

WELDING

METHOD OF UNIT CONSTRUCTION, FABRICATION AND WELDING REQUIREMENTS TO BE IN ACCORDANCE WITH GENERAL NOTES OF WELDING SEQUENCE DRAWINGS, TO J.S.Q.S. QUALITY STANDARD, AND TO THE SOCIETY'S SATISFACTION.

SCALLOPS AS DETAILED TO BE USED FOR ALL DRAIN AND AIR HOLES I.W.O. INTERSECTIONS OF MAIN MEMBERS ETC. "SNIPE OFFS" ARE NOT PERMITTED.

SCALLOPS IN FRAMING OR STIFFENERS CROSSING JOINTS IN PLATING TO BE OMITTED WHEN SUCH JOINTS ARE COMPLETED BEFORE MEMBER IS APPLIED, WELD AT MEMBER TO BE MADE FLUSH.

LOW HYDROGEN ELECTRODES OR PROCESS TO BE USED FOR ALL WELDING TO EH 38 MATERIAL, TO BE APPROVED FOR USE IN SHIP CONSTRUCTION.

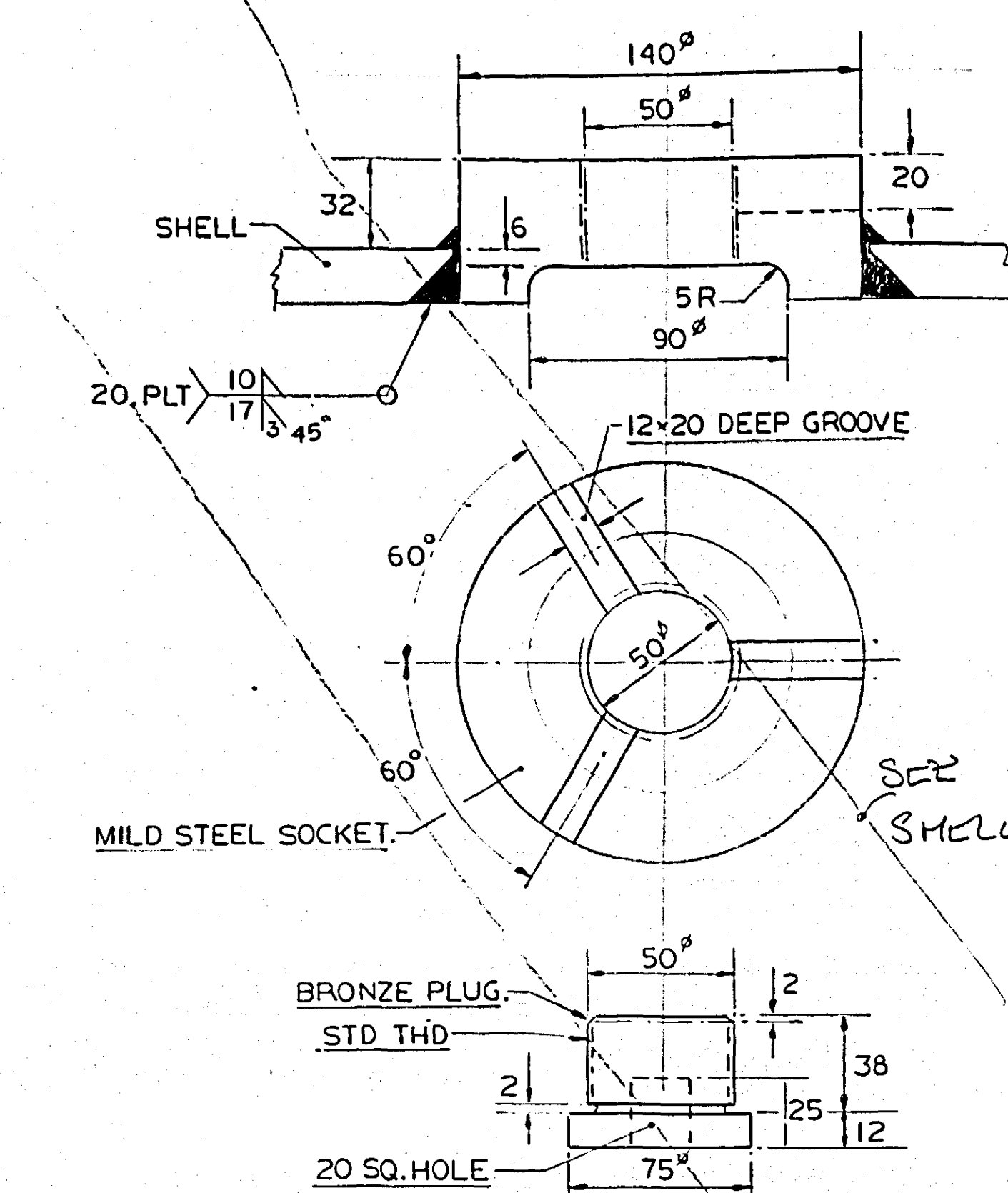
ALL MEMBERS, VERTICAL OR HORIZONTAL, TO BE LEFT LOOSE FROM EDGE OF UNIT BEING FITTED FOR ALIGNMENT AT SHIP.

ALL WELD SIZES ARE THROAT THICKNESS, IN MILLIMETRES.

ALL WELDS ARE FILLET WELDS AND DOUBLE CONTINUOUS EXCEPT AS NOTED.

✓ EXTENT OF SUBMERGED ARC WELDING.

✓ SUBMERGED ARC/MANUAL BACK WELD.



DRAIN PLUG DETAIL N.T.S.

NOTE: WHERE CEMENT FILLING IS REQUIRED TO PREVENT POCKETS OF WATER, DRAIN PLUGS ARE TO BE LOCATED TO SUIT LINE OF CEMENT.

- GENERAL NOTES**
- ALL MATERIAL TO BE LLOYDS GRADE 'A' OR EQUIVALENT EXCEPT WHERE NOTED GR E OR AS SHOWN THUS *
 - * INDICATES GRADE - MODIFIED E.H.36 LUKENS FROST LINE STEEL OR EQUIVALENT.
 - ALL DIMENSIONS ARE IN MM.
 - ALL PLATE N^{OS} DENOTED THUS ○
 - ALL SHAPE N^{OS} DENOTED THUS ◇
 - ADDITIONAL DRAINAGE ARRANGEMENTS AS MAY BE CONSIDERED NECESSARY TO BE TO THE SURVEYOR'S SATISFACTION.

MATERIAL MARK D.B.D.

PLATES ○ ON PLATE SHEET. 3

SHAPES ◇ ON SHAPE SHEET. 3

REFERENCES		
REF. No.	DRAWING TITLE	DWG. No.
1.	MAIN ENGINE SEATING.	07-07-10.
2.	SHELL	07-00-01.
3.	TANK TOP	07-00-03
4.	SIDE UNIT. FR 80 TO 99.	07-08-07/08
5.	D.B. UNIT. FR 60 TO 79	07-07-04/05
6.	SIDE UNIT. L&H. FR 60 TO 79	07-08-05/06
7.	LONGITUDINAL B.H.D.S. FR 27 TO 44.	07-11-01/06
8.	ERECTION & WELDING SEQUENCE.	
9.	D.B. UNIT. Pgs 9	
10.	I.W.T. B.H.D. 99	07-11-12

No.	REVISION	BY	DATE
6	HOLE INCREASED ON FR. 80-91 PLS	BYC	DEC. 22/82
5	ADDITIONAL M.H.S IN T.T. AT OWNERS REQUEST	OWNE	DEC. 8/82
4	FLOOR SCALLOPS ADDED	BYC	JUN 22
3	WELDING REVISIONS. R.BUTT ADDED FR. 99 & GDR. ADDED MANHOLES TO 3500 OFF € GDR.	BYC	JUNE 9
2	WELDING ADDED FLOOR 99 REVISED	BYC	MAY 20
1	ADDITIONAL AIR & DRAIN HOLES	OWNE	
1	DRAIN PLUG DETAIL GIRDER BKT DETAIL ADDED WITH REVISIONS TO SUIT LLOYDS & GERMAN & MILNE APPROVAL.	J.S.	7.4.82

DISTRIBUTION						
DEPARTMENT	QTY.	DEPARTMENT	QTY.	DEPARTMENT	QTY.	QTY.
OWNERS	2	OPERATIONS MANAGER	1	LOFT	1	PIPE FITTER
CLASSIFICATION	4	NEW CONST. SUPT.	1	PLATER	3	MACHINE SHOP
CCOSS.B.	3	REPAIR SUPT.	1	WELDER	2	ENGINE FITTER
GERMAN & MILNE	4	STEEL SUPT.	1	SHIPWRIGHT	2	SHEET METAL
YARROWS	1	WELDING ENGINEER	1	RIGGER	1	ELECTRIC SHOP
HULL D.O.	2	PLANNING	1	JOINER	1	
MACHINERY D.O.	1	BEETH SUPT.	2			
ELECTRICAL D.O.	1					

1st ISSUE APR 22/82

2nd ISSUE MAY 21/82

3rd ISSUE JUN 9/82

Burrard Yards Corporation

SHIPBUILDERS, SHIP REPAIRERS, GENERAL ENGINEERS

Victory Division
P.O. Box 86099, North Vancouver, British Columbia, Canada V7L 4J8

Victory Division
P.O. Box 1030, Victoria, British Columbia, V8W 2S9

DIVISION
VANCOUVER.

HULL 1-07 & 5-54 JOB No.

OWNERS
GULF CANADA RESOURCES INC.

TITLE
DOUBLE BOTTOM UNIT FR 80 TO FR 99 PORT & STBD.

APPROVALS

REPRESENTS	DATE	DRAWN	J. GIBBON
LLOYDS	30.3.82	CHECKED	W. CHAN
G. & M.	1.4.82	APPROVED	
C.S.I.		SCALE AS STATED	DATE 10.3.82
		DWG. No.	07-07-06/07
		REV.	6