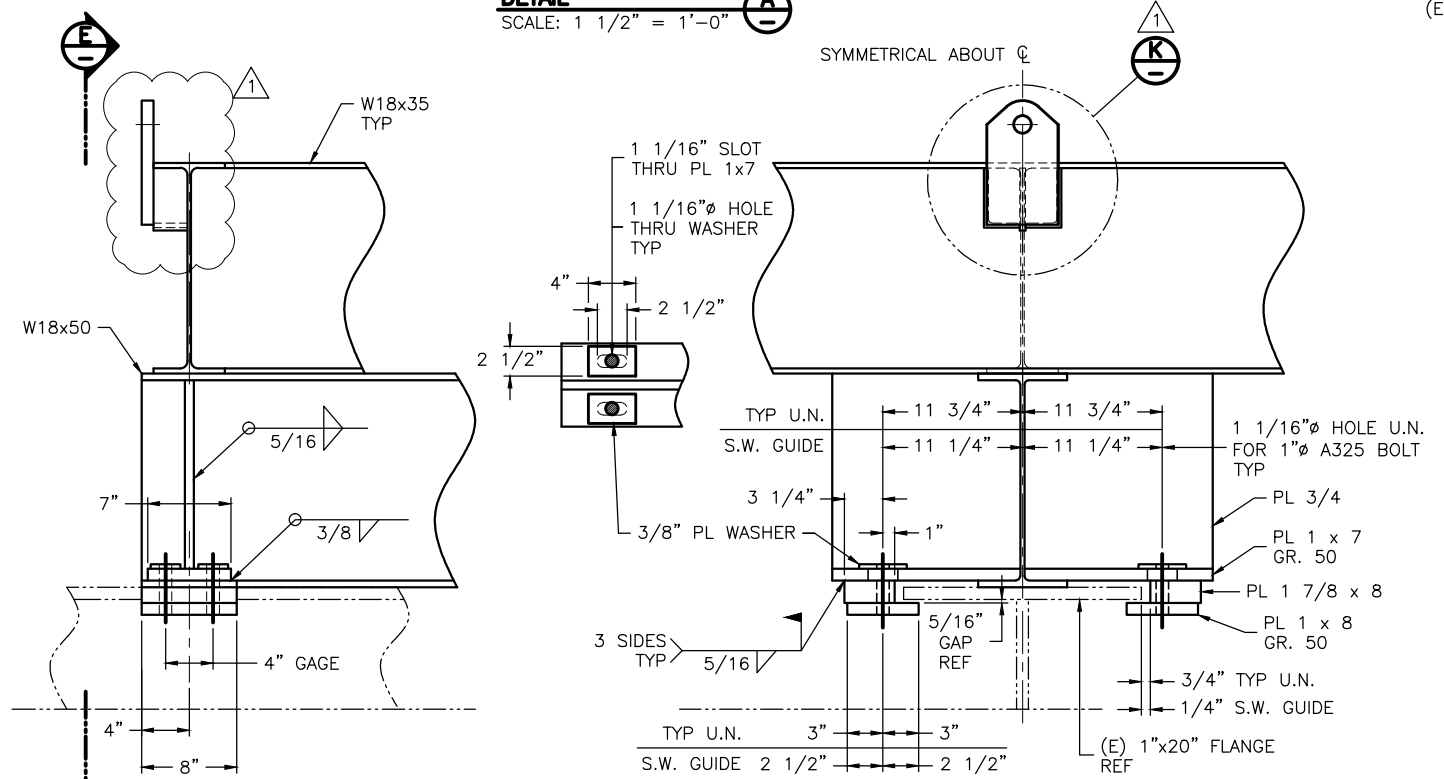
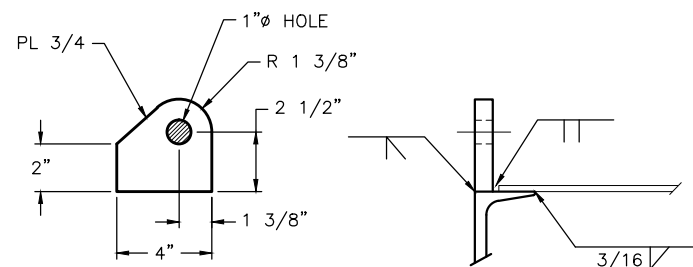


DETAIL
SCALE: 1 1/2" = 1'-0" **(A)**

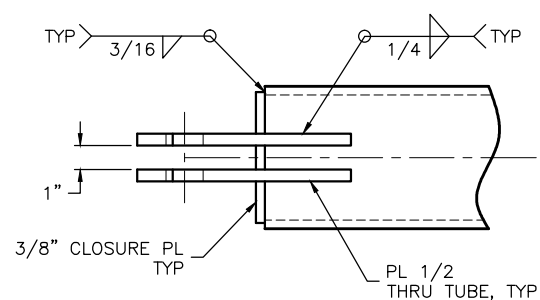


DETAIL
SCALE: 1 1/2" = 1'-0" **(D)**

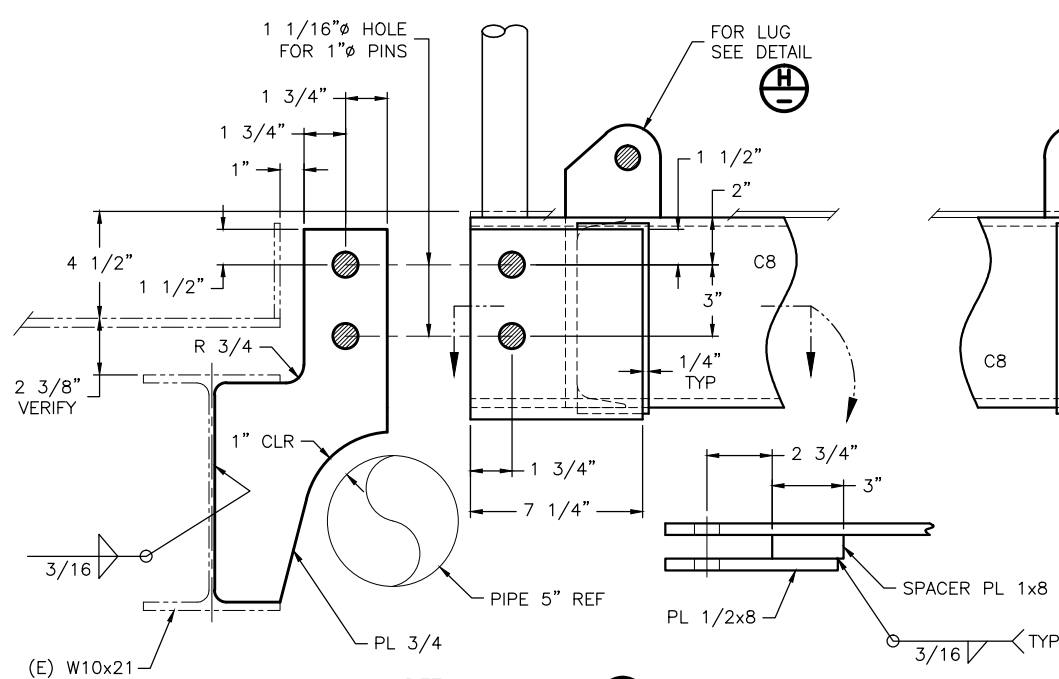
VIEW
SCALE: 1 1/2" = 1'-0" **(E)**



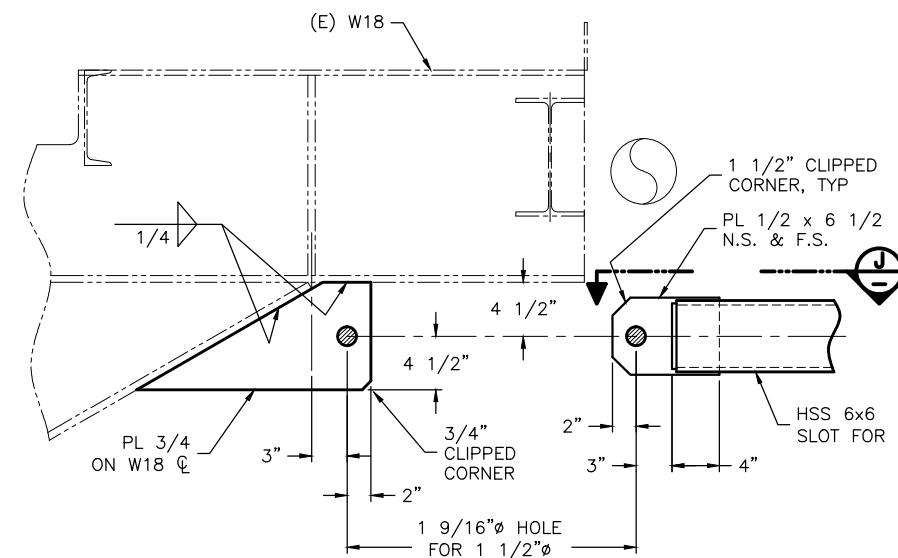
DETAIL
SCALE: 3" = 1'-0" **(H)**



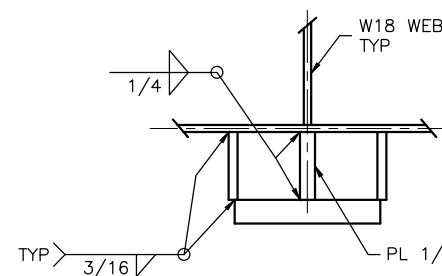
VIEW
SCALE: 3" = 1'-0" **(J)**



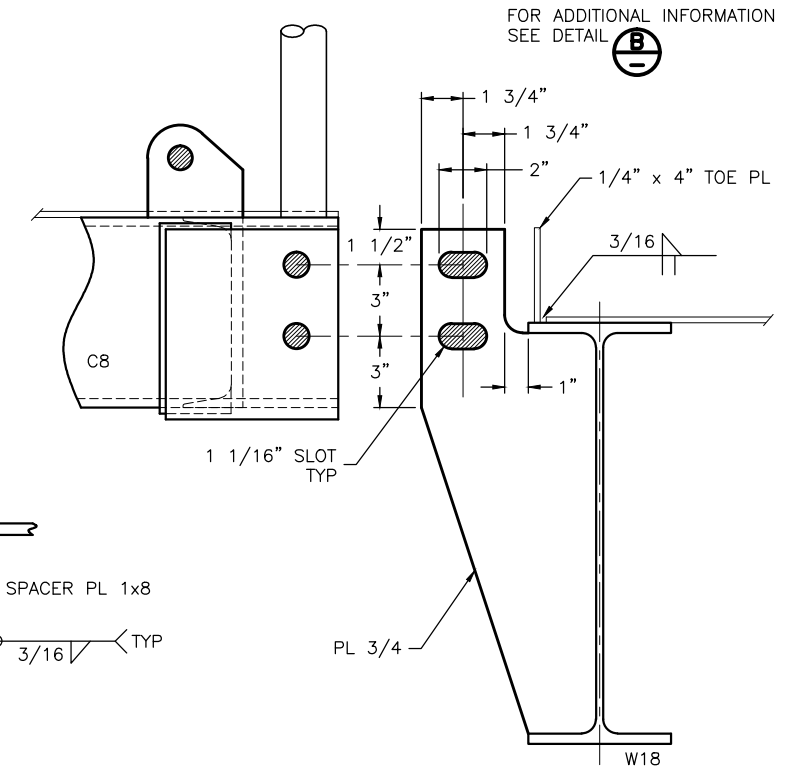
DETAIL
SCALE: 3" = 1'-0" **(B)**



DETAIL
SCALE: 1 1/2" = 1'-0" **(F)**

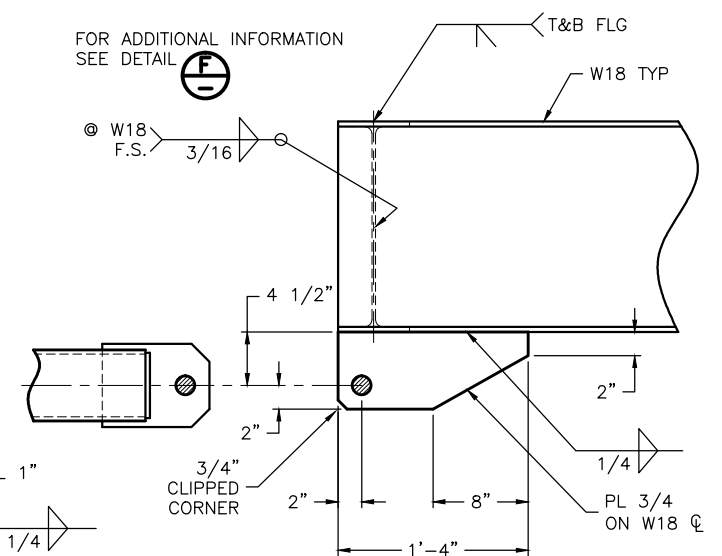


DETAIL
SCALE: 3" = 1'-0" **(K)**



DETAIL
SCALE: 3" = 1'-0" **(C)**

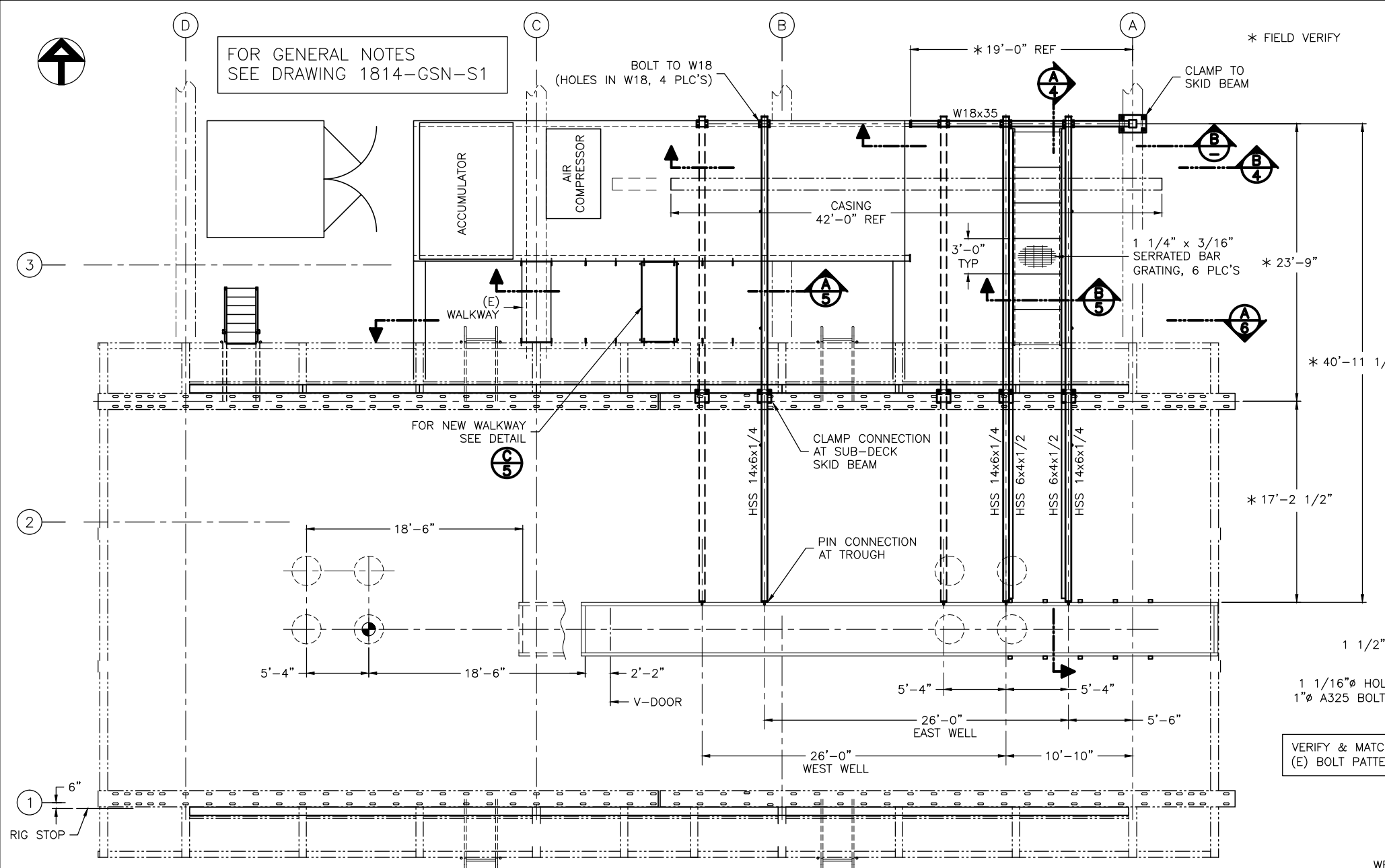
FOR ADDITIONAL INFORMATION SEE DETAIL **(F)**



DETAIL
SCALE: 1 1/2" = 1'-0" **(G)**

Rev	Date	Description	Rev By	Ckd By	App'd
0	4-23-13	ISSUED FOR CONSTRUCTION	RM	FC	RJB
1	4-29-13	ADD LIFT LUG, DETAIL K			

DRAWN BY: RM
CHECKED BY: FC
APP'D: RJB
SCALE: NOTED
DATE: 3-21-13
JOB NO.: 1814

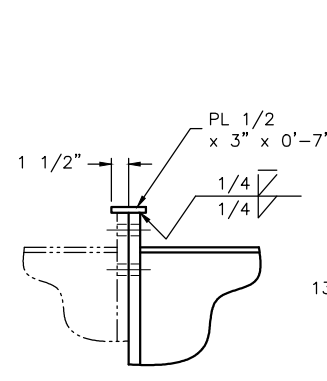


PLAN VIEW
SCALE: 3/16" = 1'-0"

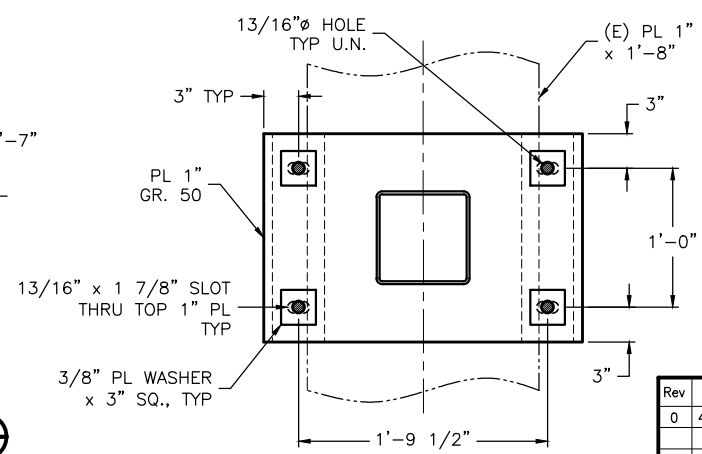
- Prepare the flanges of the beam with a 45 degree, full depth bevel.
- Fit up the end-plate and beam with a minimum root opening.
- Preheat the specimens as required by AWS specifications.
- Prepare the surfaces for welding as required by AWS specifications.
- Place the web welds (1).
- Place the 5/16 in. backing fillet welds on the beam web side of the beam flanges (2).
- Backgouge the root of the bevel to remove any contaminants from the 5/16 in. backing fillet welds (3).
- Place the flange groove welds (AWS TC-U4b-GP).

Fig. 2.10. Summary of recommended welding procedure.

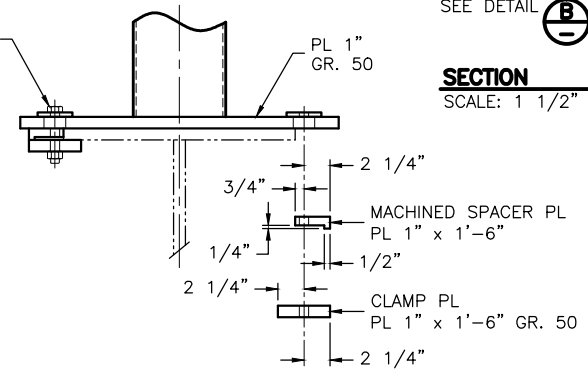
**DETAIL
AISC WELD PROCEDURE**
SCALE: NONE



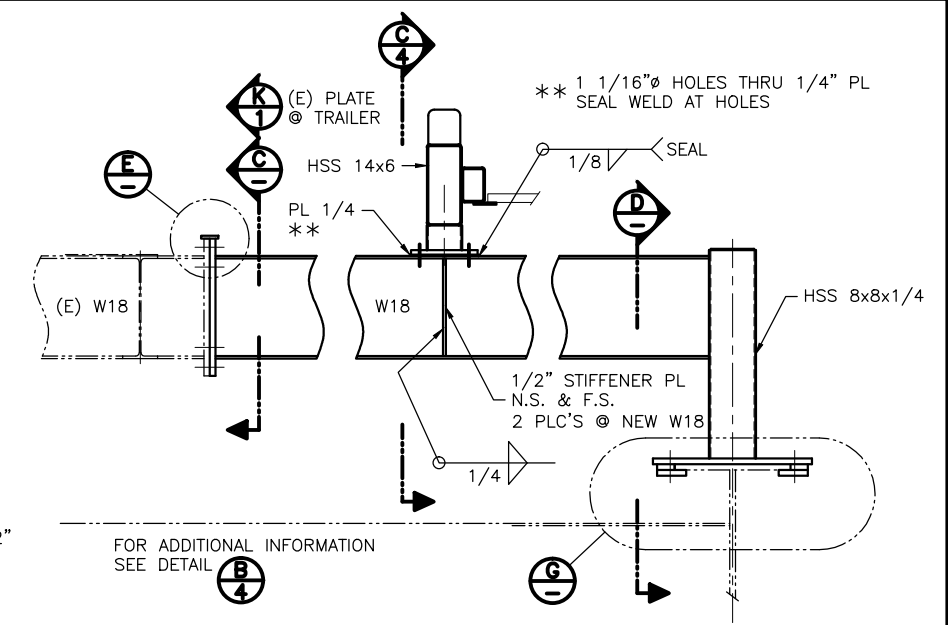
DETAIL
SCALE: 1 1/2" = 1'-0"



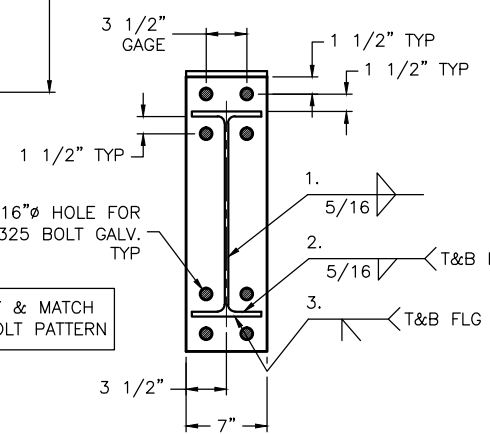
SECTION
SCALE: 1 1/2" = 1'-0"



DETAIL
SCALE: 1 1/2" = 1'-0"

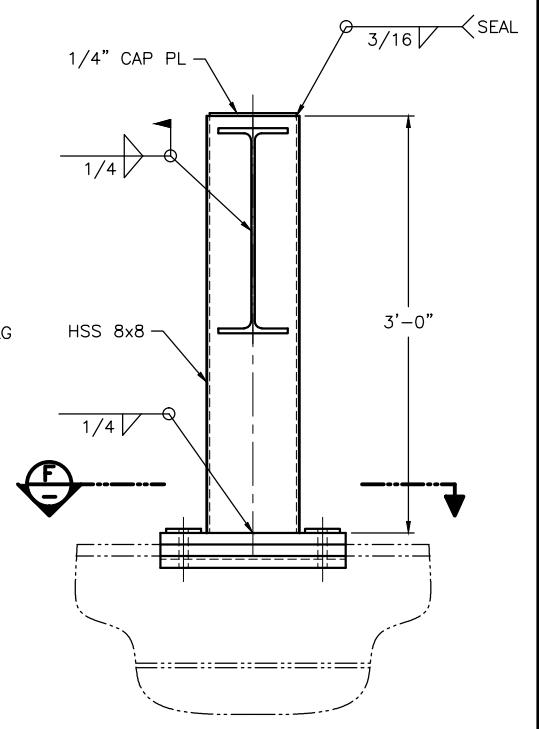


SECTION
SCALE: 3/4" = 1'-0"



WELD PER AISC RECOMMENDED PROCEDURE
SEE DETAIL

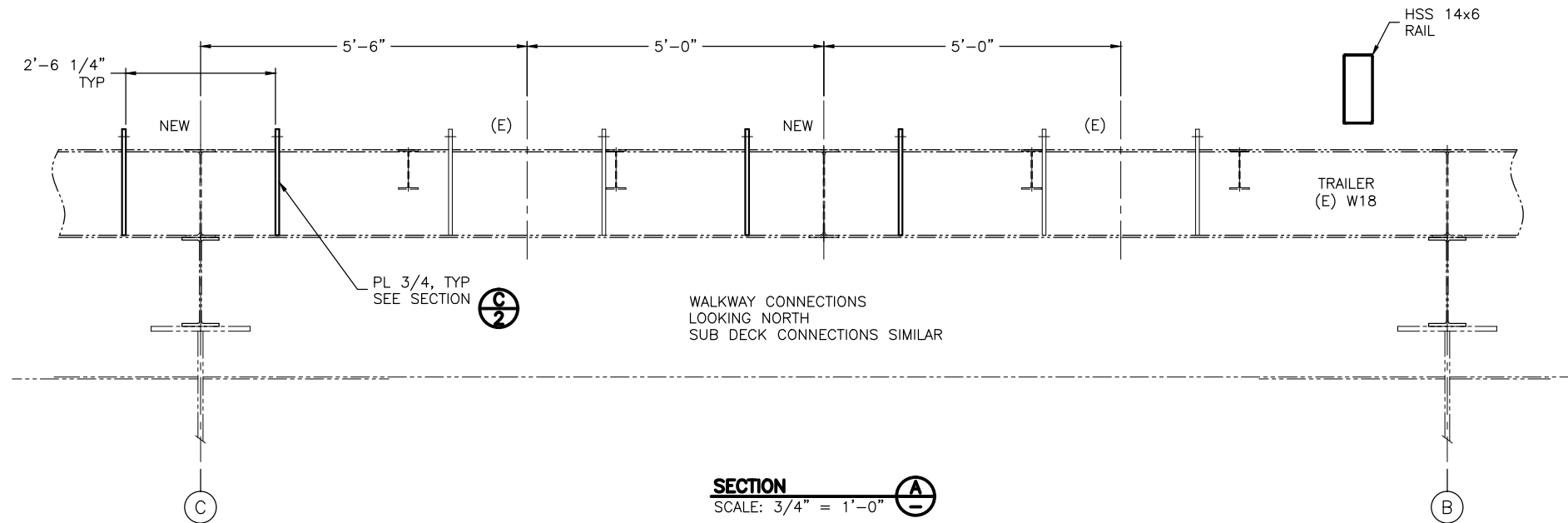
SECTION
SCALE: 1 1/2" = 1'-0"



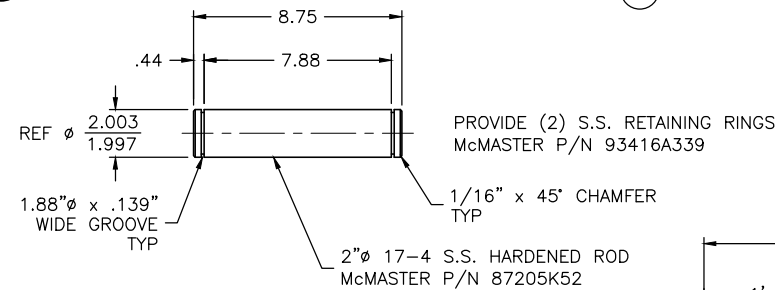
SECTION
SCALE: 1 1/2" = 1'-0"

Rev	Date	Description	Rev By	Ckd By	App'd
0	4-09-14	ISSUED FOR CONTRUCTION	RM	FC	RJB

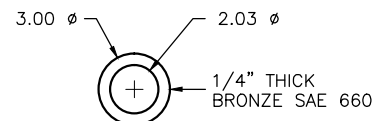
DRAWN BY: RM
CHECKED BY: FC
APP'D: RJB
SCALE: NOTED
DATE: 9-18-13
JOB NO.: 1814



SECTION
SCALE: 3/4" = 1'-0" **(A)**

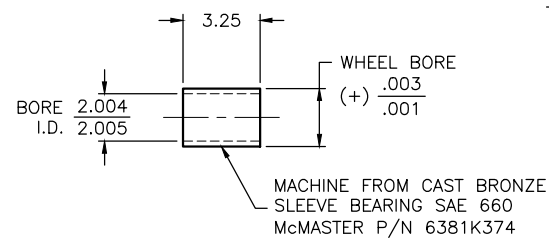


SHAFT DETAIL
SCALE: 3" = 1'-0" **(E)** QTY 4 EACH

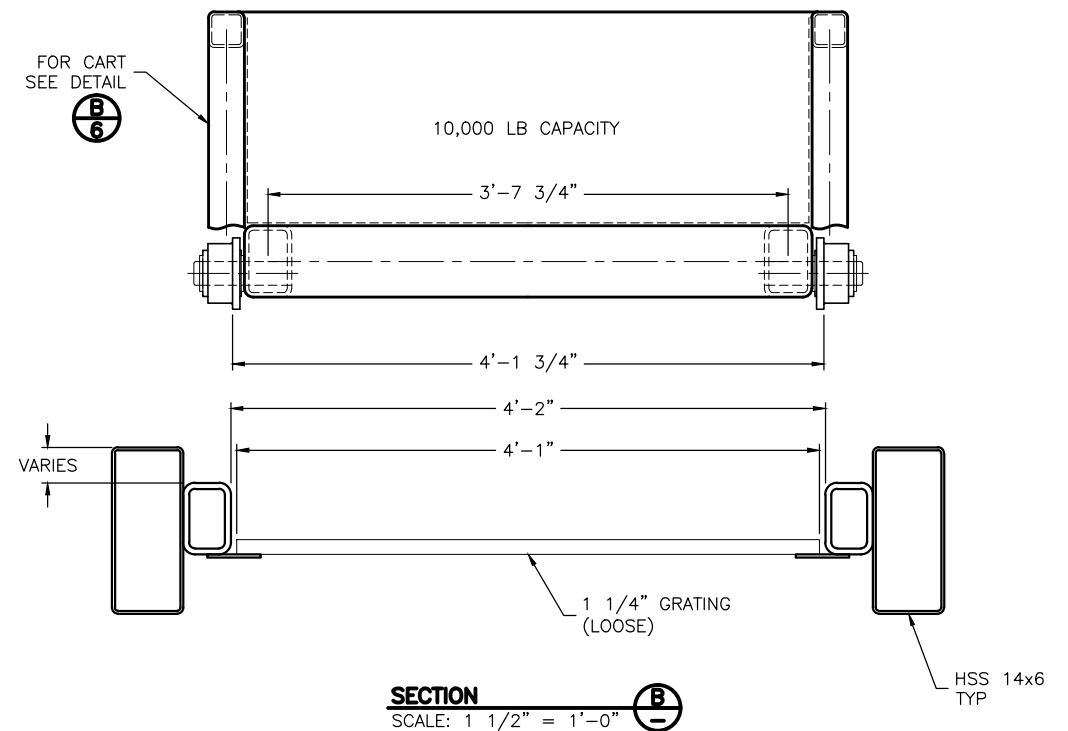


SPACER DETAIL
SCALE: 3" = 1'-0" **(F)** QTY 8 EACH

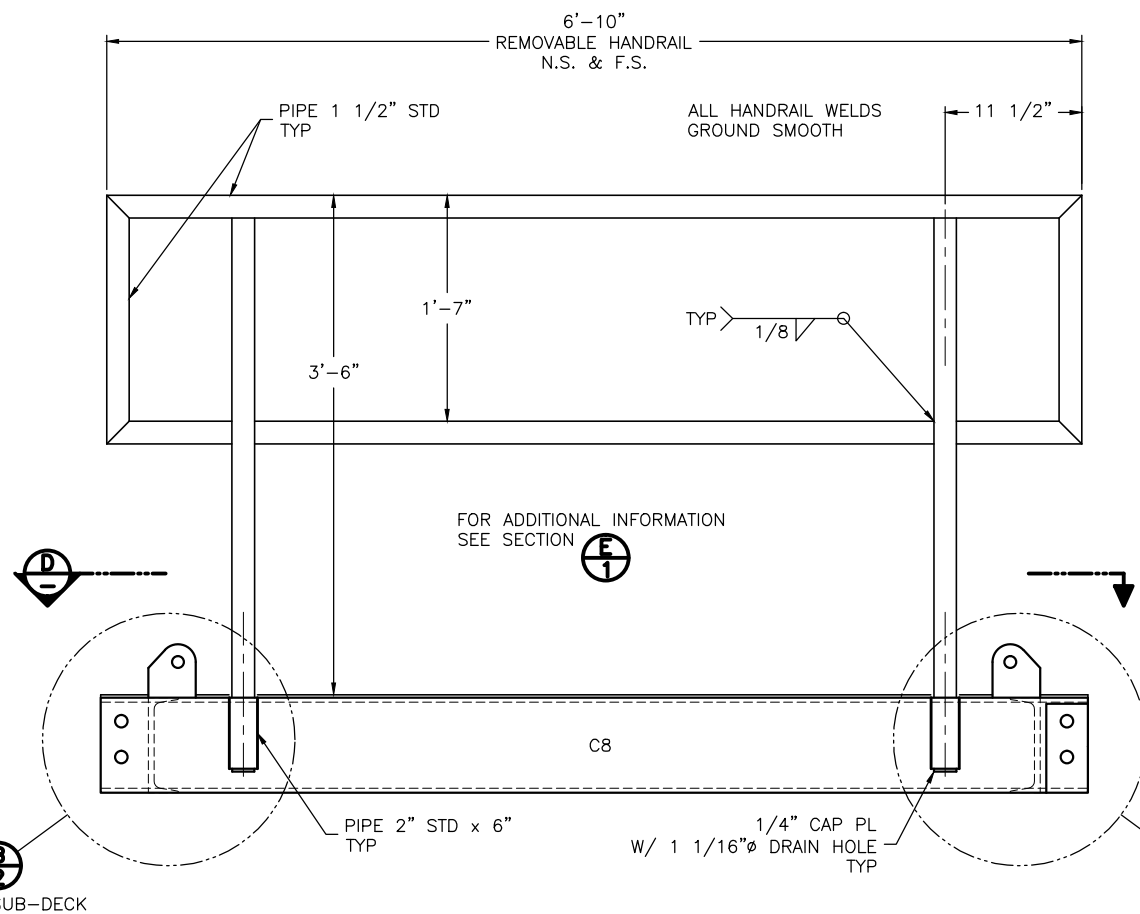
PRESS FIT SLEEVE BEARING IN WHEEL



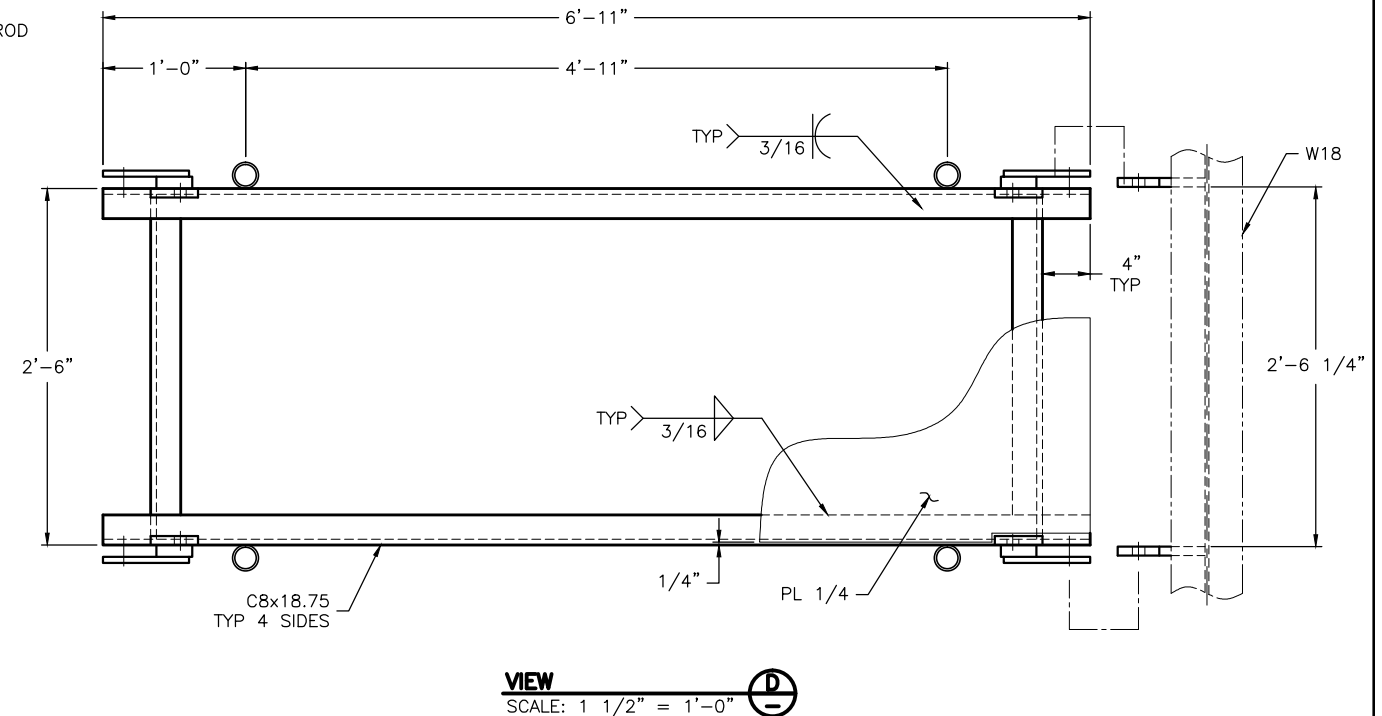
SLEEVE BEARING DETAIL
SCALE: 3" = 1'-0" **(G)** QTY 4 EACH



SECTION
SCALE: 1 1/2" = 1'-0" **(B)**



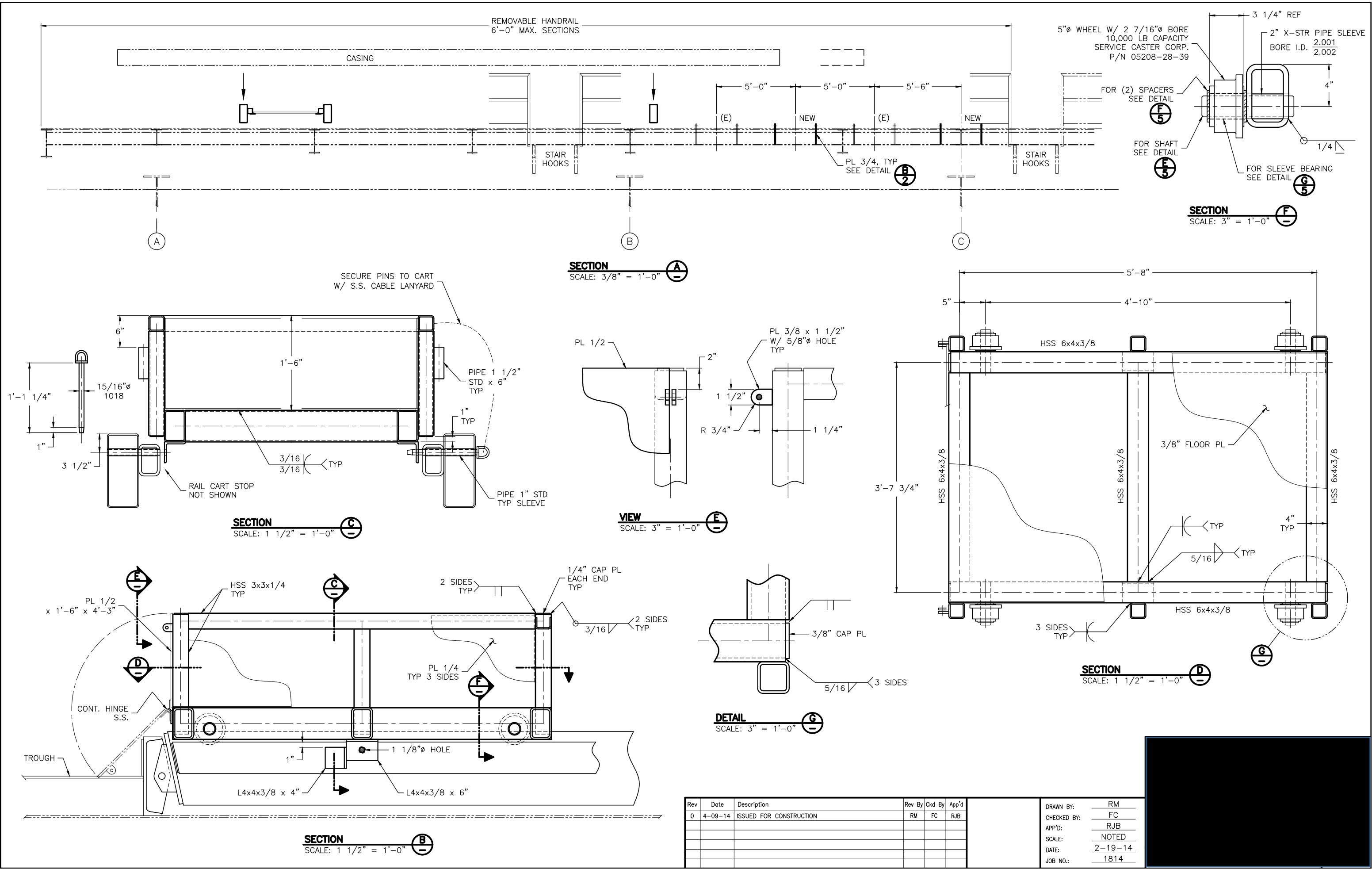
DETAIL
SCALE: 1 1/2" = 1'-0" **(C)**



VIEW
SCALE: 1 1/2" = 1'-0" **(D)**

Rev	Date	Description	Rev By	Ckd By	App'd
0	4-09-14	ISSUED FOR CONSTRUCTION	RM	FC	RJB

DRAWN BY: RM
CHECKED BY: FC
APP'D: RJB
SCALE: NOTED
DATE: 2-19-14
JOB NO.: 1814



Rev	Date	Description	Rev By	Ckd By	App'd
0	4-09-14	ISSUED FOR CONSTRUCTION	RM	FC	RJB

DRAWN BY:	RM
CHECKED BY:	FC
APP'D:	RJB
SCALE:	NOTED
DATE:	2-19-14
JOB NO.:	1814