

WELD PROCEDURE
FOR HULL & DECK PLATING



GENERAL NOTES

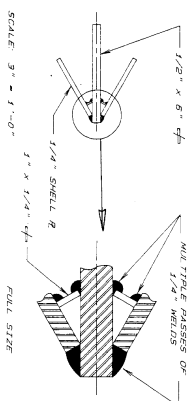
MATERIALS

1. HELL, DECK AND SUPERSTRUCTURE PLATING:
MILL, SAW OR SCRAPING 15 ALUMINUM ALLOY
STRENGTHS ON THE WELDED CONDITION
30,000 PSI (24 KGS./CM²) YIELD STRENGTH
34,000 PSI (26 KGS./CM²) TENSILE STRENGTH
10,000 PSI (7.6 KGS./CM²) ELONGATION
2. HULL FRAMES, LONGITUDINAL STRINGERS, PLANKS
AND TRANSVERSE PLATING:
SOME AS MILL DECK AND SUB-
STRUCTURE PLATING
3. BULKHEAD STRINGERS, SUPERSTRUCTURE PLATING
AND PLATING ON THE WELDED CONDITION:
MINIMUM STRENGTHS ON THE WELDED CONDITION:
30,000 PSI (24 KGS./CM²) YIELD STRENGTH
34,000 PSI (26 KGS./CM²) TENSILE STRENGTH
10,000 PSI (7.6 KGS./CM²) ELONGATION
4. FILLER WIRE USED FOR WELDING: .032 THICKNESS
5356 ALUMINUM ALLOY.

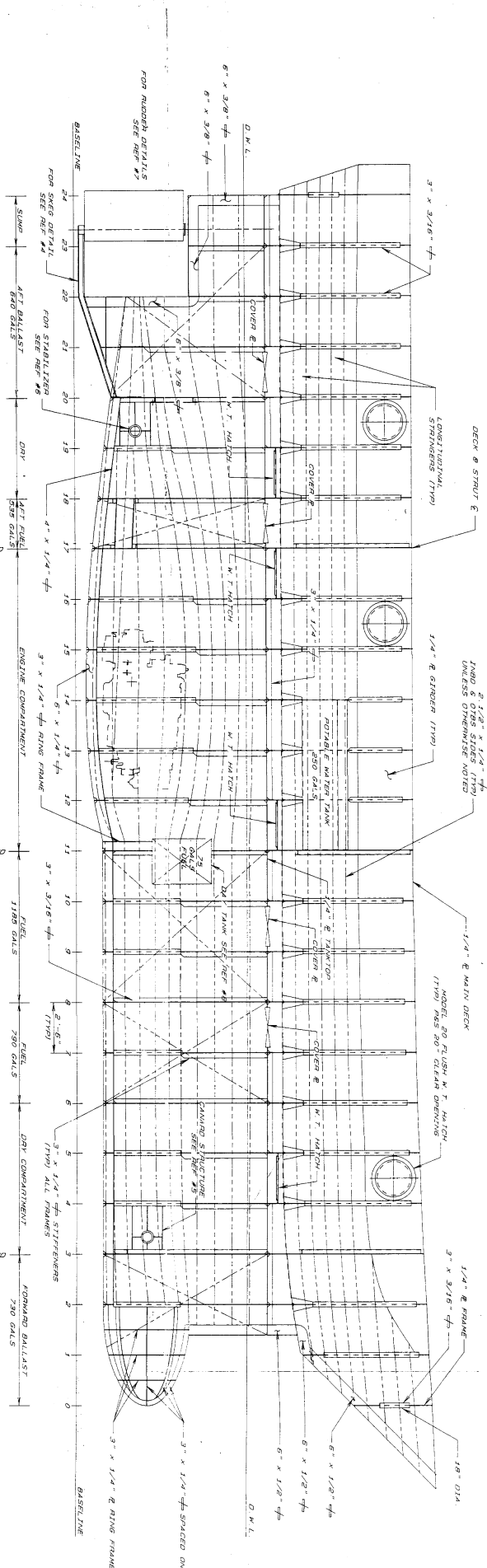
WELDING METHOD

1. ALL PLATING TO BE BEFORE WELDING.
2. CONTINUOUS WELDING.
3. OVERLAP OF PREVIOUS SKIP WELDING SHALL BE 3/4
4. BACK STEPPING 3/4
5. FOR BUTT WELDING 3/4
6. FOR WELDING FRAMING LONGITUDINALS TO BE 4" @ 8" STAGGERED
7. FOR BULKHEAD STIFFENERS STAGGERED TYPICAL MATERIALS BULKHEAD MATERIALS Y WELDING METHOD

1. LONGITUDINAL SHALL BE OF ONE CONTINUOUS LENGTH EXTENDING AS FAR AS POSSIBLE
2. GATHERS ON FLOWING WHICH OCCURS SHALL HAVE CONTINUOUS MARK AROUND
3. DOWNWARD HOLES ARE TO BE PROVIDED IN LONGITUDINAL, LAMBER HOLES IN TRANSVERSE
4. MARKED STEERING HOLES ARE TO BE SWIVED TOP AND BOTTOM TO REMOVE LOCAL STRESSES & PROVIDE ACCESS FOR CONTINUOUS
5. FLOWERS ARE TO BE LEFT OPEN UNTIL HULL BOTTOM MELTING HAS BEEN INSPECTED
6. FLOWERS MUST BE MARKED WITH NUMBER OF FLOWERS REGISTERED OR SHIPPING HULLS AND REGISTRATION FOR THE CLASSIFIED TOW, CAPTAINS AND SMALL CRAFTS MARKS 2. ON FIVE



KEEL/STEM DETAIL



PARTICULARS

L.O.A	65'-7.1/2"
L.B.P	56'-6"
BEAM	35'-0"
DEPTH @	15'-7"

CONSTRUCTION PROFILE

DATE 11 MAY 90	SCALE 3/8" = 1'-0"	DWG NO 50565-B1
DRAWN BY MEA	CHECK BY	APPROVED BY

SUNTH OCEAN

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SWATH
2000 CLASS

DATE	REVISION

No