

LAST REVISED 12-16-2014

SR JOB NO. SHEET

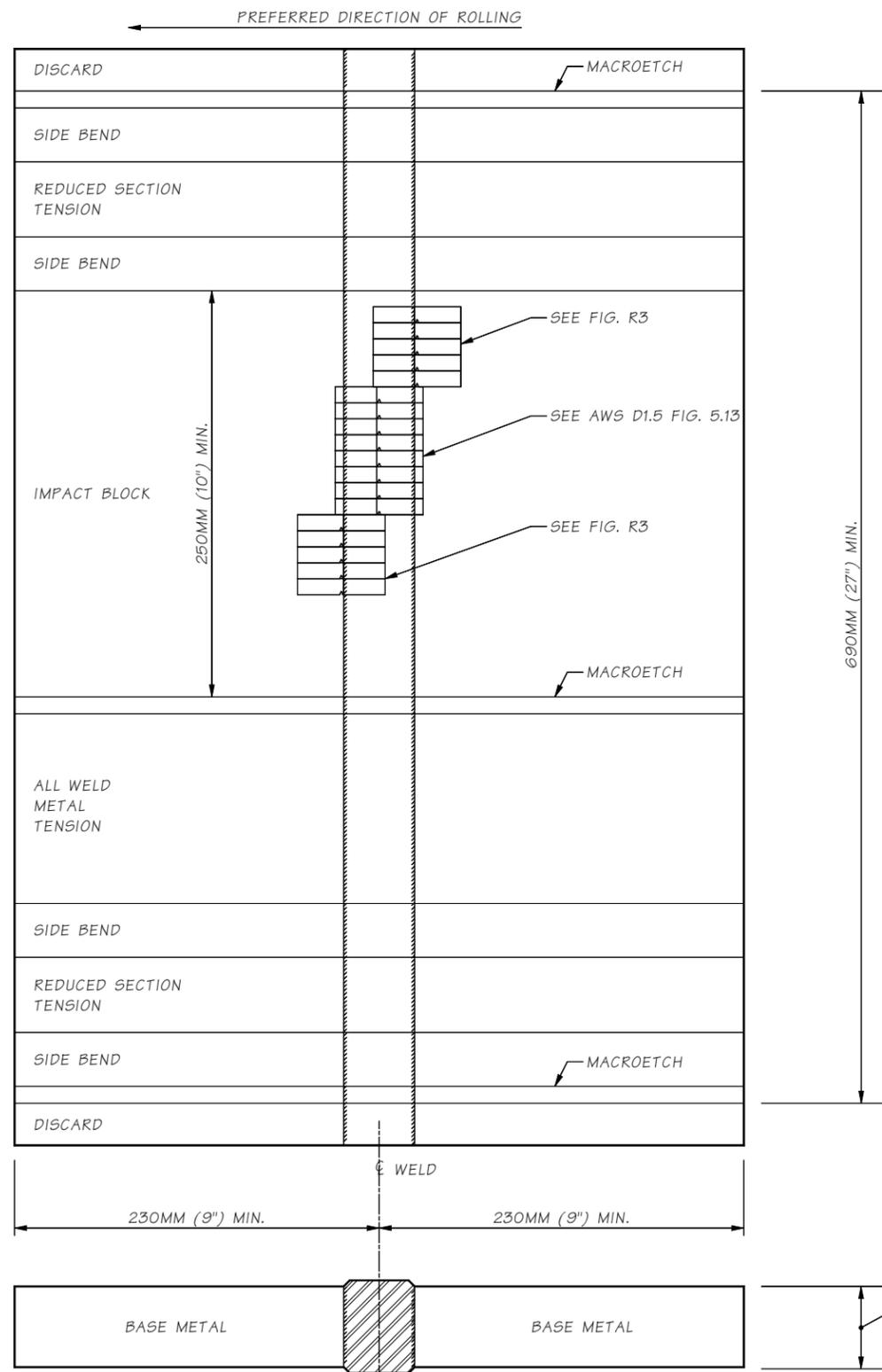
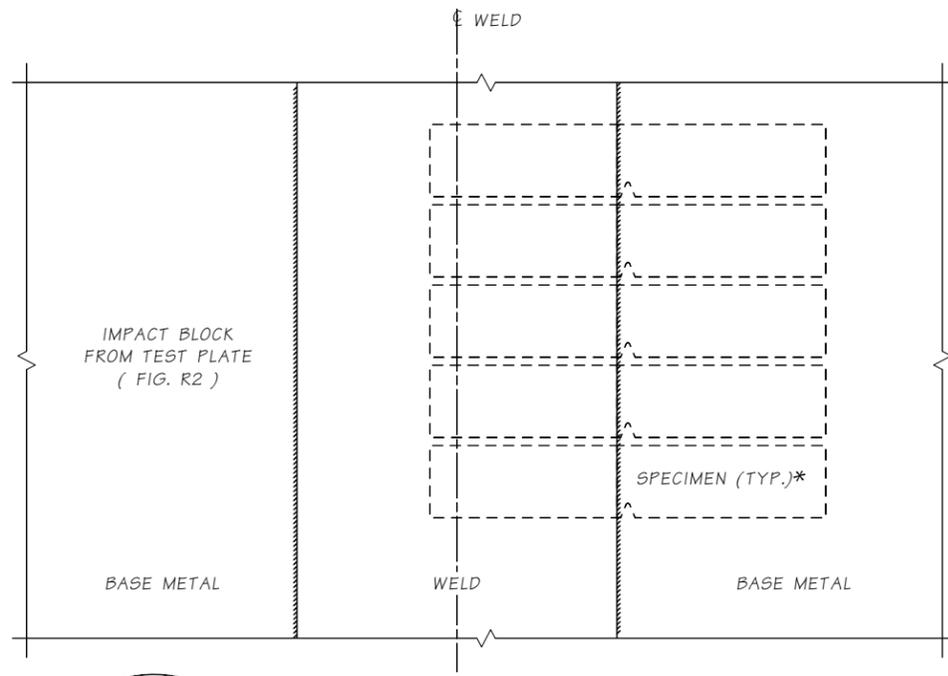


FIGURE R2

WPS QUALIFICATION OR PRETEST FOR NGI-ESW

NOTES

1. ALL DIMENSIONS IN MM (INCHES)
2. WELD METAL CVN SPECIMENS ARE LOCATED AT MID-THICKNESS.
3. HAZ CVN SPECIMENS ARE LOCATED AT 1/4 THICKNESS.



PERMISSABLE VARIATIONS

ADJACENT SIDES SHALL BE AT:	90° ± 10 MIN.
CROSS-SECTION DIMENSIONS:	± 0.025MM (± 0.001")
LENGTH OF SPECIMEN (L):	± 0, -2.5MM (± 0.100")
NOTCH LOCATION (d):	± 0, -1.5MM (± 0.060")
ANGLE OF NOTCH:	± 1°
RADIUS OF NOTCH:	± 0.025MM (± 0.001")
DIMENSIONS TO THE BOTTOM OF THE NOTCH: TYPE "A" SPECIMEN	2 ± 0.025MM (0.315" ± 0.001")
FINISH REQUIREMENTS:	ON OTHER TWO SURFACES
	ON OTHER TWO SURFACES
	2µm (± 63µin.)
	4µm (± 125µin.)

* FIVE TEST SPECIMENS ON ONE SIDE OF THE JOINT, LOCATION OF FIVE TEST SPECIMENS ON THE OTHER SIDE OF THE JOINT SIMILAR.

FIGURE R3

CVN IMPACT TEST SPECIMEN FOR TESTING THE HEAT-AFFECTED ZONE AT THE 1/4 THICKNESS LOCATION

Bridge Design Engr.	M:\STANDARDS\Structural Steel\564-A15.MAN				REGION NO.	STATE	FED. AID PROJ. NO.	SHEET NO.	TOTAL SHEETS
Supervisor					10	WASH.			
Designed By					JOB NUMBER				
Checked By									
Detailed By									
Bridge Projects Engr.									
Prelim. Plan By									
Architect/Specialist	DATE	REVISION	BY	APPD.					

Thu Jan 15 09:08:14 2015

BRIDGE AND STRUCTURES OFFICE



NGI-ESW CVN IMPACT TEST FOR HEAT AFFECTED ZONE

BRIDGE SHEET NO.
SHEET
OF
SHEETS