Welding instructions

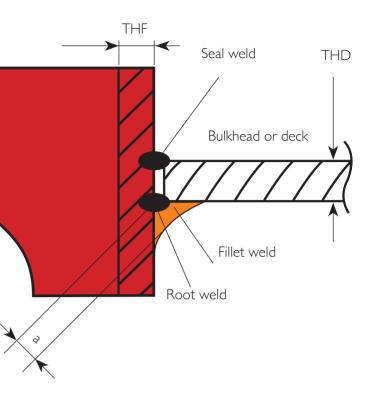
Welding sequence of a two-pass fillet Fillet weld size for a centre-placed frame shall be performed in the following steps Stop point with minimize heat input. Fillet weld size (throat thickness) is to be $0.5 \times$ plate thickness of the bulkhead or deck I – Fix with tack weld points, maximum plate (THD). However fillet weld size is 150 mm (5.90'') between. not to be greater than $0.7 \times$ frame plate Root weld 1.1 Root weld 2.1 thickness (THF). Tack weld Fillet weld 1.2 Fillet weld 2.2 2 – Root weld 1.1 and 2.1 a = Fillet size (throat thickness) Note! MCT Brattberg 3 - Fillet weld 1.2 and 2.2 THD = Thickness deck plateframe THF = Thickness frame plateOpposite Opposite 4 - Seal weld 3 and 4Multi-pass welding is required if $a \ge 5 \text{ mm} (0.20'')$ Tack weld side 4 side 3 Weld pass 4 is not to be started until weld 2 and 3 are completed! Tack weld А ¥ Maximum allowable root gap Bulkhead for fillet joint Start point or deck Figure I 1.1 1.2 2.1 2.2 V////// Bulkhead Three different welding sequences or deck Build-up of fillet joint Figure 2 Bulkhead //// or deck VIIIIS 2.2 2.1 2.2 1.1 1.2 Bulkhead Note! Weld build up on the frame is not $\overline{)}$ **Y**///// or deck recommended as it may cause deformation 3~ 5mm (0.20'')min of the frame. clearence for sayplates I.I Root weld 1.2 Fillet weld 3 Seal weld 2.1 Root weld 2.2 Fillet weld 4 Seal weld

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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).

