

REPORT ON BOILERS.

No. 18623

Received at London Office

27 FEB 1945

Date of writing Report 6/2/1945 When handed in at Local Office 6/2/1945 Port of WEST HARTLEPOOL

No. in Reg. Book. Survey held at WEST HARTLEPOOL Date, First Survey 24th May, 1944 Last Survey 24th January 1945

on the STEEL SCREW STEAMER "EMPIRE JAMAICA"

(Number of Visits 63) Tons {Gross 3537.78 Net 2257.96

Master Built at WEST HARTLEPOOL By whom built WM. GRAY & CO. LTD Yard No. 1174 When built 1945.

Engines made at WEST HARTLEPOOL By whom made CENTRAL MARINE ENGINE WORKS. Engine No. 1174 When made 1945.

Boilers made at WEST HARTLEPOOL By whom made CENTRAL MARINE ENGINE WORKS. Boiler No. 1174 When made 1945.

Nominal Horse Power 299. Owners MINISTRY OF WAR TRANSPORT. Port belonging to WEST HARTLEPOOL.

MULTITUBULAR BOILERS—MAIN, AUXILIARY, OR DONKEY.

Manufacturers of Steel Messrs. Colvilles, 2nd Glasgow. (Letter for Record S. ✓)

Total Heating Surface of Boilers 4546 sq ft ✓ Is forced draught fitted Yes. ✓ Coal or Oil fired Both ✓

No. and Description of Boilers 2 Single ended Multitubular ✓ Working Pressure 200 lbs. ✓

Tested by hydraulic pressure to 350 lbs. Date of test 6-11-44 No. of Certificate 4039. Can each boiler be worked separately Yes. ✓

Area of Firegrate in each Boiler 46.25 sq ft ✓ No. and Description of safety valves to each boiler 2 Lockburn's Stage Lift. ✓

Area of each set of valves per boiler {per Rule 6.05 sq ft ✓ as fitted 7.95 sq ft ✓ Pressure to which they are adjusted 200 lbs. ✓ Are they fitted with easing gear Yes. ✓

In case of donkey boilers, state whether steam from main boilers can enter the donkey boiler -

Smallest distance between boilers or uptakes and bunkers or woodwork 18" Is oil fuel carried in the double bottom under boilers Yes. ✓

Smallest distance between shell of boiler and tank top plating 3'-4 1/2" Is the bottom of the boiler insulated Yes. ✓

Largest internal dia. of boilers 14'-0" ✓ Length 11'-9" ✓ Shell plates: Material Steel ✓ Tensile strength 29-33 tons ✓

Thickness 1 1/4" ✓ Are the shell plates welded or flanged No. ✓ Description of riveting: circ. seams {end DR. LAP. ✓ inter. -

long. seams {Double Butt Straps Diameter of rivet holes in {circ. seams 1 5/16" ✓ {long. seams 1 5/16" ✓ Pitch of rivets {4" ✓ {9" ✓

Percentage of strength of circ. end seams {plate 67.2 ✓ {rivets 43.5 ✓ Percentage of strength of circ. intermediate seam {plate - ✓ {rivets - ✓

Percentage of strength of longitudinal joint {plate 85.42 ✓ {rivets 90.6 ✓ {combined 88.95 ✓ Working pressure of shell by Rules -

Thickness of butt straps {outer 1 5/16" ✓ {inner 1 1/4" ✓ No. and Description of Furnaces in each Boiler 3 Corrugated Weightless Section ✓

Material Steel ✓ Tensile strength 26-30 tons ✓ Smallest outside diameter 3'-5 3/16" ✓

Length of plain part {top - ✓ {bottom - ✓ Thickness of plates {crown 1 9/32" ✓ {bottom 1 3/32" ✓ Description of longitudinal joint Welded. ✓

Dimensions of stiffening rings on furnace or c.c. bottom - Working pressure of furnace by Rules -

End plates in steam space: Material Steel ✓ Tensile strength 26-30 tons ✓ Thickness 1 9/32" ✓ Pitch of stays 19 3/8" x 19 3/4" ✓

How are stays secured Double nuts ✓ Working pressure by Rules -

Tube plates: Material {front Steel ✓ {back Steel ✓ Tensile strength {26-30 tons ✓ {26-30 tons ✓ Thickness {2 9/32" ✓ {1 3/16" ✓

Mean pitch of stay tubes in nests 12 3/8" x 8 1/2" Pitch across wide water spaces 14" Working pressure {front - ✓ {back - ✓

Girders to combustion chamber tops: Material Steel ✓ Tensile strength 28-32 tons ✓ Depth and thickness of girder

at centre 7 3/4" x 13 1/4" 2 3/8" plates length as per Rule 2'-7 1/2" ✓ Distance apart 9" ✓ No. and pitch of stays

in each 2 @ 10" ✓ Working pressure by Rules - Combustion chamber plates: Material Steel ✓

Tensile strength 26-30 tons ✓ Thickness: Sides 2 3/32" ✓ Back 1 1/16" ✓ Top 2 3/32" ✓ Bottom 2 3/32" ✓

Pitch of stays to ditto: Sides 10 3/8" x 8 1/2" Back 9 3/8" x 8 3/4" Top 10" x 9" ✓ Are stays fitted with nuts or riveted over Nuts ✓

Working pressure by Rules - Front plate at bottom: Material Steel ✓ Tensile strength 26-30 tons ✓

Thickness 2 9/32" ✓ Lower back plate: Material Steel ✓ Tensile strength 26-30 tons ✓ Thickness 7/8" ✓

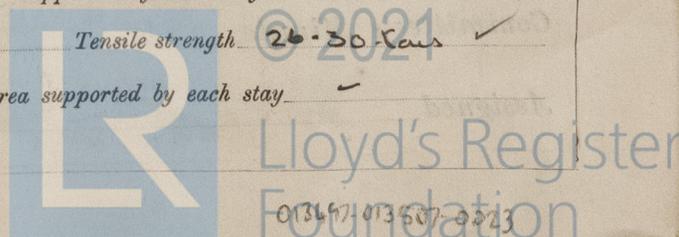
Pitch of stays at wide water space 14 3/8" x 9 3/8" ✓ Are stays fitted with nuts or riveted over Nuts ✓

Working Pressure - Main stays: Material Steel ✓ Tensile strength 28-32 tons ✓

Diameter {At body of stay, or Over threads 3 1/4" ✓ No. of threads per inch 6 ✓ Area supported by each stay -

Working pressure by Rules - Screw stays: Material Steel ✓ Tensile strength 26-30 tons ✓

Diameter {At turned off part, or Over threads 1 3/4" ✓ No. of threads per inch 9 ✓ Area supported by each stay -



Working pressure by Rules 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 Working pressure by Rules

Tubes: Material HRWS External diameter Plain 3" Stay 3" Thickness 8/16, 1/4, 5/16 No. of threads per inch 9

Pitch of tubes $H\frac{1}{4} \times H\frac{1}{8}$ Working pressure by Rules Manhole compensation: Size of opening in shell plate None Section of compensating ring No. of rivets and diameter of rivet holes

Outer row rivet pitch at ends Depth of flange if manhole flanged 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 Superheater 8" Manufacturers of Tubes Steel forgings Steel castings

Number of elements 43 per boiler Material of tubes SD Steel Internal diameter and thickness of tubes $17\frac{1}{2} \times 2\frac{1}{2}$

Material of headers Tensile strength Thickness 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 1.767 Are the safety valves fitted with easing gear Yes Working pressure as per Rules Pressure to which the safety valves are adjusted 210 lbs Hydraulic test pressure: tubes 1000 lbs forgings and castings 600 lbs and after assembly in place 600 lbs 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,
FOR THE CENTRAL MARINE ENGINE WORKS.
(S. G. & Co. Ltd.) Manufacturer.

Dates of Survey During progress of work in shops -- while building During erection on board vessel --

Are the approved plans of boiler and superheater forwarded herewith 16-9-43 (If not state date of approval.)

Total No. of visits

Is this Boiler a duplicate of a previous case Yes If so, state Vessel's name and Report No. SS EM. BERMUDA RPT No 18605.

GENERAL REMARKS (State quality of workmanship, opinions as to class, &c.) These boilers have been constructed under special survey and in accordance with the approved plans and specification for a working pressure of 200 lbs per square inch. The materials and workmanship have been found good. Upon completion the boilers were tested in the presence of the undersigned by a hydraulic pressure of 350 lbs per square inch, showed no signs of weakness and were found tight and sound in every respect at that pressure.

Survey Fee ... £ : : } When applied for, 19

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

Arthur W. Oxford,
Engineer Surveyor to Lloyd's Register of Shipping.

Committee's Minute FRI. 16 FEB 1945

Assigned Su F.E. machy. rpt.



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