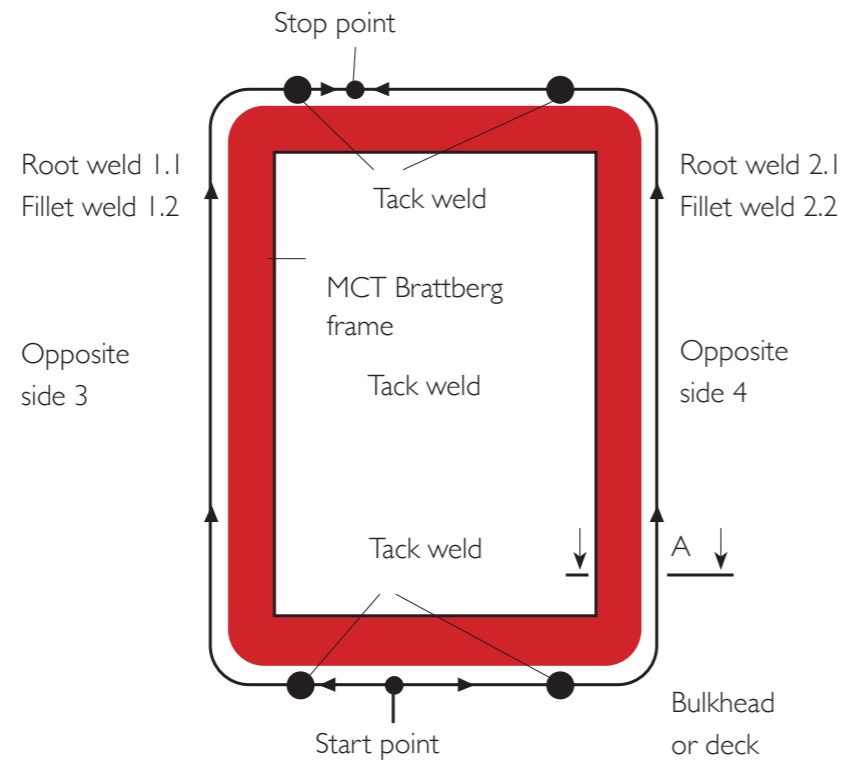


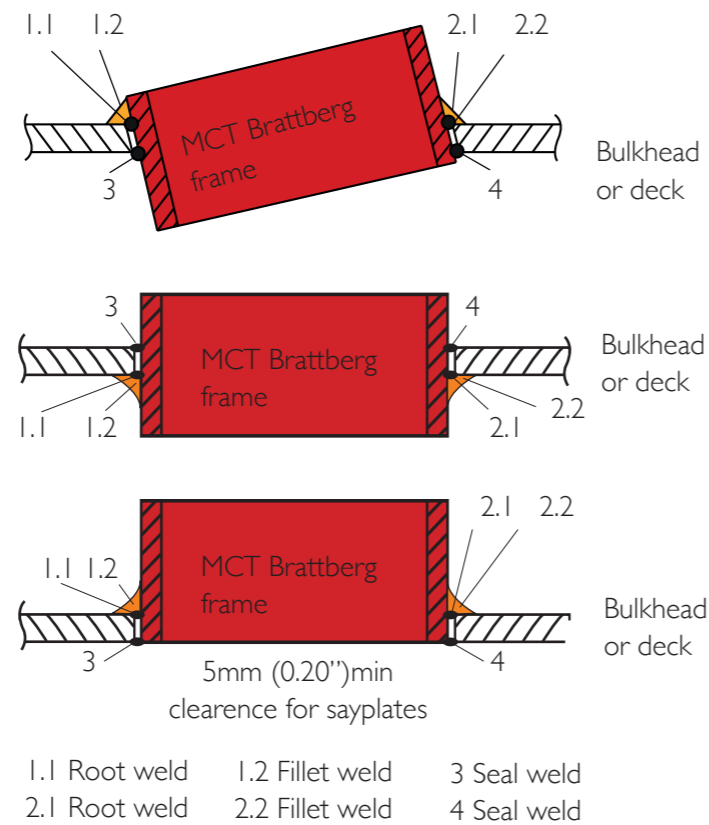
Welding instructions

Welding sequence of a two-pass fillet shall be performed in the following steps with minimize heat input.

- 1 – Fix with tack weld points, maximum 150 mm (5.90") between.
 - 2 – Root weld 1.1 and 2.1
 - 3 – Fillet weld 1.2 and 2.2
 - 4 – Seal weld 3 and 4
- Weld pass 4 is not to be started until weld 2 and 3 are completed!



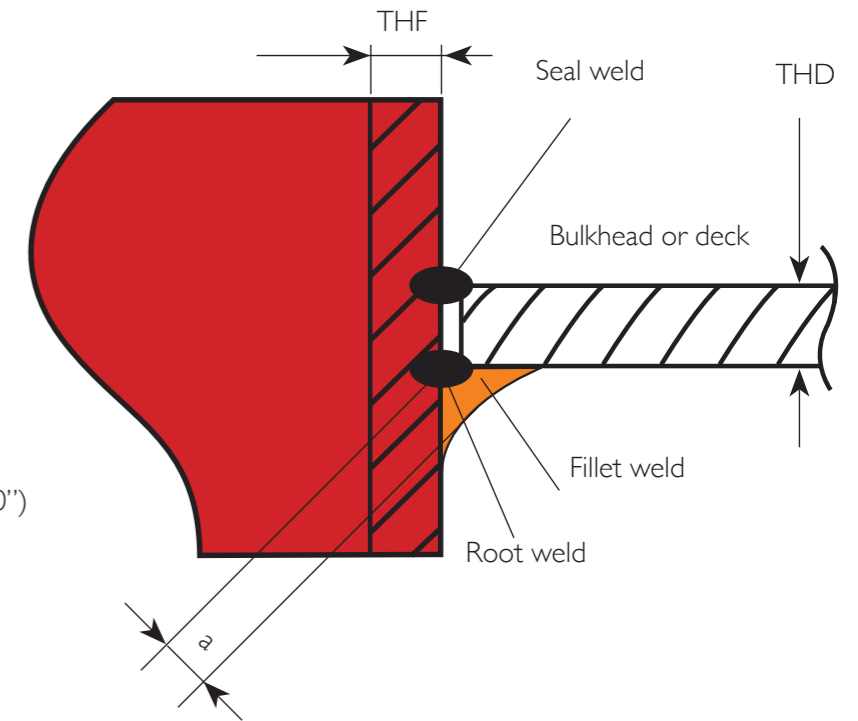
Three different welding sequences



Fillet weld size for a centre-placed frame

Fillet weld size (throat thickness) is to be $0.5 \times$ plate thickness of the bulkhead or deck plate (THD). However fillet weld size is not to be greater than $0.7 \times$ frame plate thickness (THF).

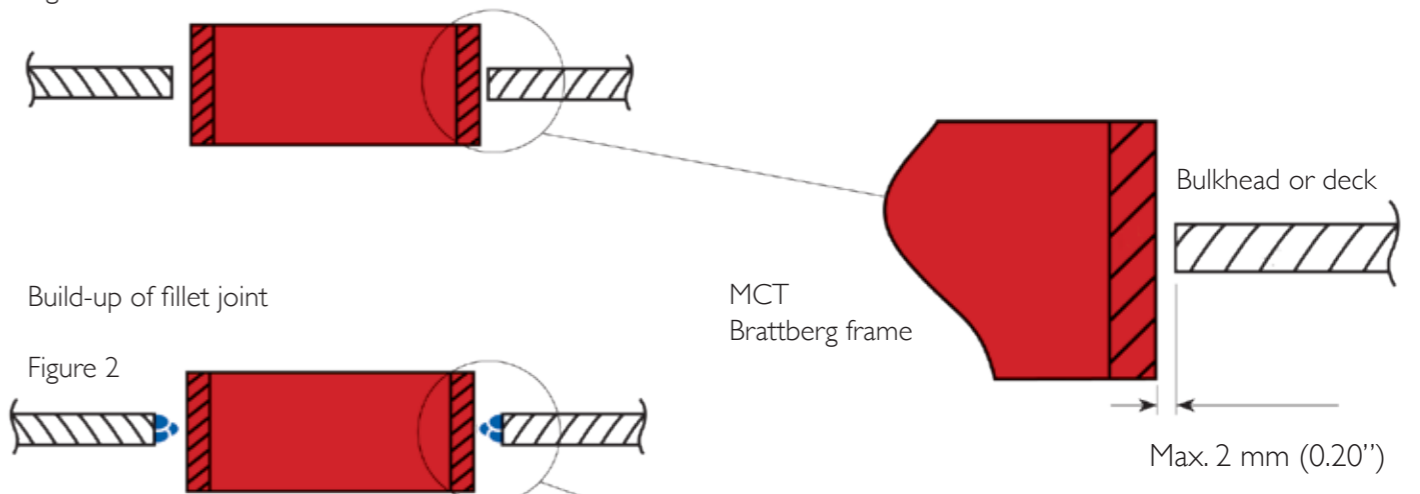
a = Fillet size (throat thickness) Note!
THD = Thickness deck plate
THF = Thickness frame plate
Multi-pass welding is required if $a \geq 5 \text{ mm (0.20")}$



Maximum allowable root gap for fillet joint

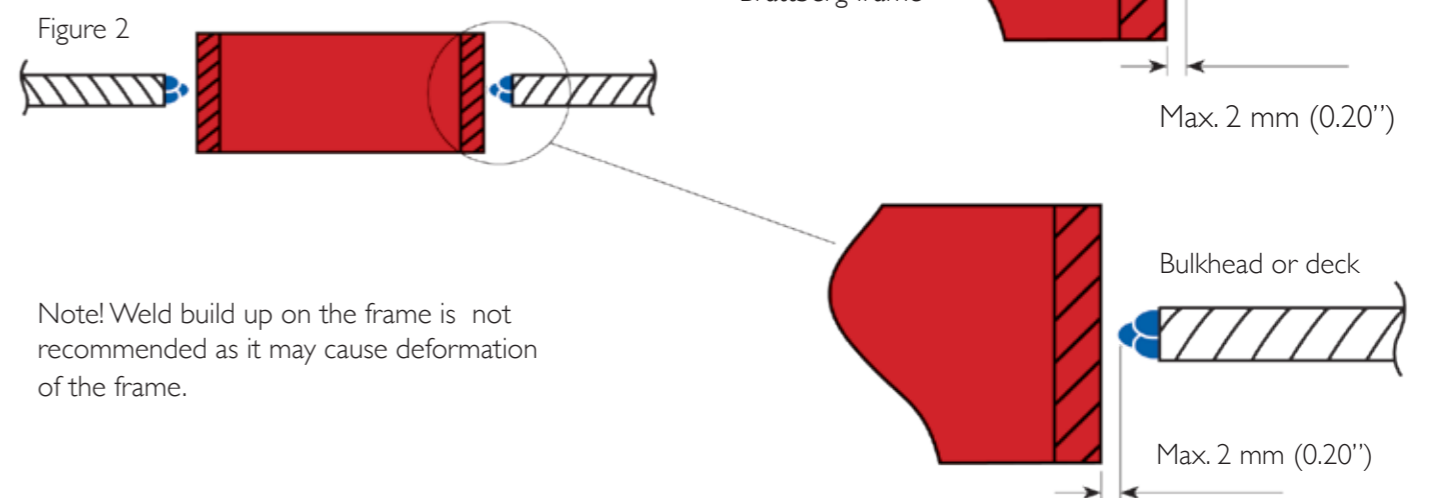
If root gap is too wide the deck plate or bulkhead may be built up with weld to achieve a proper gap (see Figure 2).

Figure 1



Build-up of fillet joint

Figure 2



Note! Weld build up on the frame is not recommended as it may cause deformation of the frame.