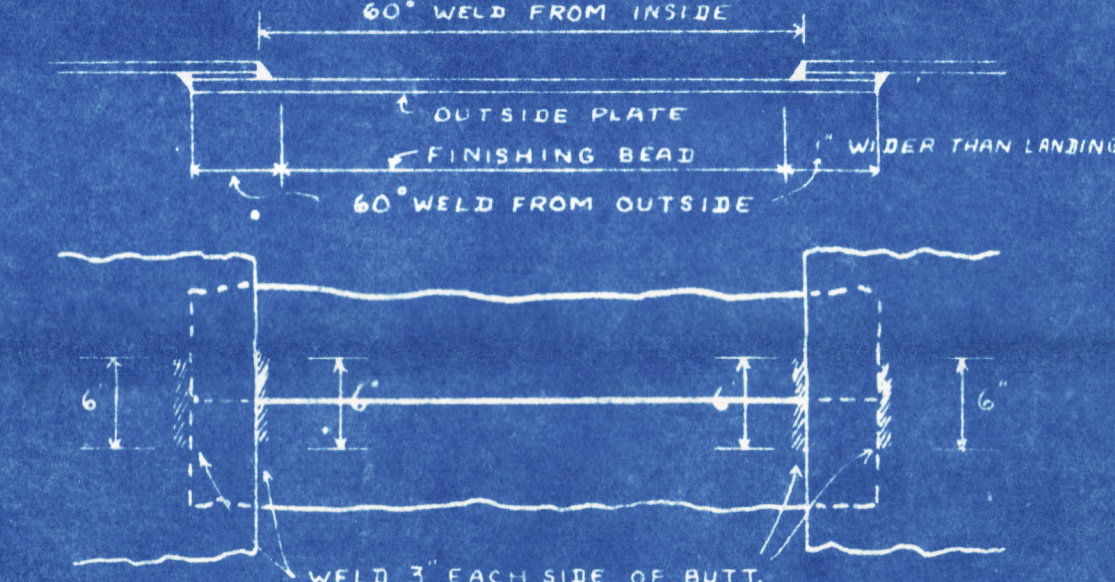


LENGTH B.P.	416'-0"
BREADTH EXTR.	57'-1"
BREADTH MLD.	56'-10 1/2"
DEPTH MLD. UPPER DK.	37'-4"
DEPTH MLD. SECOND DK.	28'-7"
DEPTHS TO LENGTH-UPPER DK.	11.14

WELDING NOTES

FLAT KEEL	WELD BUTTS FROM INSIDE (WELD IN WAY OF C.V.K. BARS AND SEAMS ONLY). DO NOT COMPLETE WELD UNTIL C.V.K. AND GARBOARD STRAKES ARE BOLTED UP.
C.V. KEEL	WILL COME RIVETED COMPLETE EXCEPT IN WAY OF BUTTS OF PLATING. SHORT BARS APPROX. 15" x 30" LONG TO BE INTRODUCED HERE AND FITTED AFTER C.V.K. IS IN PLACE AND BUTTS WELDED.



ALL BUTTS OF BOTTOM SHELL TO BE VEEED OUT AND WELDED FROM THE INSIDE. THIS IS DONE TO OBTAIN DOWN HAND WELDING TO THE FULLEST EXTENT.

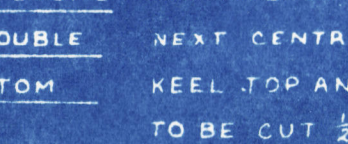
BUTTS OF INSIDE STRAKES WILL BE VEEED OUT FULL WIDTH.

THE BUTTS OF OUTSIDE STRAKES TO BE VEEED INSIDE AND WELDED BETWEEN THE LANDING EDGES OF INSIDE STRAKES ONLY.

THIS WELD WILL BE COMPLETED BY VEEING OUTSIDE ON THE SHIP AND WELDING BOTH SEAMS. THESE TO BE VEEED OUT IF WIDER THAN LANDINGS.

<u>TANK TOP</u>	ALL TANK TOP PLATING SEAMS AND FLOOR ANGLES TO BE HIVETED. ALL BUTTS TO BE WELDED FROM TOP SIDE. TANK TOP SEAMS TO BE WELDED FOR 3" EACH SIDE OF BUTT. SHAFT TUNNEL PLATING TO BE FILLET WELDED TO TANK TOP SIMILAR TO BHDS. NO FOUNDATION BARS TO BE FITTED. PLATING TO HAVE SAME PROCEDURE AS TANK TOP
MAIN AND	

W.T. FLOORS
IN DOUBLE
BOTTOM



PLUG
WELDS
ABOUT
1/2" APART

TOP AND BOTTOM ANGLES TO BE LINERED. ENDS OF BOTH BARS NEXT CENTRE KEEL TO BE CUT $\frac{1}{2}$ " SHORT OF IDE IN CENTRE KEEL. TOP AND BOTTOM FORE AND AFT ANGLES OTHER ENDS TO BE CUT $\frac{1}{2}$ " SHORT OF MARGIN PLATE. THESE BARS TO BE ELECTRIC WELDED TO FLOOR PLATE WITH HEELS PROJECTING $\frac{1}{8}$ " OVER EDGE OF FLOOR PLATE FOR THAT PURPOSE, NO COLLARS TO BE FITTED ON EITHER ENDS OF FLOOR PLATE. THE ENDS OF FLOOR PLATES ARE TO BE FITTED NEATLY TO BUTT AGAINST CENTRE KEEL AND TANK MARGIN FOR FILLET WELDING. PLUG WELDS ABOUT 1/2" APART TO BE MADE THROUGH FLOOR PLATE FLANGE OF TOP AND BOTTOM BARS. TOP AND BOTTOM FLOOR ANGLES TO BE RIVETTED TO TANK TOP AND SHELL RESPECTIVELY.

TANK MARGIN PLATE FLANGE ON TOP AND LAP RIVETED TO TANK TOP PLATING. BOTTOM EDGE TO BE BUTTED ON SHELL PLATE AND FILLET WELDED INSIDE AND OUTSIDE. THE ORDINARY FLOORS AS WELL AS W.T. FLOORS WILL BE WELDED TO THIS PLATE INSIDE AND BILGE BRACKETS WELDED ON OUTSIDE, NO ANGLE CONNECTIONS WILL BE FITTED ON EITHER SIDE OF TANK MARGIN PLATE. ALL BUTTS OF TANK MARGIN PLATES WELDED FROM OUTSIDE, WITH FINISHING BEAD INSIDE TO BE ALL RIVETED EXCEPT IN WAY OF TANK TOP AND TANK MARGIN NO FOUNDATION ANGLE TO BE FITTED TO TANK TOP OR MARGIN BHD. PLATING AND STIFFENER BRACKETS BUTTED HARD ON TANK TOP AND TANK MARGIN AND FILLET WELDED. BULKHEAD SHELL BARS TO BE CARRIED DOWN BILGE AND STOPPED 1/2" SHOW OF MARGIN PLATE.

BILGE BRKTS RIVETED TO FRAME AND BILGE ANGLE AND WELDED TO TANK MARGIN. GUSSET PLATE WELDED TO FLANGE OF BILGE BRACKET AND WELDED TO TANK TOP.

AND GUSSET

PLATE

STERN FRAME AS PER DETAIL PLAN
STEM BAR 10"x2 1/2" TO L.W.L.
PLATE STEM ABOVE L.W.L.
RUDDER AS PER DETAIL PLAN

2	-	BOWER ANCHORS	-68 CWTs.	
1	-	STUD CABLE CHAIN	-225 FATHOMS 2 3/4	
1	-	STREAM ANCHOR (STOCKLESS)	-23 3/4 CWTs.	
1	-	STREAM WIRE	90 FATHOMS 5" 6x12 F.S.W.	
1	-	TOWLINE	120 "	4 1/2" - 6x24 SPECIAL F.S.W.
2	-	HAWSEYERS	90 "	2 3/4" - 6x12 F.S.W.
2	-	WARPS	90 "	2 1/2" - 6x12 "

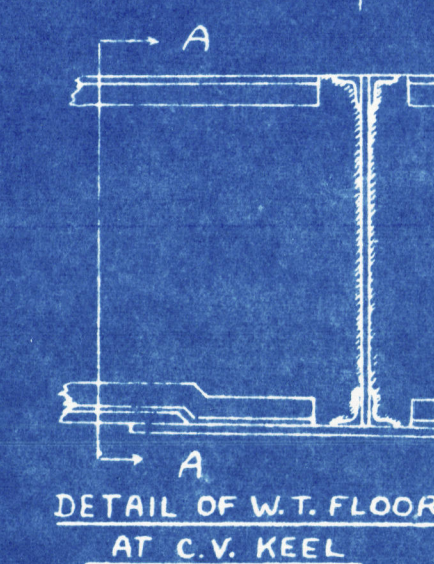
KEEL 52"x. $\frac{3}{4}$ " FOR $\frac{3}{5}$ L TO $\frac{11}{16}$ " AT ENDS
 $\frac{7}{8}$ " RIVETS IN SEAMS AND FRAMES

CEMENT CHOCKS TO BE FITTED AT UPPER
EDGE OF BILGE CEILING IN ALL HOLDS
EXCEPT NO 1

CLASS:- 100 A.I. LLOYDS, WITH FREEBOARD CORRESPONDING
TO A DRAFT 18" MORE THAN THAT OF A C.S.S. VESSEL

<u>EQUIPMENT</u>		<u>NUMERAL</u>
L (B + D)		3 9 1 8 9
MIDSHIP DECKHOUSE	30.25 x 7.5 x .50	1 1 3
CASINGS	20.5 x 7.5 x .50	7 7
"	59.75 x 10.5 x .50	3 1 4
AFTER DECKHOUSE	26 x 7.5 x .50	1 0 5
		<u>39,798</u>

: LETTER af



SECTION 10-10

WELDING FOR
FLOORS WITH
SINGLE TOP &
BOTT. BARS

WEST COAST
SHIPBUILDERS LTD.
MIDSHIP SECTION
HULL 112
S.S. FOOT FINLAY & SONS LTD.

S.S. **PORT FINLAY** **LOVUS**
VCR RPT. N° 5862

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