

REPORT ON BOILERS.

No. 6998

Received at London Office

8 AUG 1946

Date of writing Report 3rd June, 1946 When handed in at Local Office 3rd June, 1946 Port of Vancouver, B. C.

No. in Reg. Book. Survey held at Victoria, B. C.

Date, First Survey 26th Nov., 1945 Last Survey 16th May, 1946

on the Steel Single Screw Steamer "OTTAWA PANDORA"

(Number of Visits Constant attendance
Tons { Gross 909.21
Net 424.13

Built at Victoria, B.C. By whom built Victoria Machinery Depot Co. Ltd. Yard No. 42 When built 1946

Engines made at Lachine, P.Q. By whom made Canadian Allis-Chalmers Ltd. Engine No. 585 When made 1946

Boilers made at Vancouver, B. C. By whom made Dominion Bridge Co. Ltd. Boiler No. 900 When made 1945

Nominal Horse Power 162 Owners Canadian Government

Port belonging to -

s No. 13.2 MULTITUBULAR BOILERS—MAIN, ~~AUXILIARY, OR DONKEY.~~The Steel Co. Of Canada Ltd., Taylor Forge Furness,
Manufacturers of Steel Carnegie-Illinois Steel Corpn., Page-Hersey Tubes.

Total Heating Surface of Boilers 2790 sq. Ft. (2 boilers) Is forced draught fitted Yes (Letter for Record S)

No. and Description of Boilers 2 - Single Ended Cylindrical Multitubular Working Pressure 200 lbs / sq. inch

Tested by hydraulic pressure to 350 lbs. Date of test 29-12-45 No. of Certificate 899-900 Can each boiler be worked separately Yes

Area of Firegrate in each Boiler None fitted No. and Description of safety valves to each boiler 2 - Morrison High Lift

Area of each set of valves per boiler { per Rule 4.05 sq. inch
as fitted 6.28 sq. inch Pressure to which they are adjusted 200 lbs. sq. inch 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 12" Is oil fuel carried in the double bottom under boilers Yes

Spec smallest distance between shell of boiler and tank top plating 18" Is the bottom of the boiler insulated Yes

good Largest internal dia. of boilers 11'-6-15/16" Length 11' 0" Ext. Shell plates: Material O.H. Steel Tensile strength 65000-77000 lbs

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

long. seams Treble Riv. Double But Strap Diameter of rivet holes in { circ. seams 1-1/8" Pitch of rivets { 3 1/4" approx. 7-13/16"

Percentage of strength of circ. end seams { plate 65.38
rivets 47.05 Percentage of strength of circ. intermediate seam { plate - rivets -Percentage of strength of longitudinal joint { plate 85.6
rivets 91.72 combined 89.53 Working pressure of shell by Rules 201.3 lbs. per sq. inchThickness of butt straps { outer 25/32
inner 29/32 No. and Description of Furnaces in each Boiler 3 Morison Corrugated-Stephen Gourley end

Material O.H. Steel Tensile strength 55000 - 65000 lbs. Smallest outside diameter 33 1/4" Thickness of plates { crown 1/2" Description of longitudinal joint Electric Arc Welded

Length of plain part { top 7 1/4" bottom 7 1/4" Working pressure of furnace by Rules 204.4 lbs. per sq. inch

End plates in steam space: Material O.H. Steel Tensile strength 58000-68000 lbs. Thickness 1" Pitch of stays 15" x 15"

How are stays secured Double Nuts & 5 1/4" x 1/4" washers at each end Working pressure by Rules 205 lbs.

Tube plates: Material { front O.H. Steel Tensile strength { 58000-68000 lbs. Thickness { 1" 25/32"

Mean pitch of stay tubes in nests 9.31" Pitch across wide water spaces 8" x 14" Working Pressure { front 266.1 lbs. back 252.5 lbs.

Girders to combustion chamber tops: Material O.H. Steel Tensile strength 58000 - 68000 lbs. Depth and thickness of girder

at centre Double 10"x15/16" Length as per Rule 36" Distance apart 10" No. and pitch of stays

in each 3 @ 8 1/2" Working pressure by Rules 208.7 lbs. / sq. in. Combustion chamber plates: Material O.H. Steel

Tensile strength 58000 - 68000 lbs. Thickness: Sides 23/32" Back 23/32" Top 23/32" Bottom 23/32"

Pitch of stays to ditto: Sides 9"x8 1/2" wing to shell centre 10"x8 1/2" wing Top 10"x8 1/2" Are stays fitted with nuts or riveted over Nuts

Working pressure by Rules 201.7 lbs. / sq. inch Front plate at bottom: Material O.H. Steel Tensile strength 58000-68000 lbs.

Thickness 1" Lower back plate: Material O.H. Steel Tensile strength 58000-68000 lbs. Thickness 1"

Pitch of stays at wide water space 10"x14 1/2" Are stays fitted with nuts or riveted over Nuts

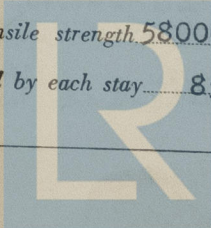
Working pressure 232.3 lbs./sq. in. Main stays: Material O.H. Steel Tensile strength 62720-71680 lbs.

Diameter { At body of stay 2 1/2" No. of threads per inch 6 Area supported by each stay 225 sq. inch

Working pressure by Rules 238.1 lbs./Sq. in. Screw stays: Material O.H. Steel Tensile strength 58000 - 68000 lbs.

Diameter { At turned off part, - No. of threads per inch 9 Area supported by each stay 85 sq. inch

Over threads 1 3/4"



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Working pressure by Rules 213.5 lbs. per sq. inch. Are the stays drilled at the outer ends No. Margin stays: Diameter { At turned off part, - or Over threads 2" No. of threads per inch 9 Area supported by each stay 115 sq. inches Working pressure by Rules 215.2 lbs. per sq. Tubes: Material O.H. Steel External diameter { Plain 3" Thickness { 8 L.S.G. No. of threads per inch 9 Stay 3" Pitch of tubes 4" x 4 1/4" Working pressure by Rules 250 lbs. / sq. inch Manhole compensation: Size of opening in shell plate 21-1/8" x 17-1/8" Section of compensating ring 1-1/16" thick No. of rivets and diameter of rivet holes 32 @ 1-3/8" Outer row rivet pitch at ends 10" Depth of flange if manhole flanged 3 3/4" Steam Dome: Material - 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 - Working pressure by Rules - Thickness of crown - No. and diameter of stays - Inner radius of crown - Working pressure by Rules - 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 None fitted Manufacturers of { Tubes - Steel forgings - Steel castings - Number of elements - Material of tubes - Internal diameter and thickness of tubes - Material of headers - Tensile strength - Thickness - Can the superheater be shut off and the boiler be worked separately - Is a safety valve fitted to every part of the superheater which can be shut off from the boiler - Area of each safety valve - Are the safety valves fitted with easing gear - Working pressure as per Rules - Pressure to which the safety valves are adjusted - Hydraulic test pressure: tubes - forgings and castings - and after assembly in place - Are drain cocks or valves fitted to free the superheater from water where necessary - 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
J. J. [Signature]

Manufacturer.

Dates of Survey { During progress of work in shops - Constant attendance from 26th November, 1945 to 16th May, 1946 Are the approved plans of boiler and superheater forwarded herewith 7-8-45 while building { During erection on board vessel - for Classification and Owners' Total No. of visits - Representation

S. S. "OTTAWA PANDA"

Is this Boiler a duplicate of a previous case Yes If so, state Vessel's name and Report No. Vancouver Report No. 6789

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 350 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.

Vertical seams of both end plates are fusion welded by Union Melt Process; stress relieved under Survey. Welds ground flush on both sides of plate. Combustion chamber wrapper plate welded to back tube plate and combustion chamber back plate; butts of combustion chamber wrapper plates also welded, all by manual electric welding tested as per Rule and ground flush.

Survey Fee ... \$140 00 :
Travelling Expenses (if any) 15 00 :

When applied for 5th June, 1946
When received 19

J. J. [Signature]
Engineer Surveyor to Lloyd's Register of Shipping.

Committee's Minute FRI. 23 AUG 1946

Assigned For minute see F.E. Kelly, Rph.



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