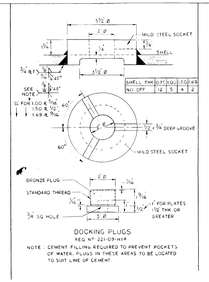
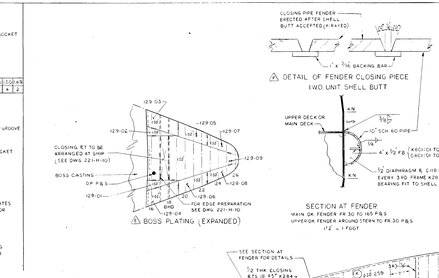
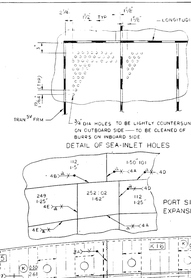
ORIGINAL TRIMMED SIZE (D) X 28 1/2 INCHES

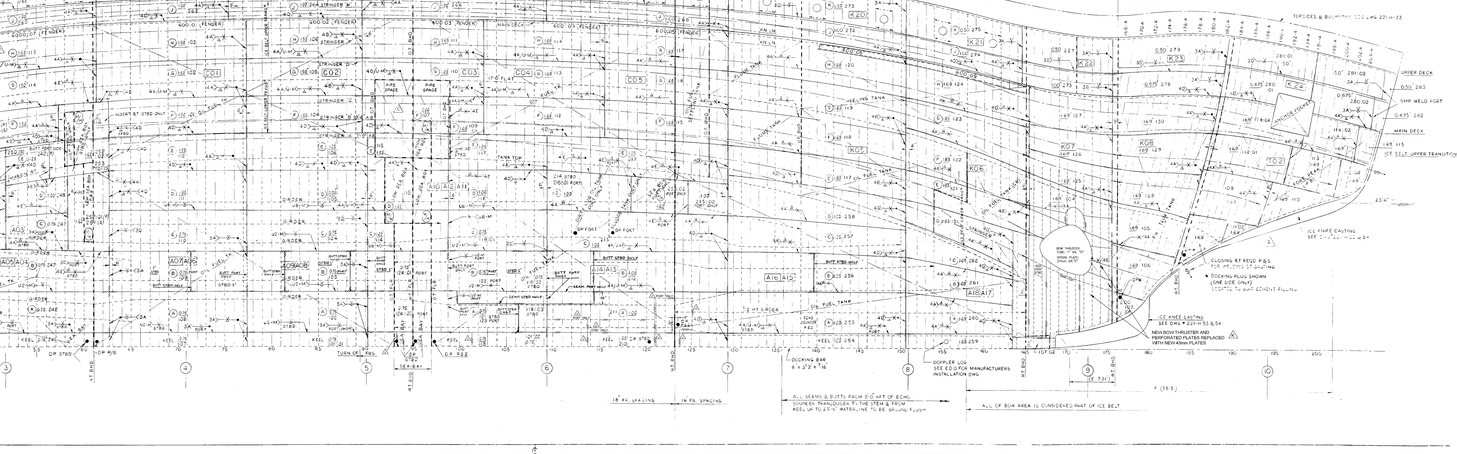
INCHES







BLK'S	SEA BOX	FR	DIA (IN)
STBD	MAIN SEA BOX FWD E R	90/91	730
STBD	LOW SEA BOX FWD E R	95/97	432
PORT	LOW SEA BOX FWD E R	95/97	432
PORT	HIGH SEA BOX AFT E R	92/95	1120
PORT	LOW SEA BOX AFT E R	92/95	2048
STBD	LOW SEA BOX AFT E R	92/95	2048
PORT	LOW SEA BOX PROP MOTOR RM	90/91	923
STBD	LOW SEA BOX PROP MOTOR RM	90/91	923
STBD	HIGH SEA BOX PROP MOTOR RM	89/90	923
STBD	MAIN SEA BOX SUB BILGE & SERVICE PUMP	88/89	272
STBD	LOW SEA BOX SPRINKLER PUMP	90/91	272
PORT	EVAPORATOR SEA INLET BOX	100/101	265



WELDING NOTES:

DOUBLE CONTINUOUS WELDING AND LOW HYDROGEN ELECTRODES SHALL BE USED FOR ALL WELDING OF INTERNAL STRUCTURE BELOW MAIN DECK TO SHELL. LOW HYDROGEN ELECTRODES TO BE USED FOR ALL JOINTS IN SHELL PLATING BELOW MAIN DECK, F. STRAKE AND ALL WELDING TO HULL CASTINGS. REFER TO ERECTION AND WELDING DWG. GENERAL NOTES (DWG 221-H) FOR ELECTRODE CLASS, PREHEAT, AND PROCEDURE TESTS REQUIRED.

GENERAL NOTES:

1. METHOD OF UNIT CONSTRUCTION, FABRICATION AND WELDING REQUIREMENTS ARE IN ACCORDANCE WITH GENERAL NOTES OF WELDING SEQUENCE DRAWING 221-H-14 (SHELL AND DK 221-H-42 DECKS).
2. SCALLOPS TO BE USED ON ALL WELDED JOINTS IN DIRECTIONS OF FRAMING MEMBERS AND BRACKETS. SHAPE NOT PRESCRIBED.
3. SCALLOPS IN FRAMING MEMBERS CROSSING JOINTS IN PLATING TO BE OMITTED WHERE SUCH JOINTS ARE COMPLETED BEFORE FRAMING APPLIED AND WELD WILL FLUSH AT MEMBER.
4. ALL SHELL PLATING BELOW MAIN DECK TO BE LLOYDS QUALITY GR.2 REMAINDER OF SHELL (MAIN TO UPPER DECK) TO BE LLOYDS QUALITY GR.1
5. PLATE THKS INDICATED ARE THE MINIMUM CLASSIFICATION REQUIREMENTS. FOR PLATES REQUIRING EXTENSIVE WORKING A 10% INCREASE IN THICKNESS HAS BEEN ADDED TO ENSURE MATERIAL (I.E. 1ST RT GROOVED 1.1 IN)
6. ICE BELT PLATING AND SHELL INSERTS WHERE THICKNESS OF PLATES JOINED VARIES IN EXCESS OF THE THICKER PLATE TO BE CHAMFERED 1:5. ELSEWHERE SHELL CLEAR OF ICE BELT 1:4.
7. REQUIREMENTS OF SPEC H-12.5 REGARDING REMOVAL OF ERECTION LUGS (H-1) TO BE STRICTLY ADHERED TO. PLATING TO BE EXAMINED AFTER ALL WELDING IS COMPLETED AND BEFORE PAINTING IS COMMENCED, FOR SURFACE LAMINATION OR FLAWS

FOR MATERIAL IDENTIFICATION MAIN/HULL BLOCKS & BLOCK CODES

BLOCK	BLOCK CODE
DOUBLE BOTTOM	B
AFT END BLOCK	A
WING TANK UNITS	C
SIDE SHELL	K
FORWARD UNITS	T

REFERENCE DRAWINGS	
TANK TOP & D.B. GIRDERS, DPT. & F	221-H-01
FLOORS UNDER PROPULSION RM. FR 20/101	2
FLOORS UNDER GENERATOR RM. FR 5-42-102	3
FLOORS, FR 102/HR	4
FLOORS, FR 1 THRUSTER COMPT	5
FLOORS, FR 1 TO FR 20 INCL. BHD. & DPT.	6
FLOORS, FR 42-102 INCL. BOSS PLATING, APPROACHES	7
FLOORS, FR 5-42 INCL. RUDDER FR. & BHD FR. C	8
FRONTAL EXPANSION	12
1ST & 2ND STRINGER PLATE	13
3RD FRAMES, REAR PLAT & LOWER BHD. GIRDERS	14
3RD FRAMES FR 1-20	15
AFT FRAMES & CANT FRG. FR 101-HR	16
TRANSV BHDS FR 20/101 & 101	17
TRANSV BHDS FR 102-HR	18
TRANSV BHDS FR 1 TO 20 INCL. & OF TANK BHD	20
TRANSV BHDS FR 1 TO 20 INCL. & OF TANK BHD	21
DECKS, TRANSV BHDS, DPT. FR 101 & FORWARD	22
ARRANGEMENT OF UNIT JOINTS	40
WELDING SEQUENCE DECKS	41
NON-DESTRUCTIVE INSPECTION	42
TANK TESTING PLAN	43
RUDDER CASTING & STEERFRAME CASTING	48
USE JOINT CASTING IN STERN BAR	49
STERN CASTING ARRANGEMENT	50
STEM CASTING DETAILS	54

K	NEW BOW THRUSTER INSTALLED AND PERFORATED PLATES REPLACED		
J	PLATES REPAIRED		
I	STBD BUNKER PLATING MODIFIED		
H	AS FITTED HULL 221		
G	FORE END REN. REARRANGED		
F	DETAIL OF FENDER CLOSING PIECE WELDING DETAIL TWO CASTING RABBET ADDED		
E	BUTTING & SEAMS MOVED UNIT BOT. PLG. WITH ADDED ARRANGEMENT OF SHAFT BRACKET		
D	1st ARRANGT. & DETAILS REDGS & 1st ARRANGT. & DETAILS REQMT. UPDATE		
C	1st ISSUE (1st UNIT CONSTRUCTION METHOD WITH ADDED DETAILS & NOTES)		
B	3rd ISSUE		
A	FIRST ISSUE FOR APPROVAL		

DRAWN			
DESIGN			
CHECKED			
APPROVED			
DATE			
SCALE			
DRAWING NO.			

BUL. DOFL. / EQD. LTD.
SHIPBUILDERS & ENGINEERS
VANCOUVER, B.C.

PROJECT: HULL
TITLE: SHELL EXPANSION
SHEET: 1 OF 1
DWG No: 221-H-1

BLUE 55