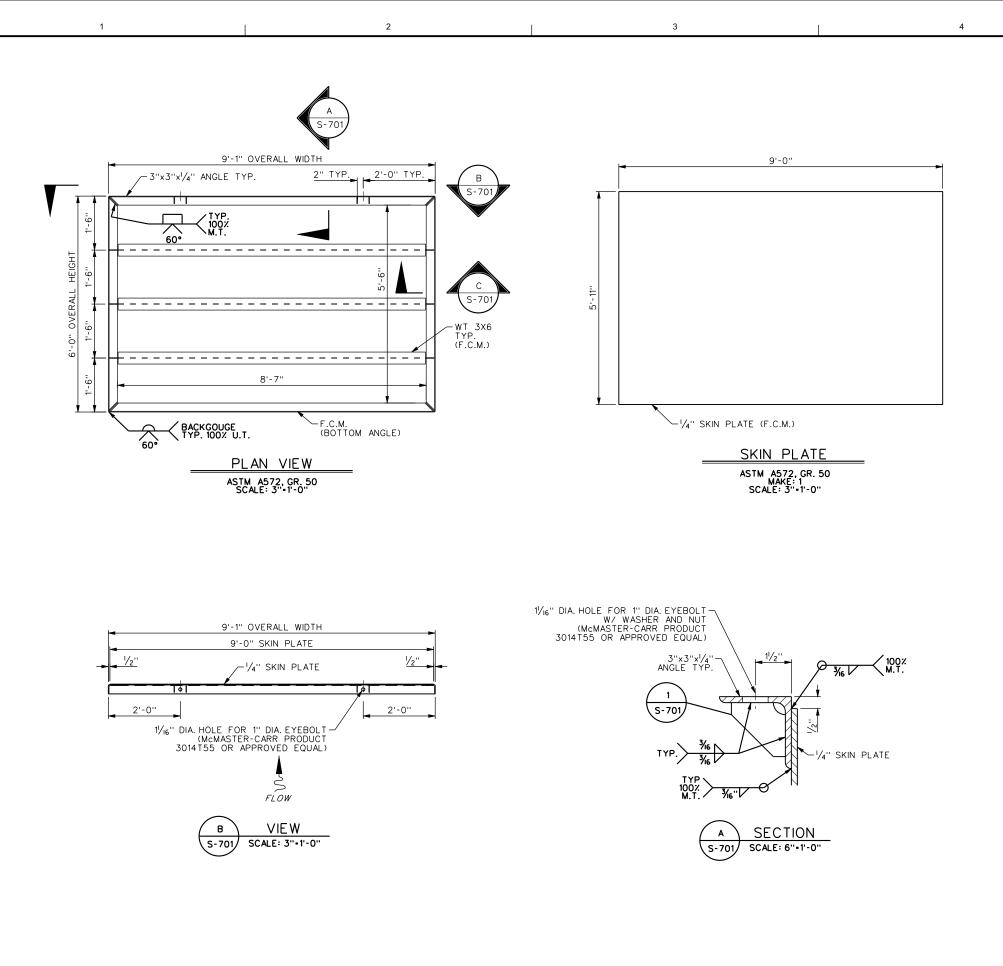
- A. ALL MATERIAL FOR F.C.M. SHALL HAVE A MINIMUM AVERAGE CHARPY
 V-NOTCH (CVN) FRACTURE TOUGHNESS VALUE OF 25 FT-LB WHEN TESTED AT
 40 DEGREES F. NO INDIVIDUAL CVN VALUE SHALL BE LESS THAN 20 FT-LB.
 TESTING SHALL BE PERFORMED IN ACCORDANCE WITH ASTM A673.
- MEMBERS IDENTIFIED ON THE DRAWINGS AS F.C.M. SHALL BE SUBJECT TO THE ADDITIONAL PROVISIONS OF AWS D1.5 SECTON 12. ALL OTHER PROVISIONS OF AWS D1.5 SHALL APPLY TO THE CONSTRUCTION OF F.C.M. S.EXCEPT AS MODIFIED OR SUPPLEMENTED IN AWS D1.5 SECTION 12.

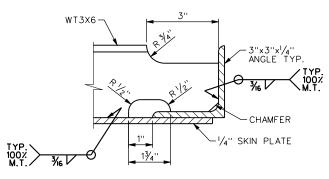
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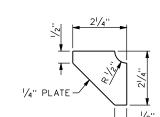
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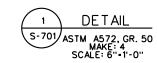
SHEET IDENTIFICATION S-001





SECTION SCALE: 6"-1'-0"





- GENERAL NOTES:
 1. CONTRACTOR SHALL PROVIDE A TOTAL OF THREE (3) BULKHEADS. QUANTITIES SHOWN ARE FOR ONE (1) BULKHEAD.
- 2. ALL MATERIAL SHALL MEET THE REQUIREMENTS OF ASTM A572, GR. 50.
- 3. ALL WELDS SHALL BE MADE USING E70XX ELECTRODES.
- 4. ALL THREE (3) BULKHEADS SHALL BE PAINTED PER SPECIFICATIONS SECTION 09 97 02.
- 5. FRACTURE CRITICAL MEMBERS (DENOTED F.C.M.) ALL MATERIAL FOR F.C.M. SHALL HAVE A MINIMUM AVERAGE CHARPY V-NOTCH (CVN) FRACTURE TOUGHNESS VALUE OF 25 FT-LB WHEN TESTED AT 40 DEGREES F. NO INDIVIDUAL CVN VALUE SHALL BE LESS THAN 20 FT-LB. TESTING SHALL BE IN ACCORDANCE WITH ASTM A673.

SHEET S-701