ARUN CLASS
WELDING SCHEDULE

PROJECT #95004

1.	3/16"thk DECK PLATE BOUNDARIES	3/16
2.	3/16"thk BULKHEAD BOUNDARIES	3/16
3.	3/8"thk INSERT PLATES TO SHEER STRAKE	5/16
4.	1/4"thk VERTICAL KEEL TO SHELL	1/4
5.	1/4"thk KEEL FACE PLATE TO WEB	1/4
6.	5/16"thk WEB TO SHELL AND DECK	5/16; 5/16 4-7 ALT
7.	5/16"thk FACE PLATE TO WEB	5/16; 5/16 4-7 ALT
8.	1/2"thk GIRDER FACE PLATE TO 5/16"thk WEB	5/16; 3/8 3-5 ALT
9.	5/16"thk BRACKETS TO DECK INSERT PLATES	5/16
10.	1/4"thk BRACKETS TO DECK INSERT PLATES	1/4
11.	1/4"thk FLAT BAR AND PLATE TO BULKHEADS, SHELL, ETC.	3/16
12.	1/4"thk FACE PLATE TO 3/16"thk WEB	3/16; 1/4 4-7 ALT
13.	1/4"thk FACE PLATE TO 3/8"thk WEB	1/4
14.	3/16"thk GIRDER TO SHELL AND BULKHEAD	3/16; 1/4 4-7 ALT
15.	3/8"thk GIRDER TO BULKHEAD	3/16; 5/16 3-5 ALT
16.	3/8"thk GIRDER TO 5/16"thk SHELL	5/16; 3/8 3-5 ALT
17.	3/8"thk GIRDER TO 1/2"thk SHELL	3/8
18.	ENGINE GIRDER FACE PLATE TO WEB	3/8
19.	TANK TOP CLOSING PLATES PERIMETER	3/16
20.	STIFFENERS TO DECKS, BULKHEADS, GIRDERS, ETC.	3/16 3-6
21.	SIDE SHELL TRANSVERSE FRAMES	3/16 3-6
22.	BOTTOM TRANSVERSE FRAMES	3/16; 1/4 4-7 ALT
22A.	TANK TOP (FUEL OIL TANKS)	3/16

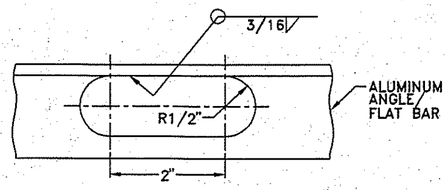
ARUN CLASS
WELDING SCHEDULE

PROJECT #95004

23. PLATE BUTTS AND SEAMS :

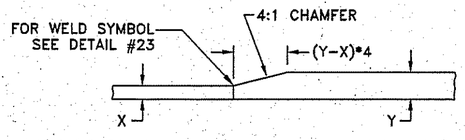
		ALT
3/16"	1/8+1/16 BG, 1/16	1/16 60° TEMPORARY CERAMIC BACKUP
1/4"	1/4+1/16 BG, 1/16 60°	1/16 60° TEMPORARY CERAMIC BACKUP
5/16"	1/4+1/16 BG, 1/16 60°	1/16 60° TEMPORARY CERAMIC BACKUP

24. TANK TOP PLATE TO BOTTOM STIFFENERS



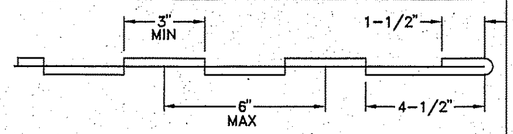
SLOT WELD DETAIL

25. TYPICAL INSERT PLATE DETAILS



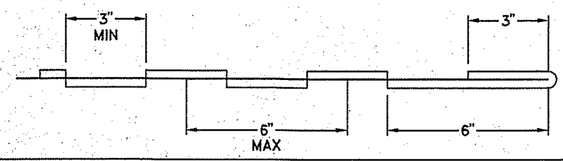
26. TYPICAL STAGGERED INTERMITTENT WELD DETAIL

UNDER 1m LENGTH

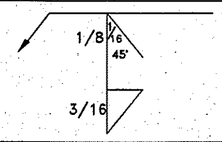


27. TYPICAL STAGGERED INTERMITTENT WELD DETAIL

OVER 1m LENGTH



28. TANK TOP (VOID SPACES)
3/16" TANK TOP TO 3/16" BULKHEAD



WHEELHOUSE WELDING DETAILS

29.	WEB FRAMES TO SHELL	3/16; 3/16
30.	TRANSVERSE FRAMING TO SHELL & DECK	3/16 3-6; 3/16
31.	F.F. TO WEB OF WEB FRAMES	3/16; 3/16
32.	BRACKETS	3/16
33.	BUTTS AND SEAMS	AS PER ITEM #23

No	Reference Drawings		Drawing No
7.	AS FITTED		20 APR 96
6.	ITEM #28 MODIFIED ITEM #22A ADDED	HIKE	29 MAR 96
5.	ITEM #28 MODIFIED	HIKE	26 FEB 96
4.	ITEM #28 MODIFIED ITEM #29 DELETED ITEM #30 MODIFIED	HIKE	20 SEP 95
3.	ITEMS #30-34 ADDED	HIKE	07 SEP 95
2.	ITEMS #23,28 & 29 MODIFIED	HIKE	28 JUL 95
1.	ITEMS #28 & 29 ADDED	HIKE	14 JUL 95
No	Revisions	Issued to	Date

Notes

E.Y.E. MARINE CONSULTANTS

Dartmouth N.S. St. John's NFLD

Project

ARUN CLASS LIFEBOAT HULLS 107 & 108

Client HIKE METAL

Title

WELDING SCHEDULE

Scale N.T.S.		
Client Approval		Date 13 OCT 95
C.C.G. Approval		06 NOV 95
Classification Society Approval		
	Drawn G. PEET	13 APR 95
	Checked T.THOMPSON	
	Project No. 95004	Sheet 1 of 1
	Drawing No. 95004-5	Rev. No. 7