



WELDING -

THICKNESS	WELD TYPE	WELD SIZE	WELD LENGTH	WELD SPACING
1/4"	1/2" DC	1/4"	3" - 10"	10"
3/8"	3/8" DC	3/8"	3" - 10"	10"
1/2"	1/2" DC	1/2"	3" - 10"	10"
3/4"	3/4" DC	3/4"	3" - 10"	10"
1"	1" DC	1"	3" - 10"	10"
1 1/4"	1 1/4" DC	1 1/4"	3" - 10"	10"
1 1/2"	1 1/2" DC	1 1/2"	3" - 10"	10"
1 3/4"	1 3/4" DC	1 3/4"	3" - 10"	10"
2"	2" DC	2"	3" - 10"	10"
2 1/4"	2 1/4" DC	2 1/4"	3" - 10"	10"
2 1/2"	2 1/2" DC	2 1/2"	3" - 10"	10"
2 3/4"	2 3/4" DC	2 3/4"	3" - 10"	10"
3"	3" DC	3"	3" - 10"	10"
3 1/4"	3 1/4" DC	3 1/4"	3" - 10"	10"
3 1/2"	3 1/2" DC	3 1/2"	3" - 10"	10"
3 3/4"	3 3/4" DC	3 3/4"	3" - 10"	10"
4"	4" DC	4"	3" - 10"	10"
4 1/4"	4 1/4" DC	4 1/4"	3" - 10"	10"
4 1/2"	4 1/2" DC	4 1/2"	3" - 10"	10"
4 3/4"	4 3/4" DC	4 3/4"	3" - 10"	10"
5"	5" DC	5"	3" - 10"	10"
5 1/4"	5 1/4" DC	5 1/4"	3" - 10"	10"
5 1/2"	5 1/2" DC	5 1/2"	3" - 10"	10"
5 3/4"	5 3/4" DC	5 3/4"	3" - 10"	10"
6"	6" DC	6"	3" - 10"	10"
6 1/4"	6 1/4" DC	6 1/4"	3" - 10"	10"
6 1/2"	6 1/2" DC	6 1/2"	3" - 10"	10"
6 3/4"	6 3/4" DC	6 3/4"	3" - 10"	10"
7"	7" DC	7"	3" - 10"	10"
7 1/4"	7 1/4" DC	7 1/4"	3" - 10"	10"
7 1/2"	7 1/2" DC	7 1/2"	3" - 10"	10"
7 3/4"	7 3/4" DC	7 3/4"	3" - 10"	10"
8"	8" DC	8"	3" - 10"	10"
8 1/4"	8 1/4" DC	8 1/4"	3" - 10"	10"
8 1/2"	8 1/2" DC	8 1/2"	3" - 10"	10"
8 3/4"	8 3/4" DC	8 3/4"	3" - 10"	10"
9"	9" DC	9"	3" - 10"	10"
9 1/4"	9 1/4" DC	9 1/4"	3" - 10"	10"
9 1/2"	9 1/2" DC	9 1/2"	3" - 10"	10"
9 3/4"	9 3/4" DC	9 3/4"	3" - 10"	10"
10"	10" DC	10"	3" - 10"	10"

NOTES -

- MAIN & INTERMEDIATE FRAMES TO SHELL.
- BOTTOM FRAMES TO SHELL.
- STIFFERS TO SHELL.
- BOTTOM LONGS TO SHELL.
- OUTLIGHT GIRDER TO SHELL & TANK TOP.
- GIRDER TO SHELL.
- GIRDER TO TANK TOP & FLOORS.
- FLOORS TO BOTTOM SHELL (OUTLIGHT).
- CENTRE GIRDER (OUTLIGHT).
- TANK TOP (OUTLIGHT).
- BOUNDARIES OF W.T. BULKHEAD.
- CENTRE GIRDER TO KEEL (OUTLIGHT).
- CENTRE GIRDER TO PIPE DUCT (OUTLIGHT).
- PIPE DUCT TO TANK TOP & W.T.
- BECKET FLOORS.
- FLOORS TO SHELL, TANK TOP, GIRDERS.
- MINOR BULKHEAD BOUNDARIES.
- BEAMS TO TANK TOP.
- STIFFERS TO DECK.
- STIFFERS TO W.T. BULKHEAD.
- F.B. TO TANK TOP.
- BEAM KNEES.
- FRAME EXTS.
- GIRDER END BKT.
- GIRDERS TO DECK.
- TRIPPING EXTS.

PORT WELDER DRY DOCKS LIMITED
MAY 11 1967
ST. CATHARINES, ONTARIO
APPROVED
MAY 18 1967
LLOYD'S REGISTER OF SHIPPING
MONTREAL
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