Washington State Department of Transportation

TRANSMITTAL OF CATALOG CUTS

DATE : 1/28/11

FROM: Frank Green

TO: E & EP Materials Lab - Documentation Section; MS47365

Section: Columbia River Bridge Temporary Pile Test Program

Contract No: 008078 **SR -** 5

Bid Item	Material Description	Manufacturer	FOSSC Appr'l Action
4.01.01	open end cutting shoes	Vancouver Iron & Steel, Inc.	

INSTRUCTIONS:

1.) This form is the "MASTER" and will need to be copied and used throughout the contract for each catalog cut submitted for approval.
2.) The Project Office will fill in the "DATE", "Bid Item", "Material Description" and "Manufacturer". If the Project Office is unable to provide this information, request the additional information from the contractor.
3.) Attach TWO(2) copies of the catalog cut for retention at the E & EP - Materials Lab.
4.) E & EP will check the catalog cut for compliance with the appropriate section of the Standard Specification, mark the "E & EP Approval Action" and return this transmittal cover sheet to the Project Engineer.

REMARKS:

Distribution:
Mat'l File____x_____
Proj Engr____x_____

CAT-0001

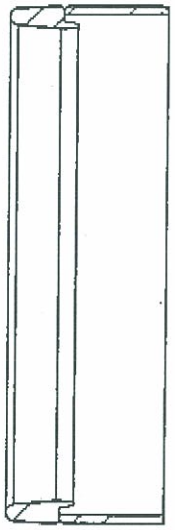
Phone: 1-800-678-0814 / 1-503-287-9822 Fax: 1-800-287-7483 / 1-503-287-7483

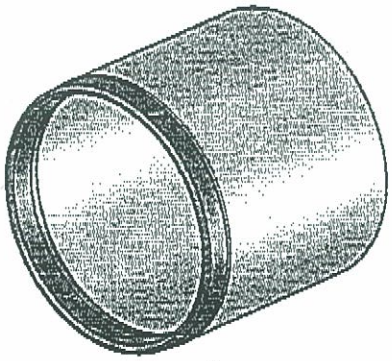
Versa- Steel, Inc.

www.piletips.com

1618 NE 1st Avenue Portland, Oregon 97232-1136

Open End Cutting Shoe
Data Sheet



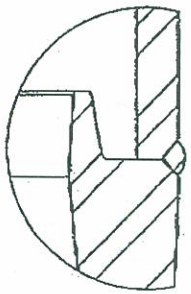


SIZE A | DWG. NO. Equipment Data Sheet | REV. A

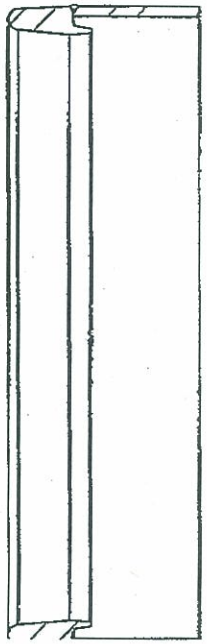
SCALE: 1:10 WEIGHT: SHEET 1 OF 3

Open End Cutting Shoes

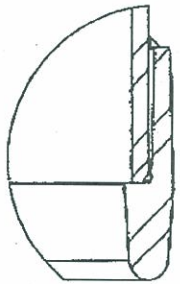
Type Inside Fit
700 Series



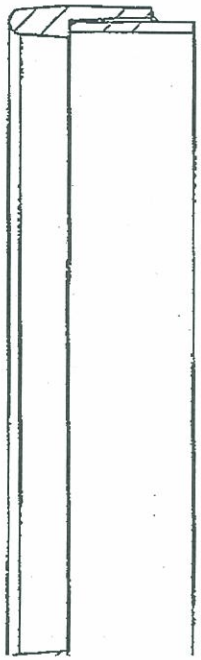
These tips are designed with a weld chamfer built into the casting. Slip shoe inside pipe and using a 70xx series rod weld a 5/16" or larger weld all around.



Type Outside Fit
200 Series



These slip fit shoes are easily attached with a 5/16" or larger fillet weld at the top of the flange. For best results, weld all around the shoe with a 70xx series rod.



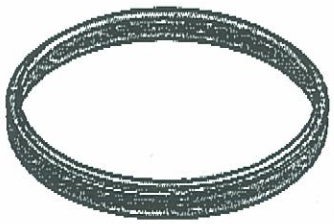
Product Description

Our inside fit and outside fit cutting shoes are designed to install with a slip-on fit. The design places the cross-sectional area directly below the wall of the pipe for maximum support during penetration. They are a more heavy duty construction than other brands.

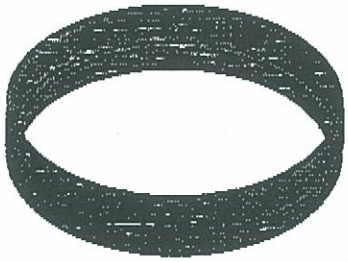
The inside fit cutting shoe has a weld prep chamfer built into the casting. Slip shoe inside pipe and using a 70xx series rod weld a 5/16" or larger weld all around.

The outside fit cutting shoe has a natural fillet on top for easy welding. These slip fit shoes are easily attached with a 5/16" or larger fillet weld at the top of the flange. Weld all around the shoe with a 70xx series rod.

Type Inside Fit
700 Series



Type Outside Fit
200 Series



Versa Steel Open End Cutting Shoe and Pipe Cross-Section View

NEXT ASSY | USED ON

APPLICATION

DIMENSIONS ARE IN INCHES
TOLERANCES:
1/X ± 1/16"
.XX ± .01
.XXX ± .003
.XXXX ± .0005

MATERIAL Steel Alloy

FINISH None

DO NOT SCALE DRAWING

	NAME	DATE
DRAWN	JML	12/27/2007
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		
COMMENTS:		

Description:
Open End Cutting Shoes
Part Number:

SIZE A | DWG. NO. Equipment Data Sheet | REV. A
SCALE: 1:5 | WEIGHT: | SHEET 2 OF 3

Drive Shoes

Vancouver Iron & Steel, Inc.

MATERIAL CERTIFICATE

Customer: Versa Steel Inc. Date: 9-Mar-09

PO Number: 2947 Part Number: VS748

Heat Number: Total Quantity: 3

Specification : ASTM A148 Gr. 80-50

Heat Treatment: NORMALIZE

CHEMICALS		MECHANICAL			LOT NUMBER	
Carbon	0.21	Tensile	85,600	psi	Julian Date	Qty.
Silicon	0.58	Yield	54,500	psi		
Manganese	0.66	Elong.	25	%		
Phosphorus	0.01	Reduc.	42	%		
Sulfur	0.01	Brinell	179	BHN		
Chromium						
Nickel						
Molybdenum						
Copper						
Vanadium						
Aluminum	0.04					
Magnesium						

CHARPY TEST:

Notch: Temp:

Test 1:

Test 2:

Test 3:

Average:

We certify that the above items have been melted and manufactured in the United States in accordance with, and conform to, the applicable specifications, standards, requirements, instructions and/or drawings referenced on the above purchase order, subject to our acknowledgment of said purchase order.

Vancouver Iron and Steel, Inc

Quality Assurance Department

1200 West 13th Street
Vancouver, WA 98660
Phone: 360-695-3914
866 N. Columbia Blvd.
Portland, OR 97217
Phone: 503-821-8100
Fax: 503-821-8121

VANCOUVER IRON & STEEL, INC

MATERIAL CERTIFICATE

Customer: Versa Steel Inc. Date: 12/20/2010

PO Number: 2907 / 2888 Part Number: VS724-80/50

Heat Number: Total Quantity: 76

Specification : ASTM A148 Gr. 80-50

Heat Treatment: NORMALIZE

CHEMICALS		MECHANICAL			LOT NUMBER	
					Julian Date	Qnty.
Carbon	0.25	Tensile	82,600	psi		
Silicon	0.55	Yield	53,000	psi		
Manganese	0.86	Elong.	28	%		
Phosphorus	0.01	Reduc.	30	%		
Sulfur	0.01	Brinell	174	BHN		
Chromium	0.13					
Nickel	0.06					
Molybdenum	0.10	CHARPY TEST:				
Copper	0.13	Notch:		Temp:		
Vanadium						
Aluminum	0.04	Test 1:				
Magnesium		Test 2:				
		Test 3:				
		Average:				

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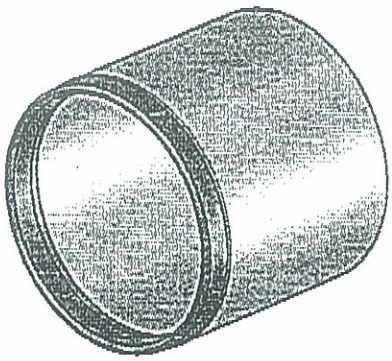
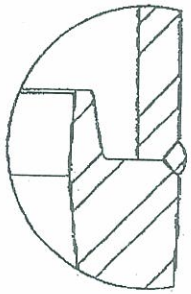


SIZE A | DWG. NO. Equipment Data Sheet | REV. A
SCALE: 1:1 | WEIGHT: | SHEET 1 OF 3

Open End Cutting Shoes

Type Inside Fit
700 Series



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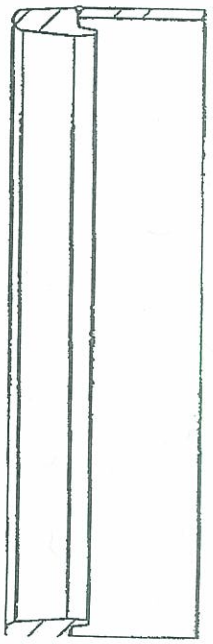
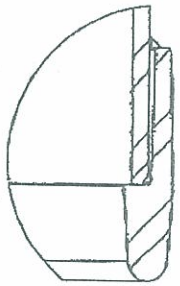


Type Outside Fit
200 Series



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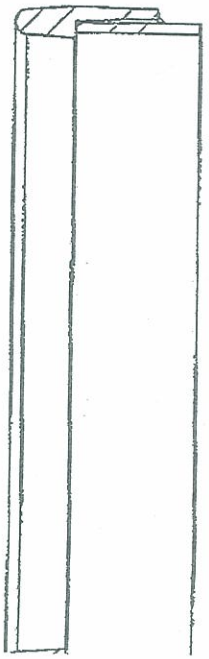

Product Description

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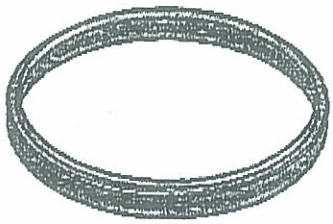

Type Outside Fit
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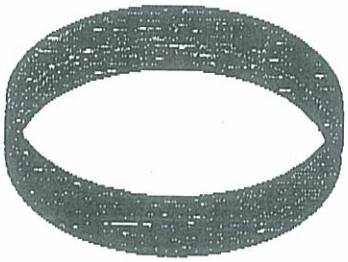
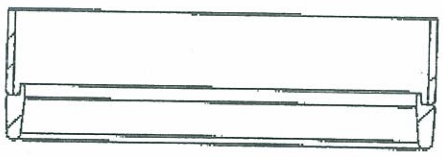
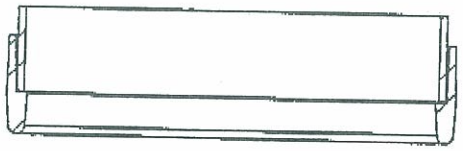


Versa Steel Open End Cutting Shoe and Pipe Cross-Section View





NEXT ASSY | USED ON

APPLICATION

DIMENSIONS ARE IN INCHES
TOLERANCES:
1/X ± 1/16"
.XX ± .01
.XXX ± .003
.XXXX ± .0005

MATERIAL: Steel Alloy
FINISH: None

DO NOT SCALE DRAWING

	NAME	DATE
DRAWN	JML	12/27/2007
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		
COMMENTS:		

Description:
Open End Cutting Shoes
Part Number:

SIZE A | DWG. NO. Equipment Data Sheet | REV. A
SCALE: 1:5 | WEIGHT: | SHEET 2 OF 3

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Specification : ASTM A148 Gr. 80-50

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Manganese	0.66	Elong.	25	%		
Phosphorus	0.01	Reduc.	42	%		
Sulfur	0.01	Brinell	179	BHN		
Chromium						
Nickel						
Molybdenum						
Copper						
Vanadium						
Aluminum	0.04					
Magnesium						

CHARPY TEST:

Notch: _____ Temp: _____

Test 1: _____

Test 2: _____

Test 3: _____

Average: _____

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