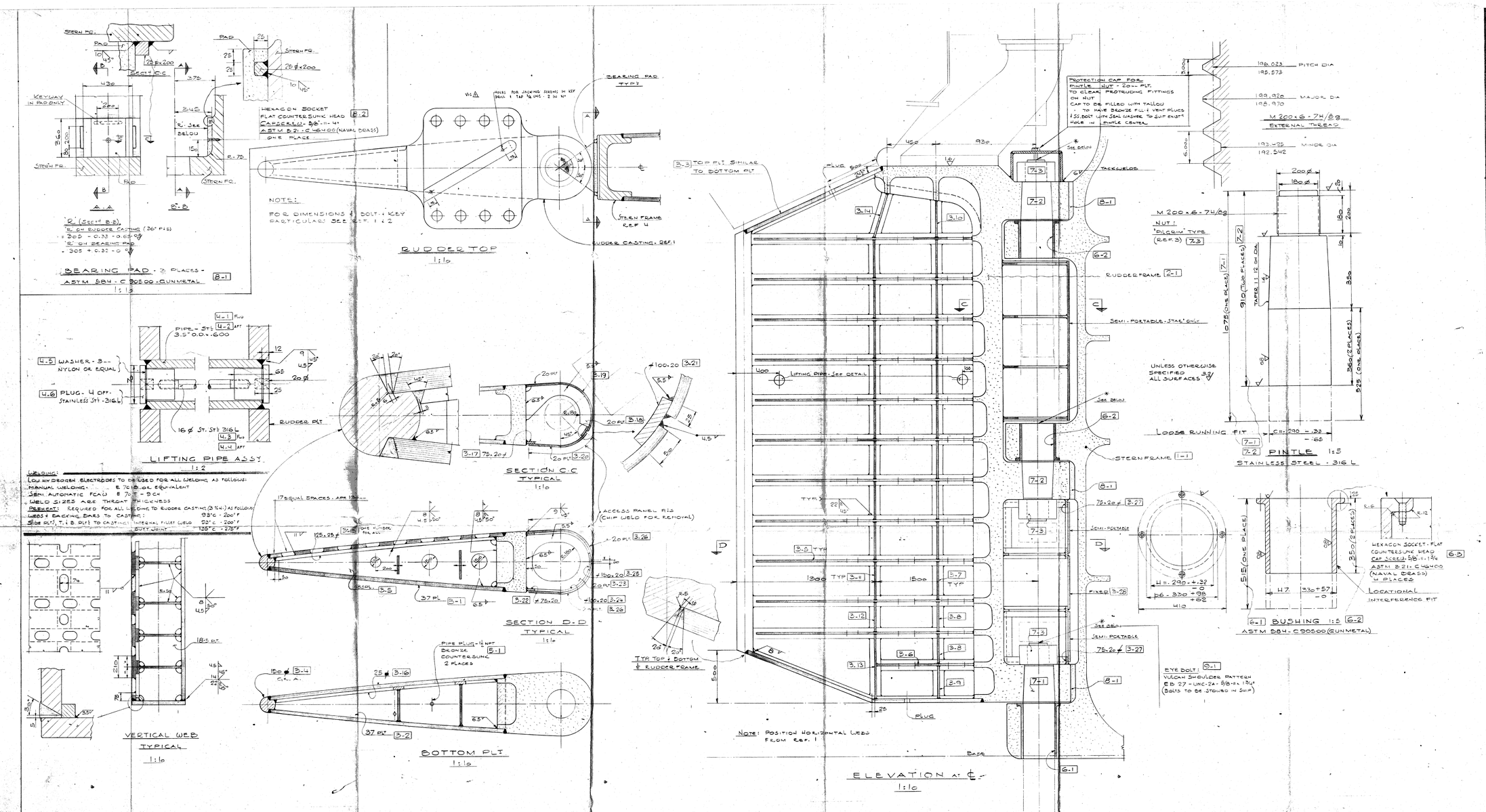
BEARING PAD - 3 PLACES -
ASTM 584 - C 90500 - GUNMETAL
1:1.5
RUDDER TOP
1:10
LIFTING PIPE ASSY.
1:2
SECTION C-C
TYPICAL
1:10
SECTION D-D
TYPICAL
1:10
VERTICAL WEB
TYPICAL
1:10
BOTTOM PLT
1:10
ELEVATION AT ℄
1:10
PINTLE 1:5
STAINLESS STEEL - 316 L
BUSHING 1:5
ASTM 584 - C90500 (GUNMETAL)
LOCATIONAL
INTERFERENCE FIT
NOTE:
FOR DIMENSIONS & BOLT & KEY PARTICULARS SEE REF. 1 & 2
Note: POSITION HORIZONTAL WEBS FROM REF. 1
WELDING:
LOW HYDROGEN ELECTRODES TO BE USED FOR ALL WELDING AS FOLLOWS:
MANUAL WELDING - E 7018 OR EQUIVALENT
SEMI AUTOMATIC FCAW - E 70T - 9C1
WELD SIZES ARE THROAT THICKNESS
PREHEAT: REQUIRED FOR ALL WELDING TO RUDDER CASTING (3% Ni) AS FOLLOWS
WEBS & BACKING BARS TO CASTING: 93°C - 200°F
SIDE PLT, T. & BLT TO CASTING: INTERNAL FILLET WELD 93°C - 200°F
SIDE PLT TO WEBS: BUTT WELD 135°C - 275°F
GENERAL NOTES
1. CASTING:
THE RUDDER IS TO BE TESTED FOR CASTER MOUNTING
THE DIA HEAD OF GATE OF 2.1 m (7 ft)
AT PRESSURE OF 2V ER (2.5 psi)
WHILE LAYING FLAT
TO THE SATISFACTION OF LLOYDS & C.S.I. OWNER.
2. INTERNAL TREATMENT:
FOLLOWING TESTING THE INTERNALS ARE TO BE COATED WITH A BITUMINOUS COMPOSITION BY MEANS OF FILLING AND DRAINING.
3. MATERIAL: LLOYDS GRADE 'E' (SACKET GRADE 'HIGH' OR 'I' STAMP)
4. EXPOSED PLT EDGES TO BE SLIGHTLY ROUNDED
5. DWG. IN CLOSING PLT TO BE FILLED SMOOTH WITH TOUCH CONFOUND OR EQUAL.
6. WELDING: SEE NOTE ON DRAWING.
REFERENCES
DISTRIBUTION
MATERIAL:
INSTALLATION PARTS LIST OUTFIT MARKED
ZONE: 112
AS FITTED
Burrard Yarrows Corporation
DIVISION
VESSEL OWNER
OWNERS GULF OIL
TITLE
RUDDER
ARRANGEMENT & DETAILS
DWG. No. 250101
REVISIONS