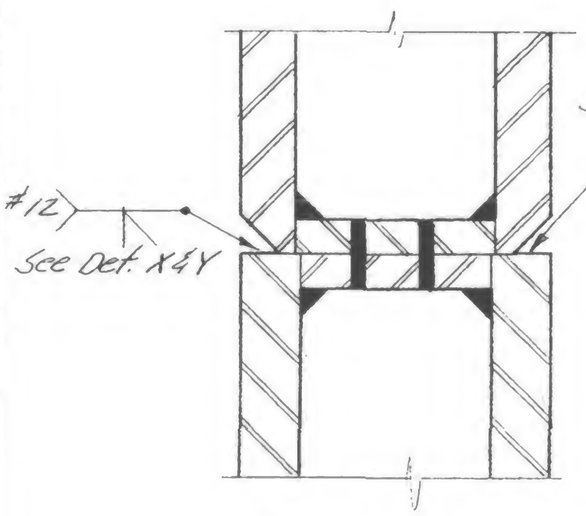
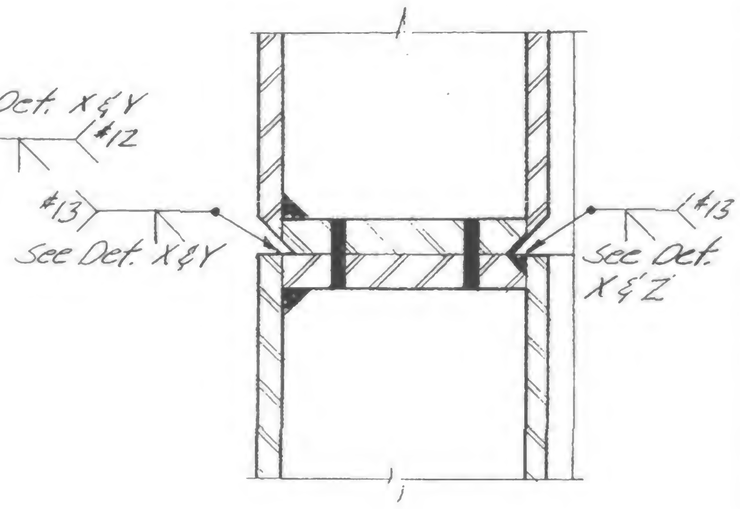
SKILLING, HELLE, CHRISTIANSEN, ROBERTSON — Structural & Civil Engineers

PROJECT: THE WORLD TRADE CENTER | TITLE: EXTERIOR WALL - COLUMN SPLICE REPAIR PROCEDURE | DATE: 6-20-69

REVISIONS



Section a-a



Section b-b

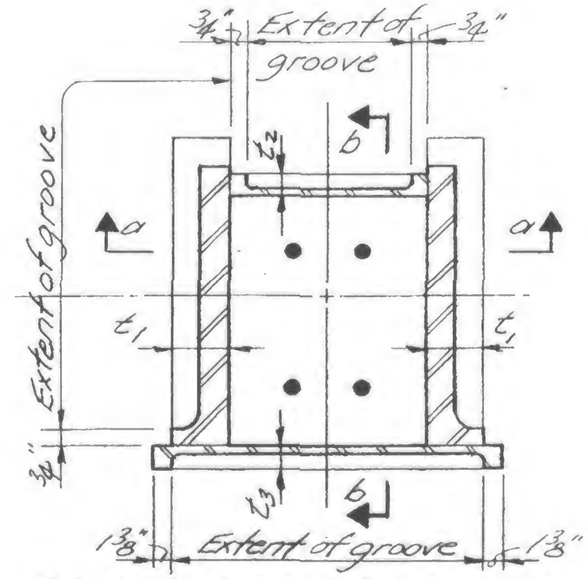
COLUMN TYPES	WELD SIZE	
	WELD 12	WELD 13
120 thru 122	1/2	1/2
123 thru 129	5/8	1/2
130 thru 134	3/4	1/2
135 thru 139	7/8	5/8
140 and 141	1	5/8
142 thru 145	1 1/8	5/8
146 thru 149	1 1/4	5/8
150 thru 155	1 5/8	5/8
156 thru 158	1 5/8	3/4
159 thru 164	1 3/4	3/4

WELDING ELECTRODE TABLE

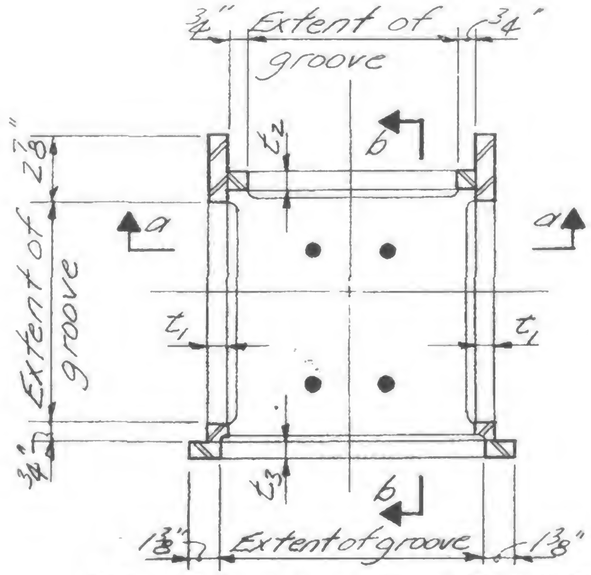
Fy GREATER THAN	Fy EQUAL OR LESS THAN	ASTM SPEC	CLASS
	36	A233	E70XX
36	50	A233	E70XX
50	70	A316	E80XX
70	80	A316	E90XX
80	90	A316	E100XX
90		A316	E110XX

Low hydrogen electrodes shall be used.

NOTE: Column splices may be welded as shown if the bolt hole diameter or pattern preclude the use of specified splice bolts.



PLAN ABOVE SPLICE
Column Type 128-164



PLAN ABOVE SPLICE
Column Type 120-127

NOTES:

1. Weld size shall be determined by the upper column type at the splice.
2. Preparation for welds shall be accomplished by arcair gouging to dimensions shown in schedule.
3. For Detail X, Y, Z see 19-AB-1004.2
4. Erector to supply shims of 18 ga. stock, where required, to maintain full bearing. Shim material to be ASTM A245, Grade D. For plan of shim see 4-AB2-12.
5. Preheat shall be not less than AWS minimums and shall conform, wherever applicable, to steel manufacturer's recommendations.
6. Welding electrodes shall be determined by the Fy of the upper column type at the splice. See welding electrode table.

DESIGNED H. I. GELLER
DRAWN J. Adams
REVIEWED W. Brewer

19-AB-1004.1