

REPORT ON BOILERS.

Received at London Office 7 JUN 1943

Date of writing Report April 14th, 43 When handed in at Local Office April 14th, 43 Port of Vancouver, B. C.

No. in Reg. Book. Survey held at Vancouver, B. C. Date, First Survey March 1st, 1943 Last Survey April 13th, 1943

-- on the Steel Single Screw Steamer "FORT ASH" (Number of Visits 20) Tons {Gross 7131.07
Net 4245.02

Built at North Vancouver, B.C. By whom built Burrard Dry Dock Co. Ltd. Yard No. 174 When built 1943

Engines made at Montreal, P.Q. By whom made Dominion Engineering Works Engine No. 79 When made 1943

Boilers made at Vancouver, B. C. By whom made Dominion Bridge Co. Ltd. Boiler No. (392, 393 & 397) When made 1943

Nominal Horse Power 504 Owners Minister of Munitions & Supply of Canada. Port belonging to

MULTITUBULAR BOILERS—MAIN, ~~AUXILIARY~~, OR ~~DONKEY~~.

Manufacturers of Steel Worth Steel Co., Lukens Steel Co., American Welding Co., Bethlehem Steel Co. (Letter for Record --)

Total Heating Surface of Boilers 7140 sq. ft. Is forced draught fitted Yes Coal or Oil fired Coal

No. and Description of Boilers Three Single ended cylindrical multitubular Working Pressure 220 lbs.

Tested by hydraulic pressure to 380 lbs. Date of test 12-3-43 No. of Certificate 392 Can each boiler be worked separately Yes

Area of Firegrate in each boiler 51 sq. ft. No. and Description of Safety valves to each boiler Two - 2-1/4" dia. Morrison High Lift

Area of each set of valves per boiler {per Rule 6.35 sq. ins. as fitted 7.95 sq. ins. Pressure to which they are adjusted 220 Are they fitted with easing gear Yes

In case of donkey boilers, state whether steam from main boilers can enter the donkey boiler No donkey boiler

Smallest distance between boilers or uptakes and bunkers or woodwork 2 ft. Is oil fuel carried in the double bottom under boilers No

Smallest distance between shell of boiler and tank top plating 2 ft. Is the bottom of the boiler insulated Yes

Largest internal diameter of boilers 14'-6-3/16" Length 11'-9" ext. Shell plates: Material O.H. Steel Tensile strength 29 - 33 tons

Thickness 1-13/32" Are the shell plates welded or flanged No Description of riveting: circ. seams {end Double inter --

Long. seams Treble Riv. Double Butt straps. Diameter of rivet holes in {circ. seams 1-1/2" long. seams 1-1/2" Pitch of rivets {4-3/16" approx. 10-1/16"

Percentage of strength of circ. end seams {plate 64.2% rivets 47.6% Percentage of strength of circ. intermediate seam {plate -- rivets --

Percentage of strength of longitudinal joint {plate 85.1% rivets 92.8% combined 88.7%

Thickness of butt straps {outer 1-3/32 inner 1-7/32 No. and Description of Furnaces in each Boiler 3 Morrison Corrugated Stephen Gourley end.

Material O.H. Steel Tensile strength 26 - 30 tons Smallest outside diameter 41-9/16"

Length of plain part {top 9-3/16" bottom 9-3/16" Thickness of plates {crown 21/32" bottom -- Description of longitudinal joint Forge Weld

Dimensions of stiffening rings on furnace or c.c. bottom --

End plates in steam space: Material O.H. Steel Tensile strength 26 - 30 tons Thickness 1-7/16" Pitch of stays 21" x 21"

How are stays secured Double nuts & 6-3/4" x 1/4" washers each end.

Tube plates: Material {front O.H. Steel back O.H. Steel Tensile strength {26 - 30 tons 26 to 30 tons Thickness {31/32 13/16

Mean pitch of stay tubes in nests 9.82" Pitch across wide water spaces 8-1/4" x 14-1/2"

Girders to combustion chamber tops: Material O.H. Steel Tensile strength 29 - 33 tons Depth and Thickness of girder double 10-1/4" x 7/8"

at centre 10-1/4" x 7/8" Length as per Rule 34" Distance apart 11" No. and pitch of stays in each 3 - 7-5/8

Combustion chamber plates: Material O.H. Steel Tensile strength 26 - 30 tons Thickness: Sides 25/32 Back 23/32 Top 25/32 Bottom 25/32

Pitch of stays to ditto: Sides 9"x10-3/16" Back 9"x8 1/2" Cent CC Top 7-5/8" x 11" Are stays fitted with nuts or riveted over nuts

Front plate at bottom: Material O.H. Steel Tensile strength 26 - 30 tons

Thickness 31/32" Lower back plate: Material O.H. Steel Tensile strength 26 - 30 tons Thickness 29/32

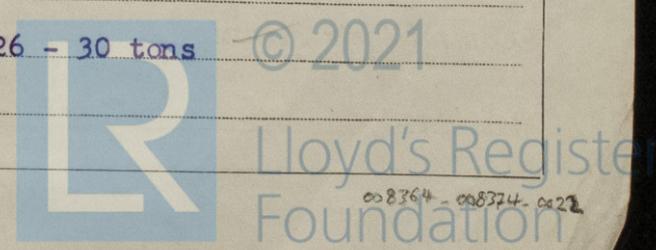
Pitch of stays at wide water space 9" x 14-1/2" Are stays fitted with nuts or riveted over nuts

Main stays: Material O.H. Steel Tensile strength 28 - 32 tons

Diameter {At body of stay 3-1/2" or 3-3/4" No. of threads per inch 6

Screw stays: Material O.H. Steel Tensile strength 26 - 30 tons

Diameter {At turned off part 1.606 or 1-3/4" No. of threads per inch 9



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Are the stays drilled at the outer ends No Margin stays: Diameter { At turned off part 1.856" or Over threads 2"

No. of threads per inch 9

Tubes: Material O.H. Steel External diameter { Plain 3" Stay 3" Thickness { .16" No. of threads per inch 9

Pitch of tubes 4-1/8" x 4-1/4" Manhole compensation: Size of opening in shell plate 16" x 12" Section of compensating ring -- No. of rivets and diameter of rivet holes { Upper 4-1/4" Lower 3-1/2" Steam Dome: Material --

Outer row rivet pitch at ends -- Depth of flange if manhole flanged 4-1/4" Tensile strength -- Thickness of shell -- Description of longitudinal joint --

Diameter of rivet holes -- Pitch of rivets -- Percentage of strength of joint { Plate -- Rivets --

Internal diameter -- Thickness of crown -- No. and diameter of stays -- Inner radius of crown --

How connected to shell -- Size of doubling plate under dome -- Diameter of rivet holes and pitch of rivets in outer row in dome connection to shell --

Type of Superheater "ELESCO" Smoke box type Manufacturers of { Tubes (National Tube Co., Steel forgings (Pittsburg, Penna.) Steel castings

Number of elements 58 Material of tubes S.D. Steel Internal diameter and thickness of tubes .69" .095" (BBWG min.)

Material of headers O.H. Steel Tensile strength 33.5 tons Thickness 1-1/8" min. Can the superheater be shut off and the boiler be worked separately No Is a safety valve fitted to every part of the superheater which can be shut off from the boiler Yes

Area of each safety valve 1.75 per sq. inch Are the safety valves fitted with easing gear Yes

Pressure to which the safety valves are adjusted 220 lbs. per sq. inch Hydraulic test pressure: tubes 2500 lbs. per sq. inch. forgings and castings 550 lbs. per sq. inch. and after assembly in place Steam test Are drain cocks or valves fitted to free the superheater from water where necessary Yes

Have all the requirements of Sections 14 to 22 inclusive for boilers been complied with Yes

The foregoing is a correct description,
Dominion Bridge Co. Ltd Manufacturer.
per J. H. Ross

Dates of Survey { During progress of work in shops -- } 1943. March 1, 4, 6, 9, 12, 15, 17. Are the approved plans of boiler and superheater forwarded herewith Approved Plans in U.K. (If not state date of approval.)

{ During erection on board vessel -- } 1943. March 20, 22, 27, 31. April 1, 2, 4, 5, 7, 8, 9, 12, 13. Total No. of visits 20

Is this Boiler a duplicate of a previous case Yes If so, state Vessel's name and Report No. S.S. "FORT ST. JAMES" (Ver. Rpt. No. 5718).

GENERAL REMARKS (State quality of workmanship, opinions as to class, &c.) These boilers have been constructed under special survey of tested materials in accordance with the approved plans, New York letters and otherwise in conformity with the Society's Rules. On completion the boilers were satisfactorily tested under hydraulic pressure to 380 lbs. per sq. inch.

They were fitted on board under special survey, examined under working conditions, safety valves adjusted under steam to the working pressure and a satisfactory accumulation test carried out.

Cross seam of both end plates is fusion welded by Union Melt Process, stress relieved and x-rayed under survey. Certificate attached. Welds ground flush both sides of plate. Combustion Chamber wrapper plates welded to back tube plate and Combustion Chamber back plate; wrapper plate butts also selded, all hand welding and ground flush and tested as per Rule.

Survey Fee ... £ \$150.00 : } When applied for, 13th Apr. 1943

Travelling Expenses (if any) £ 15.00 : } When received, 19

R. Knox W. B. Baillie
 Engineer Surveyor to Lloyd's Register of Shipping.

Committee's Minute FRI. 11 JUN 1943

Assigned See F. E. Mchey Rpt.

