

WELDING SCHEDULE

CONNECTION	THK	REMARKS
100x14 F.B. BENDER TO SHELL	10mm	DOUBLE CONTINUOUS
10mm CLOSING R TO F.B. BENDER	10mm	CONTINUOUS (OUTSIDE)
10mm CLOSING R TO 25 Ø S.R.	10mm	CONTINUOUS (OUTSIDE)
25 Ø S.R. TO F.B. BENDER (ENDS)	6.5mm	ALL AROUND.

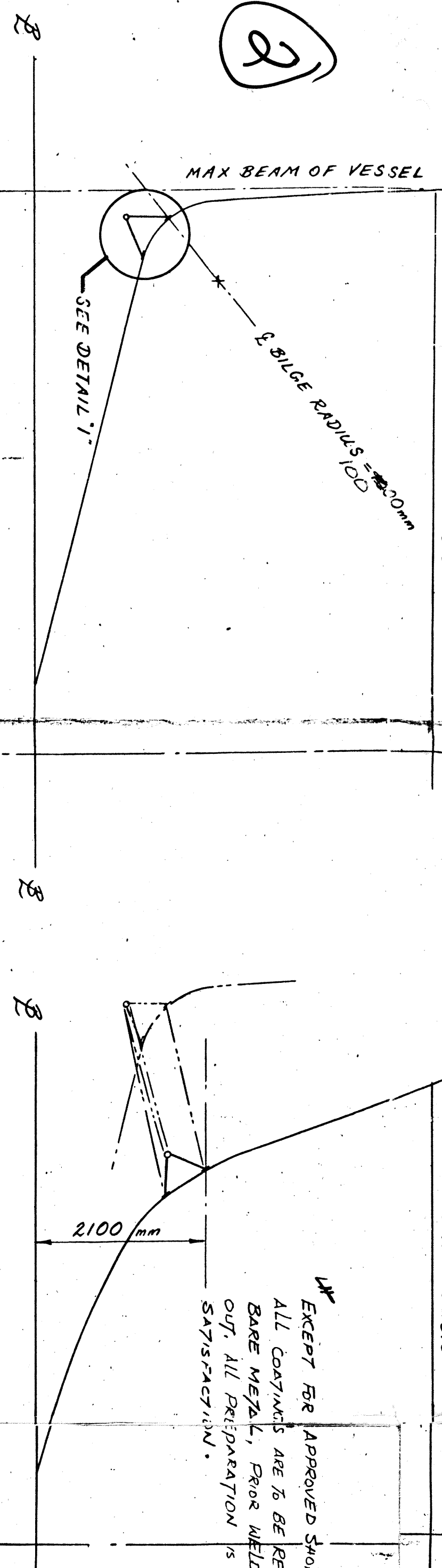
THICKNESS INDICATES LEG LENGTH

NOTE:

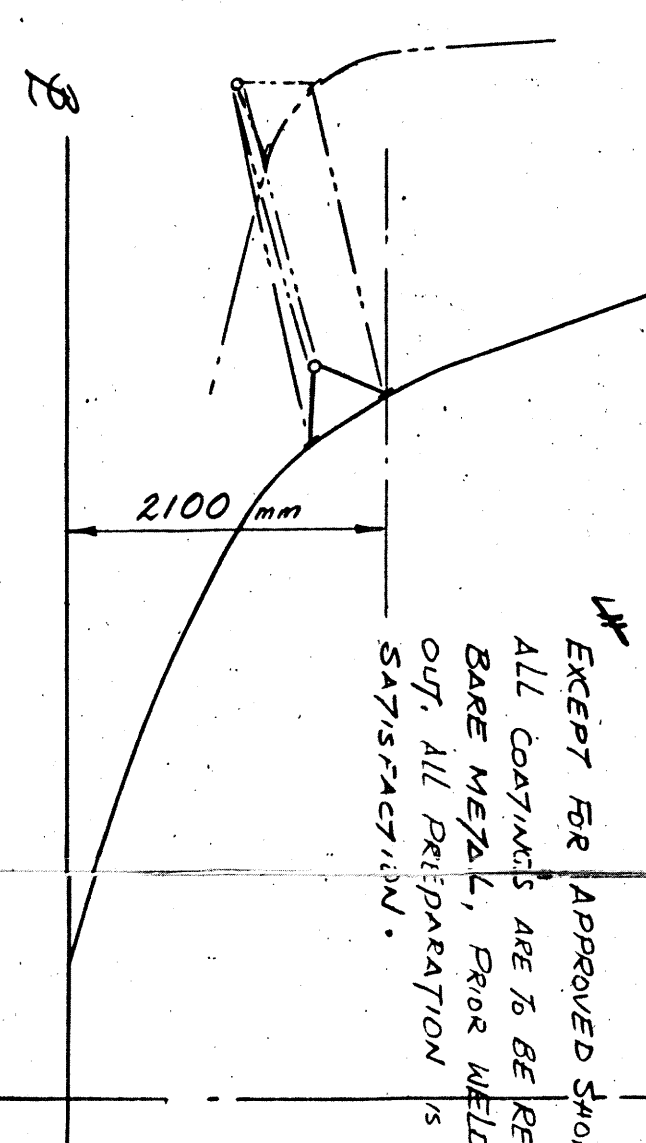
FUEL OIL TANKS No. 1, 2, 3 & 4 TO PORT & STBD. TO BE CERTIFIED GAS FREE PRIOR TO COMMENCEMENT OF ANY HOT WORK.
ALL PLATE & SHAPES UTILIZED IN CONSTRUCTION OF THE BILGE KEELS ARE TO BE LLOYD'S GRADUALLY ACCEPTABLE EQUIVALENT.
ALL DIMENSIONS TO BE CONFIRMED AT SHIP PRIOR TO COMMENCEMENT OF FABRICATION.
ALL NEW STEELWORK TO BE BLASTED TO SA 2½ FINISH & COATED WITH 2 COATS OF RED OXIDE PRIMER PRIOR TO INSTALLATION.

THE VESSELS EXTERIOR HULL IS PROTECTED BY AN INTERNATIONAL PAINT INERTIA 160 COATING SYSTEM BELOW THE WATERLINE. MANUFACTURERS ARE TO BE CONSULTED PRIOR TO COMMENCEMENT OF WORK TO ENSURE DAMAGE TO THE EXISTING SYSTEM BE KEPT TO A MINIMUM. DAMAGED AREAS SHALL BE RE-FABRICATED AS ORIGINAL & IN STRICT ACCORDANCE WITH MANUFACTURERS RECOMMENDATIONS.
ANY DAMAGE TO TANK INTERNAL COATING SYSTEMS SHALL BE RE-FABRICATED TO OWNERS SATISFACTION WHERE APPLICABLE.

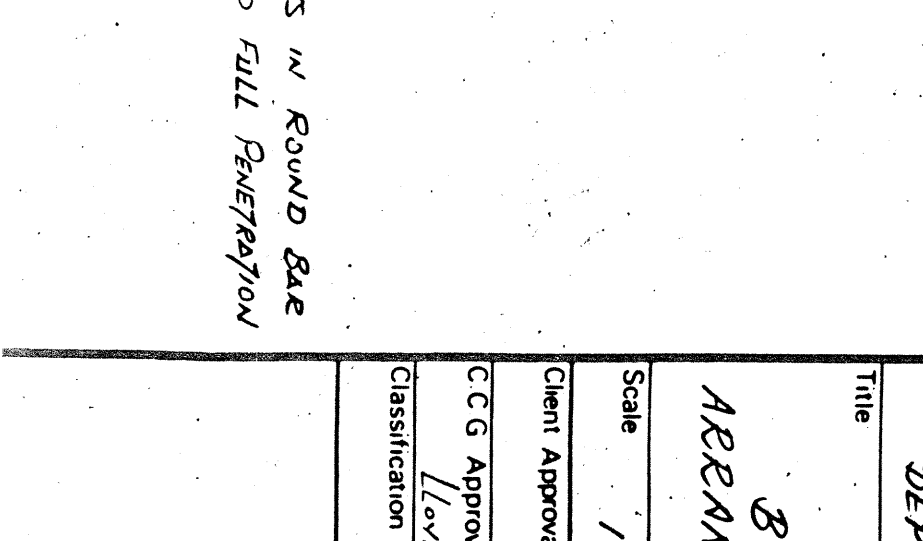
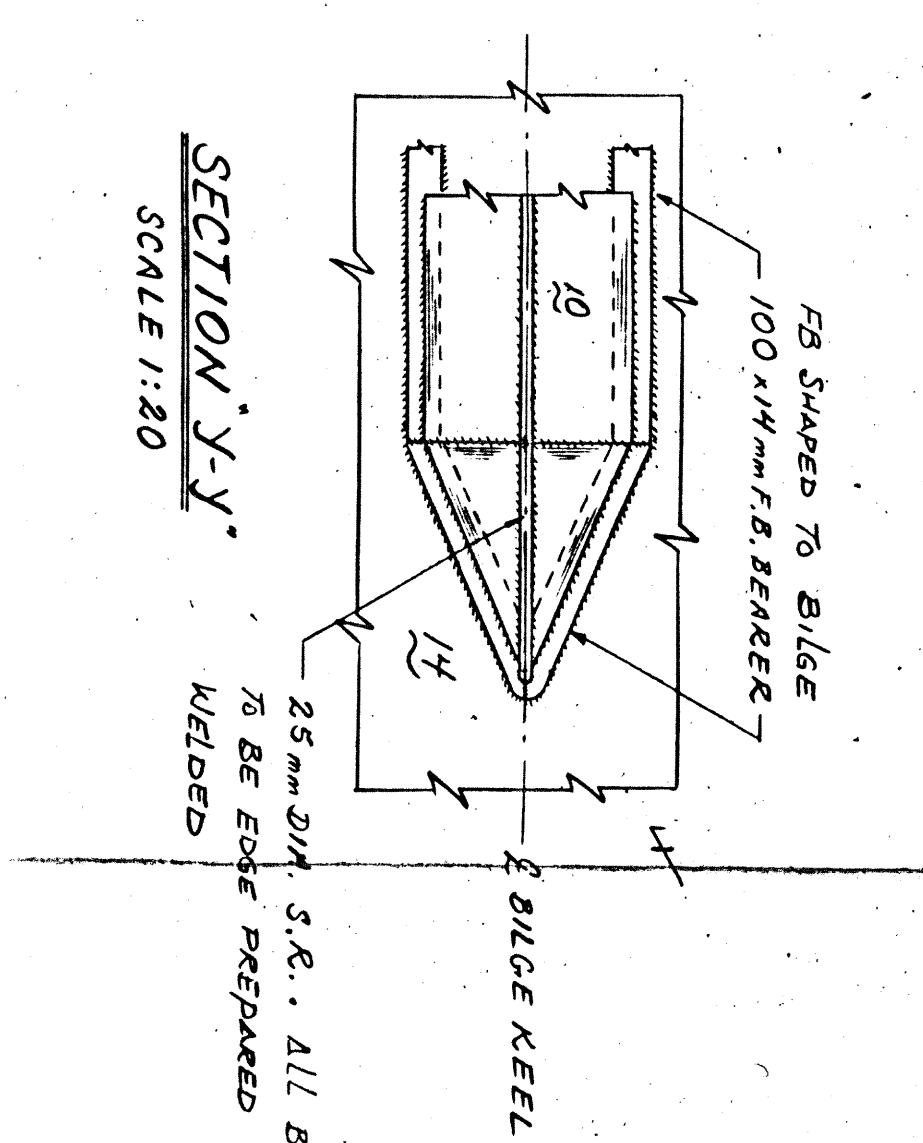
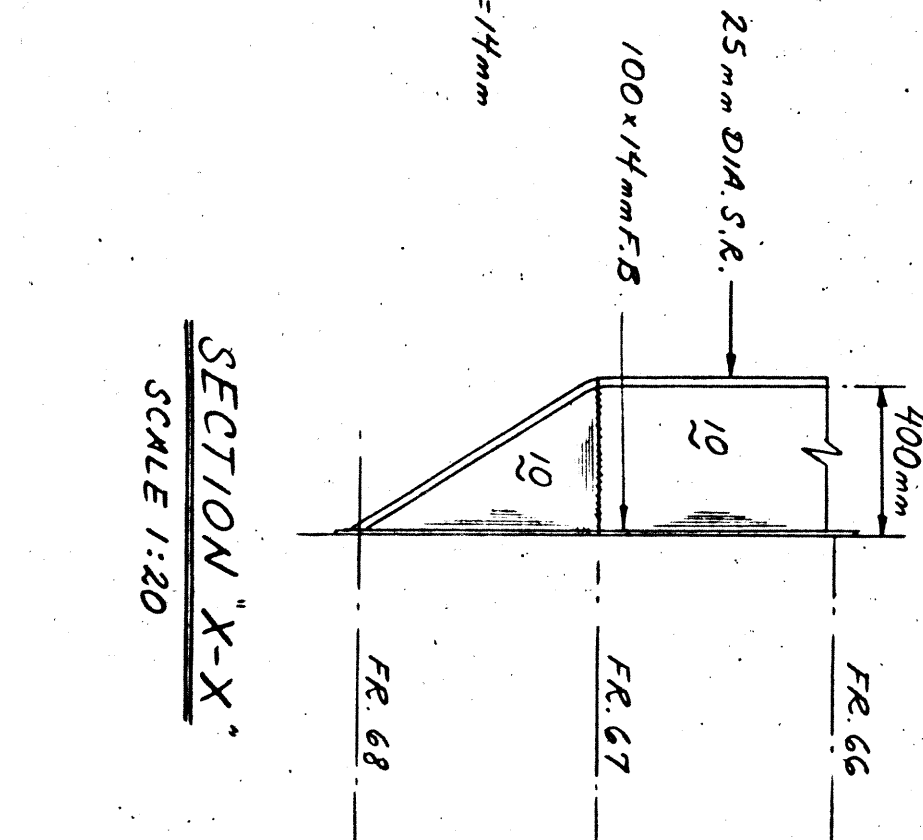
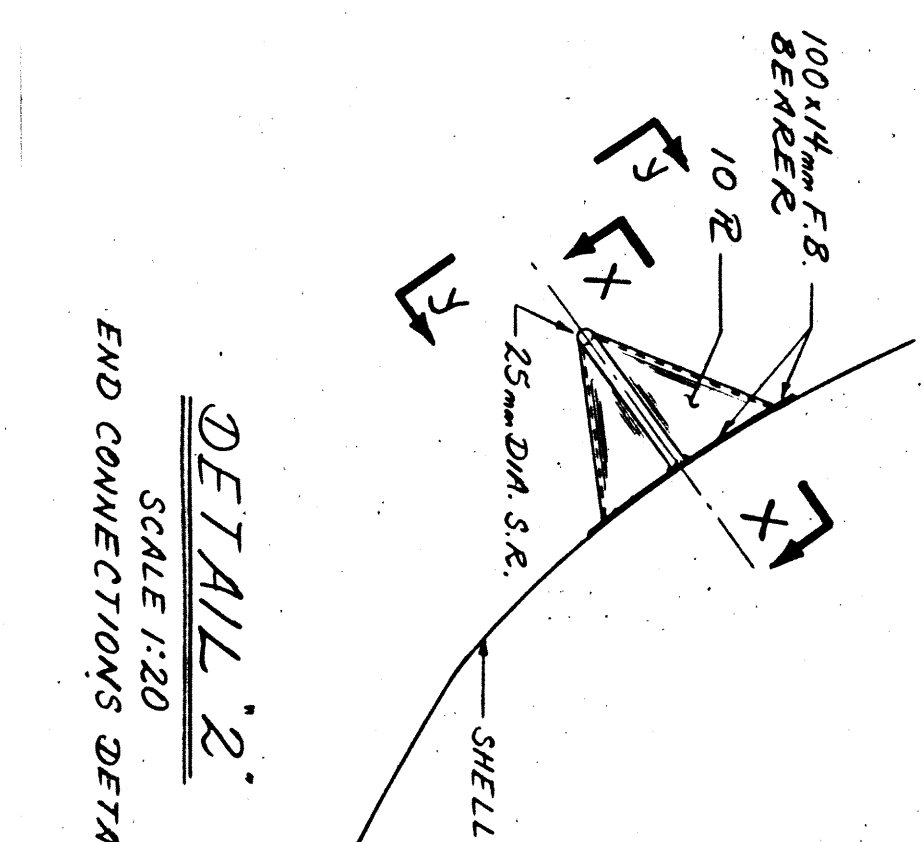
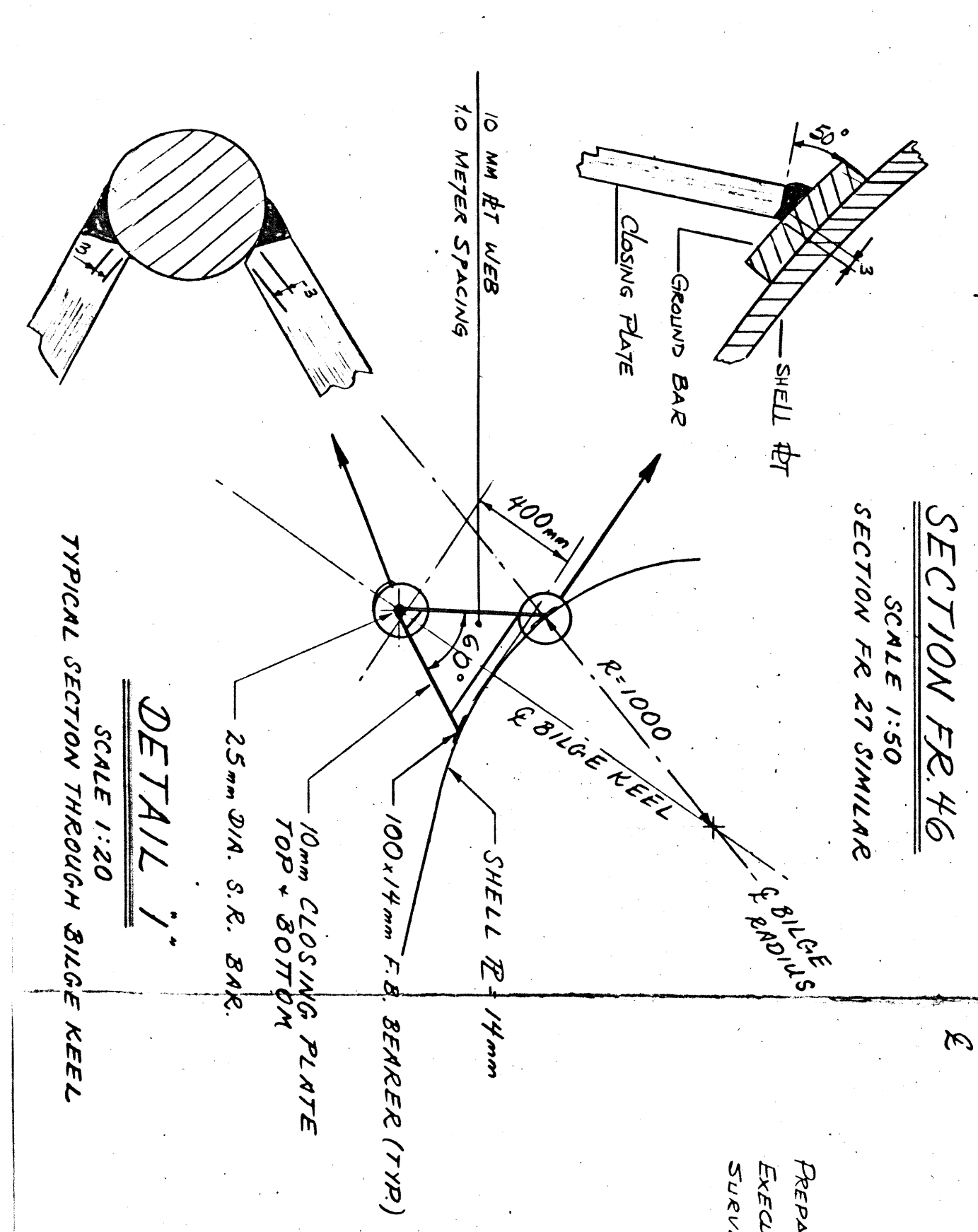
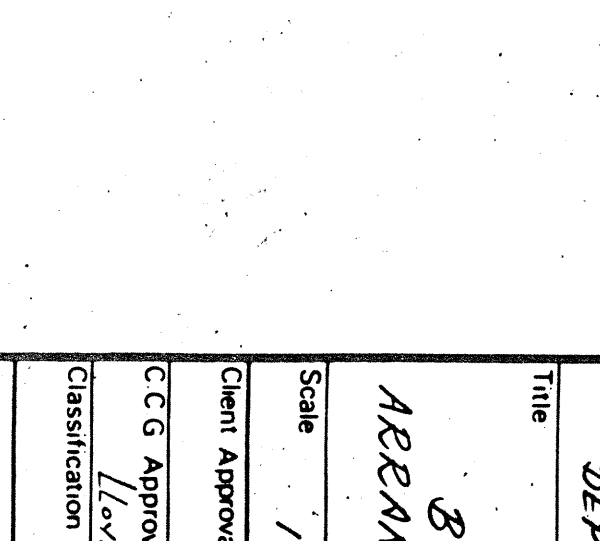
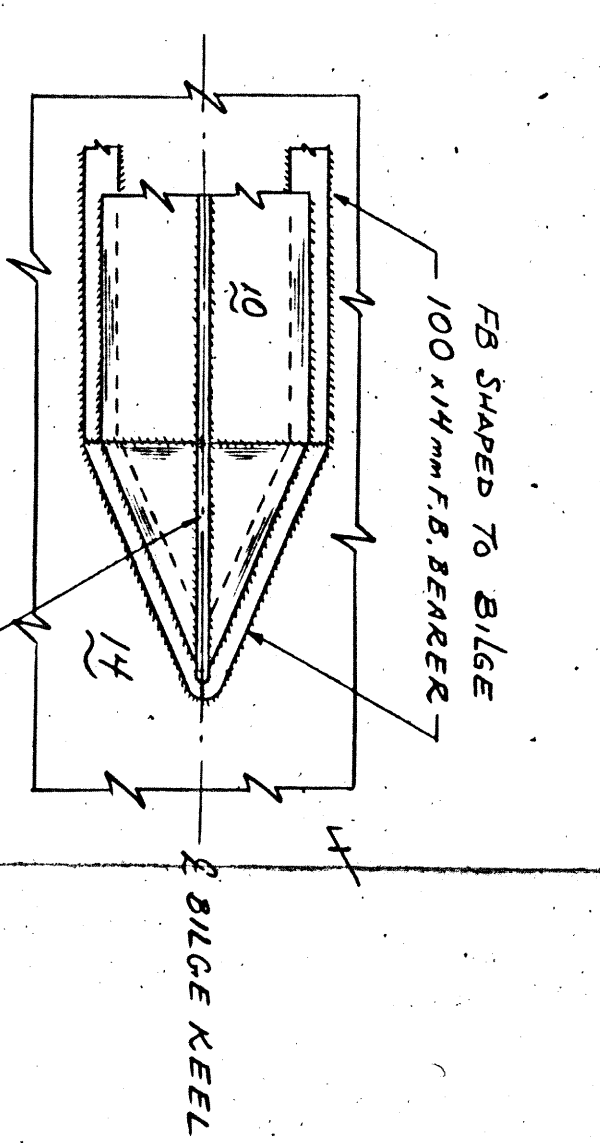
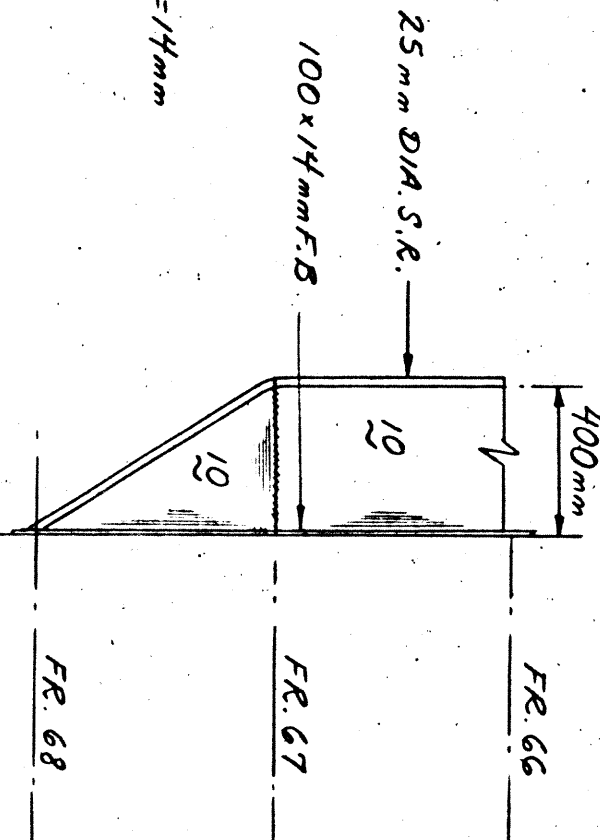
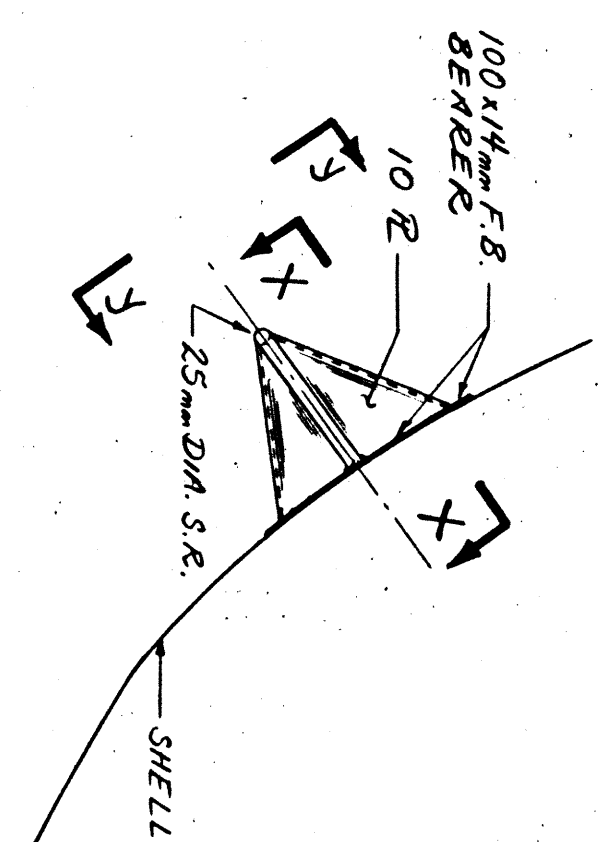
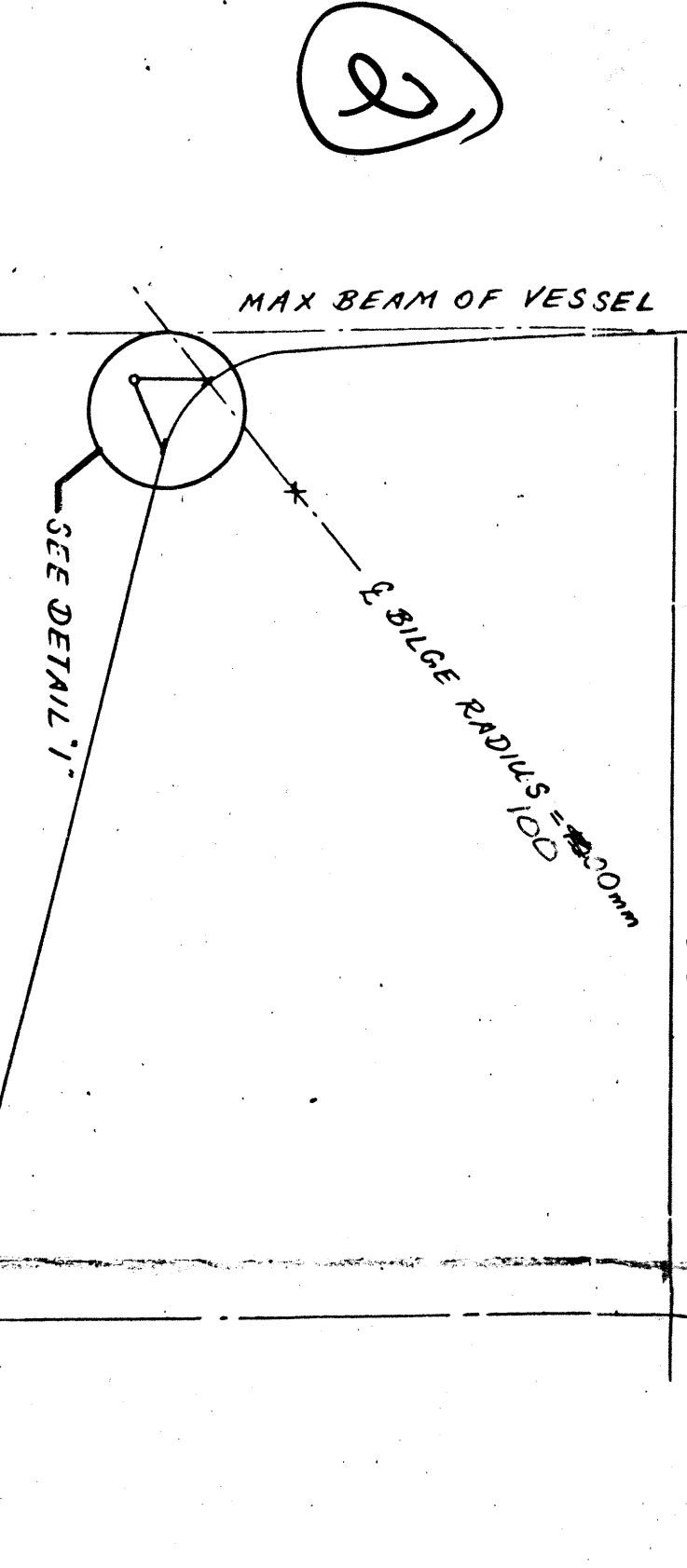
NOTE:
① WELDING PER PREPARED EDGE - SEE DETAILS
② DIRECT CONNECTION BETWEEN GROUND BAE BUTT WELDS AND SHELL PLATING AND BETWEEN BILGE KEEL BUTT WELDS AND GROUND BAE IS TO BE AVOIDED. DETAILS TO SURVEYORS SATISFACTION. ALL BUTTS IN BILGE KEEL PLATING TO BE SUBJECT TO SURVEYORS SATISFACTION.



SECTION FR 67
SCALE 1:50



SECTION FR 46
SCALE 1:50
SECTION FR 27 SIMILAR



BILGE KEELS ARRANGEMENT & DETAILS

Scale 1:100 AND AS NOTED

Client Approval	Date
CCG Approval	22 DEC 1987
Classification Society Approval	

Drawn	Checked	Project No	Sheet 1
		87536	1
		Drawing No	87536-1
		Rev No	1

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