

1. INSTALL TEMPORARY SUPPORT
2. REMOVE SECONDARY MEMBERS AS NECESSARY IF APPLICABLE
- 3A. SAW OR FLAME CUT TO REMOVE DAMAGED FLANGE USING A MECHANICAL GUIDE
- 3B. IF THE CRACK EXTENDS BEYOND THE REMOVAL LIMITS SHOWN REMOVE THE ENTIRE WIDTH OF FLANGE. REMOVE THE WEB WELDS OR WEB MATERIAL AS REQUIRED TO DEVELOP A CONTINUOUS COMPLETE PENETRATION FLANGE WELD. SEE WEB COPE AND REMOVAL DETAILS ON COLLISION REPAIR PLAN INSERT SHEET WCI OR BCI.
4. PREPARE EXISTING FLANGE FOR A COMPLETE PENETRATION WELD BY EDGE BEVELING.
5. PREPARE NEW FLANGE MATERIAL THAT MATCHES THE THICKNESS OF THE EXISTING PLATE BY EDGE BEVELING
6. ERECT NEW FLANGE AND CHECK FIT UP, NO GAP EXCEEDING 1/16", TACK WELD PLATE IN PLACE
7. PERFORM THE COMPLETE PENETRATION FLANGE WELDING ACCORDING TO C&MS 513.21 BY ATTACHING RUNOFF TABS, PERFORM WELDS, REMOVE THE TABS AND GRIND ALL WELDED SURFACES SMOOTH ACCORDING TO ANSI B46.1 OF 250 ml
8. PERFORM NDT TESTING ACCORDING TO C&MS 513.25A
9. REPAIR SECONDARY MEMBERS IF APPLICABLE

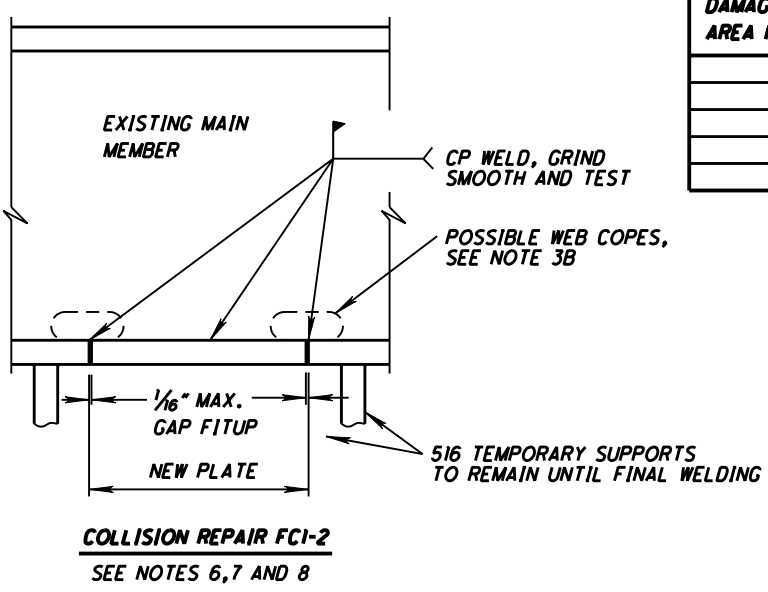
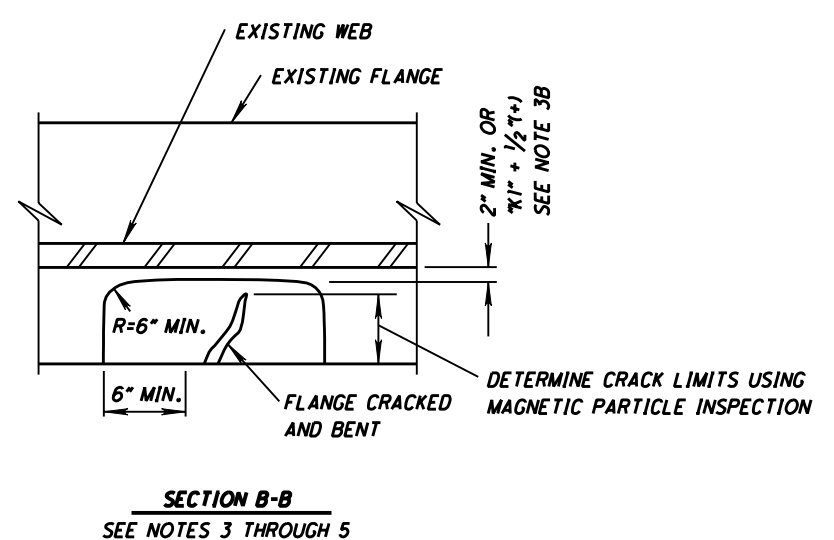
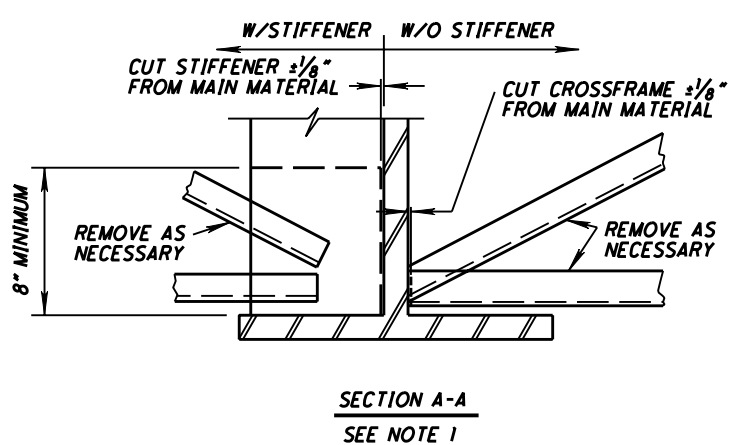
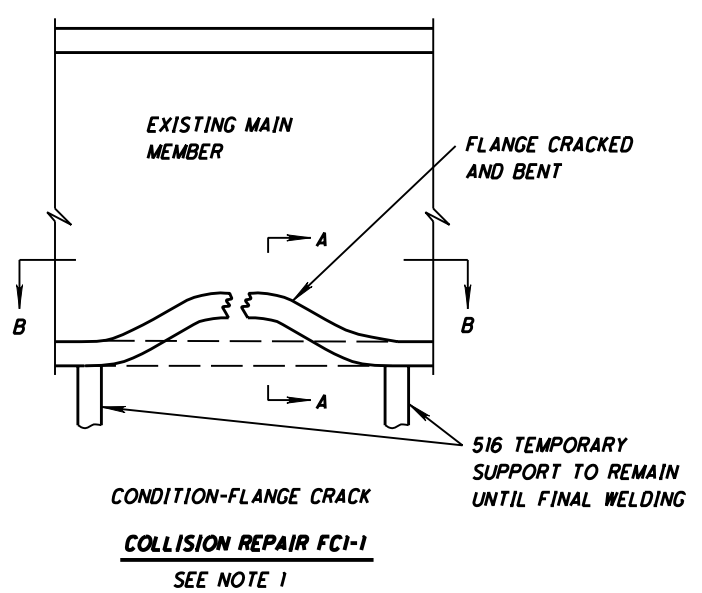


TABLE #3 513 REPAIRS

DAMAGED AREA No.	MEMBER LINE No. A	PIER OR ABUTMENT	DIM. C	REPAIR DETAIL TYPE	DRILLING HOLES (EACH)	COPE HOLES (EACH)	STEEL MEMBER LEVEL UP (POUNDS)	CP WELD (FEET)	FILLET WELD (FEET)
				FC1					

SEE PARTIAL FRAMING PLAN FOR DIMENSION C

