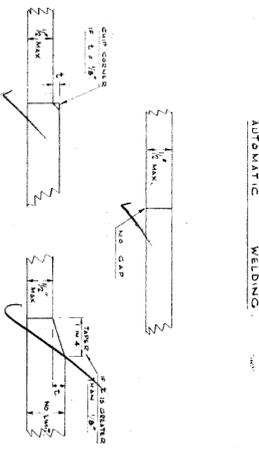
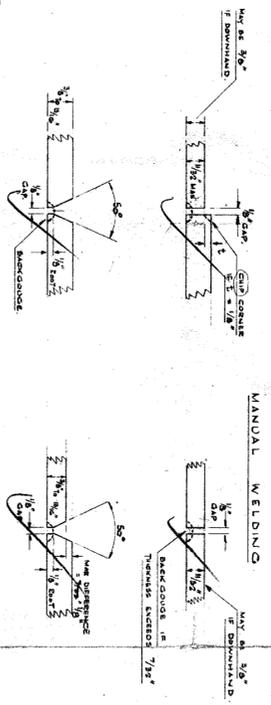


PLATE SEAM EDGE PREPARATION

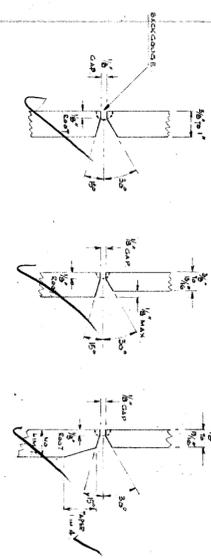


Preparation for, Procure and execution of welding to Superior Satisfaction

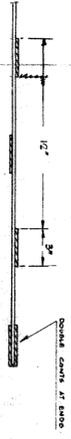
PLATE BUTT EDGE PREPARATION



MANUAL WELDING



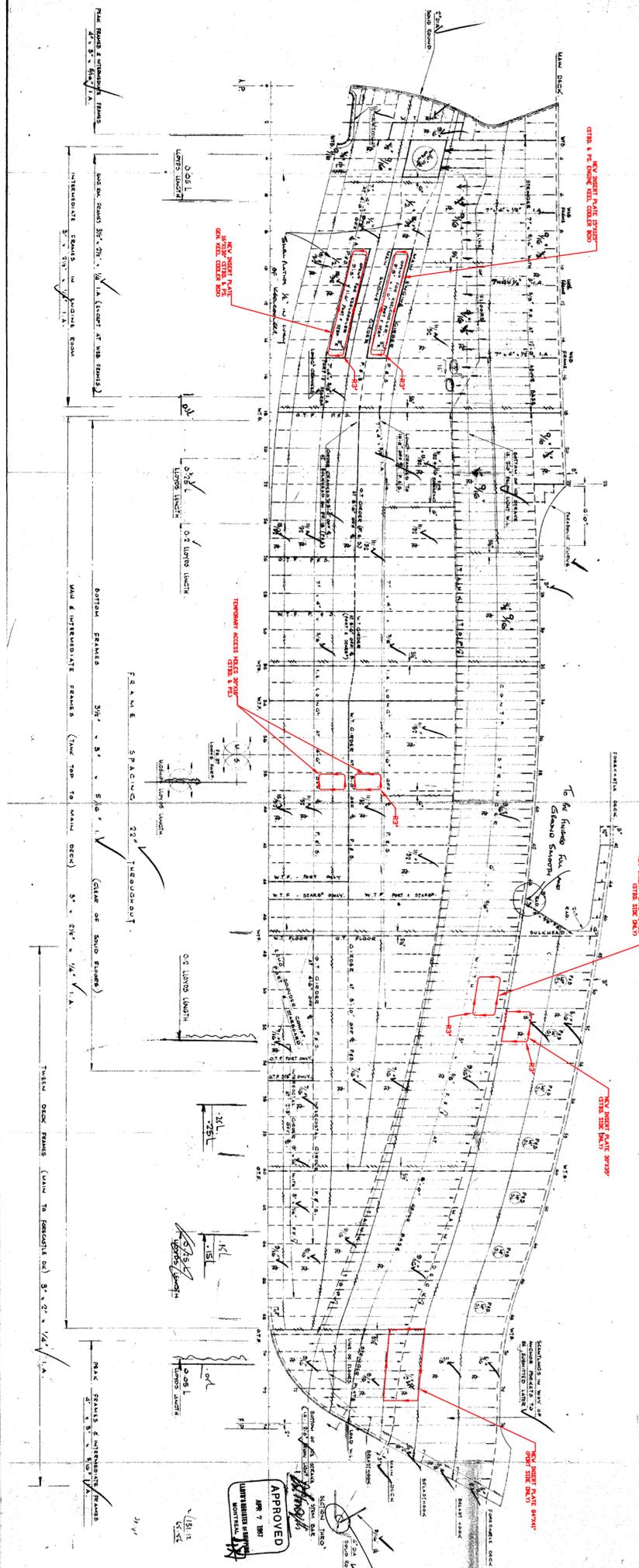
DETAIL OF STITCHED INTERMITTENT WELDING



WELDING TABLE

| Welding Process | Welding Position | Welding Direction | Welding Speed | Welding Temperature | Welding Electrode | Welding Shielding Gas | Welding Wire | Welding Diameter | Welding Length | Welding Spacing | Welding Interference |
|-----------------|------------------|-------------------|---------------|---------------------|-------------------|-----------------------|--------------|------------------|----------------|-----------------|----------------------|
| Automatic | Vertical | Downward | 1/2" to 1" | 200° to 250° | 1/8" to 1/4" | Argon | ER70S-B | 1/8" to 1/4" | 12" to 18" | 1/2" to 1" | 1/2" to 1" |
| Manual | Vertical | Downward | 1/2" to 1" | 200° to 250° | 1/8" to 1/4" | Argon | ER70S-B | 1/8" to 1/4" | 12" to 18" | 1/2" to 1" | 1/2" to 1" |
| Manual | Vertical | Upward | 1/2" to 1" | 200° to 250° | 1/8" to 1/4" | Argon | ER70S-B | 1/8" to 1/4" | 12" to 18" | 1/2" to 1" | 1/2" to 1" |
| Manual | Horizontal | Left to Right | 1/2" to 1" | 200° to 250° | 1/8" to 1/4" | Argon | ER70S-B | 1/8" to 1/4" | 12" to 18" | 1/2" to 1" | 1/2" to 1" |
| Manual | Horizontal | Right to Left | 1/2" to 1" | 200° to 250° | 1/8" to 1/4" | Argon | ER70S-B | 1/8" to 1/4" | 12" to 18" | 1/2" to 1" | 1/2" to 1" |
| Manual | Overhead | Downward | 1/2" to 1" | 200° to 250° | 1/8" to 1/4" | Argon | ER70S-B | 1/8" to 1/4" | 12" to 18" | 1/2" to 1" | 1/2" to 1" |
| Manual | Underneath | Upward | 1/2" to 1" | 200° to 250° | 1/8" to 1/4" | Argon | ER70S-B | 1/8" to 1/4" | 12" to 18" | 1/2" to 1" | 1/2" to 1" |

NOTES -
 1. TOTAL OF SHELL IN WAY OF SEA WELLS TO BE SUBMITTED LATER.
 2. ALL FRAMES LOOK TO MIDSHIP - FRAME BY FRAME FORWARD.
 3. ALL EXPOSED SURFACES SHALL WELD TO BE CARBON STEEL.



APPROVED
 JUN 7 2010
 MONTREAL COPY
 JUN 20 2010

PORT WELER DRY DOCKS LTD.
 87 CATHARINE ONTARIO

PORT WELER DRY DOCKS LTD.
 87 CATHARINE ONTARIO

ACCOUNT NO. 1300
 BANK OF MONTREAL
 BRANCH: 1000 RUELLE
 HULL NO. 47
 PLAN NO. 47 - H. 3