Welding instructions

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

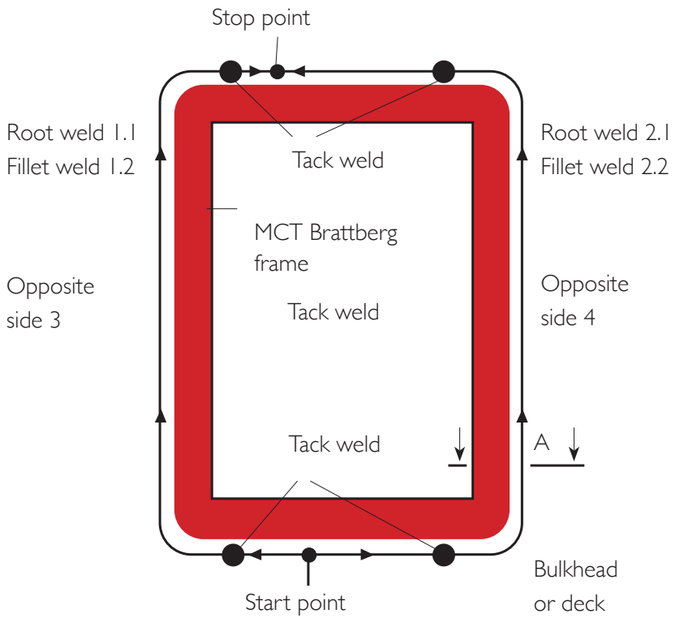
1 – Fix with tack weld points, maximum 150 mm (5.90") between.

2 – Root weld 1.1 and 2.1

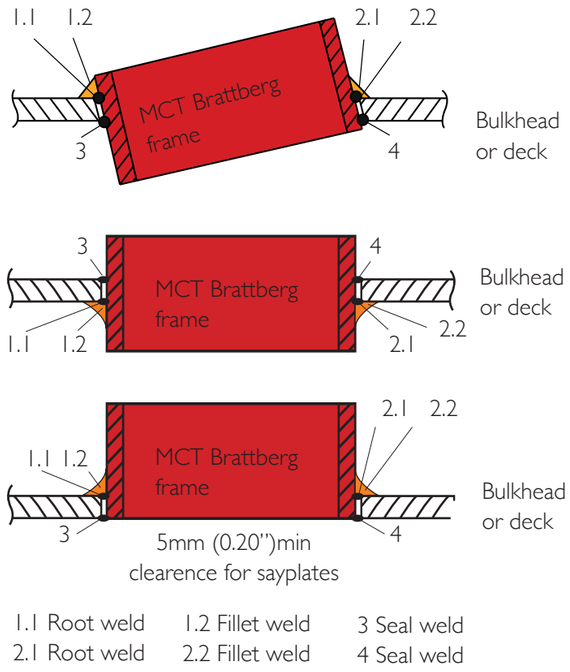
3 – Fillet weld 1.2 and 2.2

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



1.1 Root weld 1.2 Fillet weld 3 Seal weld
2.1 Root weld 2.2 Fillet weld 4 Seal weld

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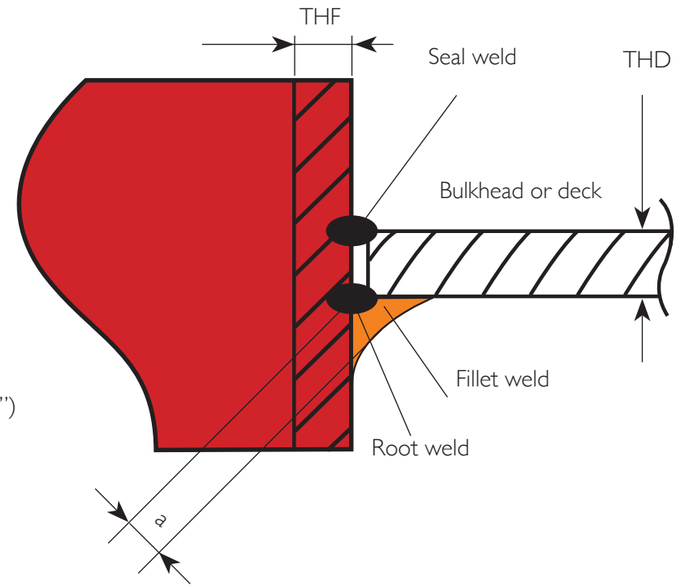
Fillet weld size for a centre-placed frame

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

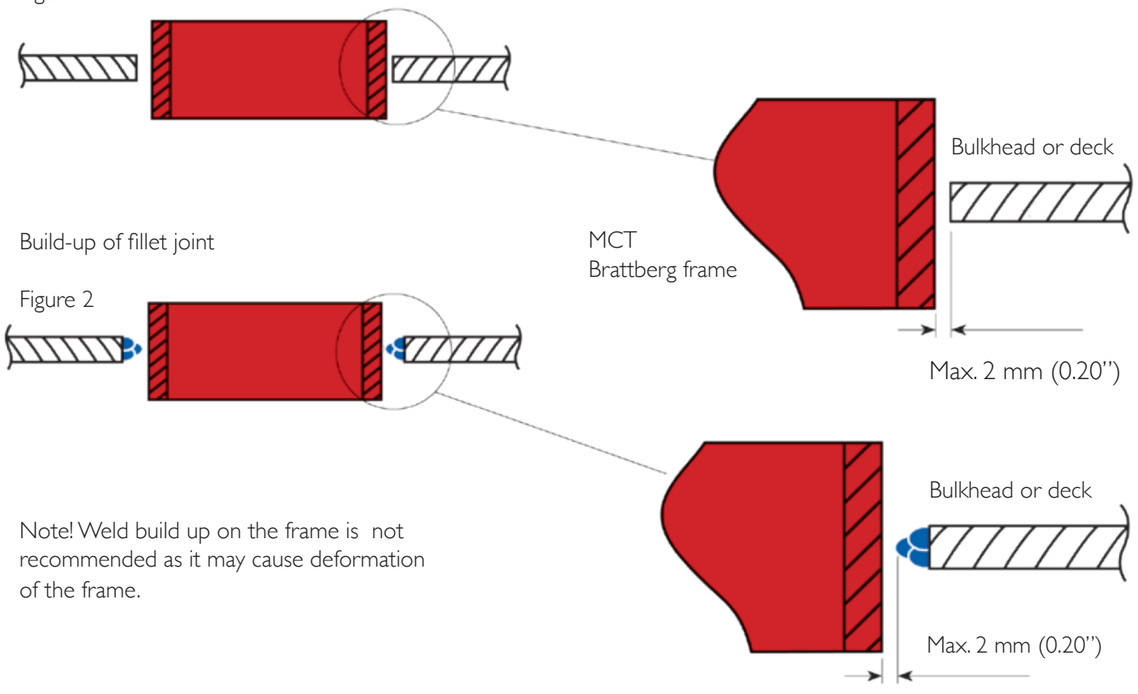
a = Fillet size (throat thickness) Note!
THD = Thickness deck plate
THF = Thickness frame plate
Multi-pass welding is required if a ≥ 5 mm (0.20")



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.