

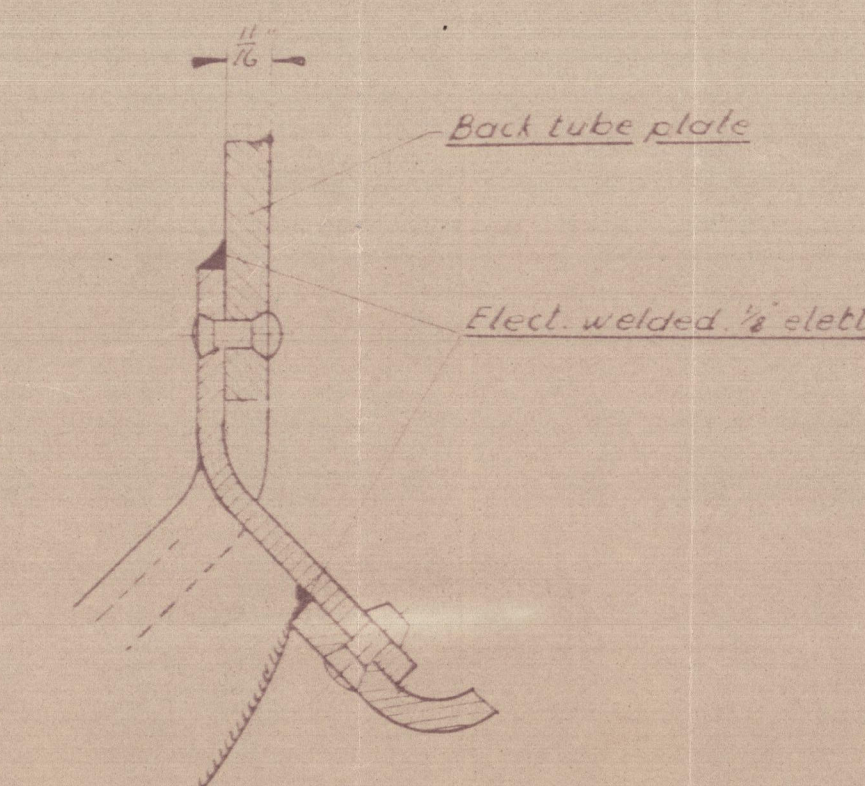


Particulars of riveting

	Longitudinal seam	Longitudinal seam in tube plate	Circumf. seams
Art of seams	Lapjoint	Lapjoint	Lapjoint
Diam. of rivet holes	$2\frac{3}{32}$ "	$2\frac{3}{32}$ "	$2\frac{3}{32}$ "
Pitch of rivets	2.4"	2.34"	$1\frac{13}{16}$ "
Number of rivets in pitch	2.	2.	1.
% of plate	70.06 %	69.3 %	60.34 %
% of rivets	63.45 %	56.94 %	42.0 %

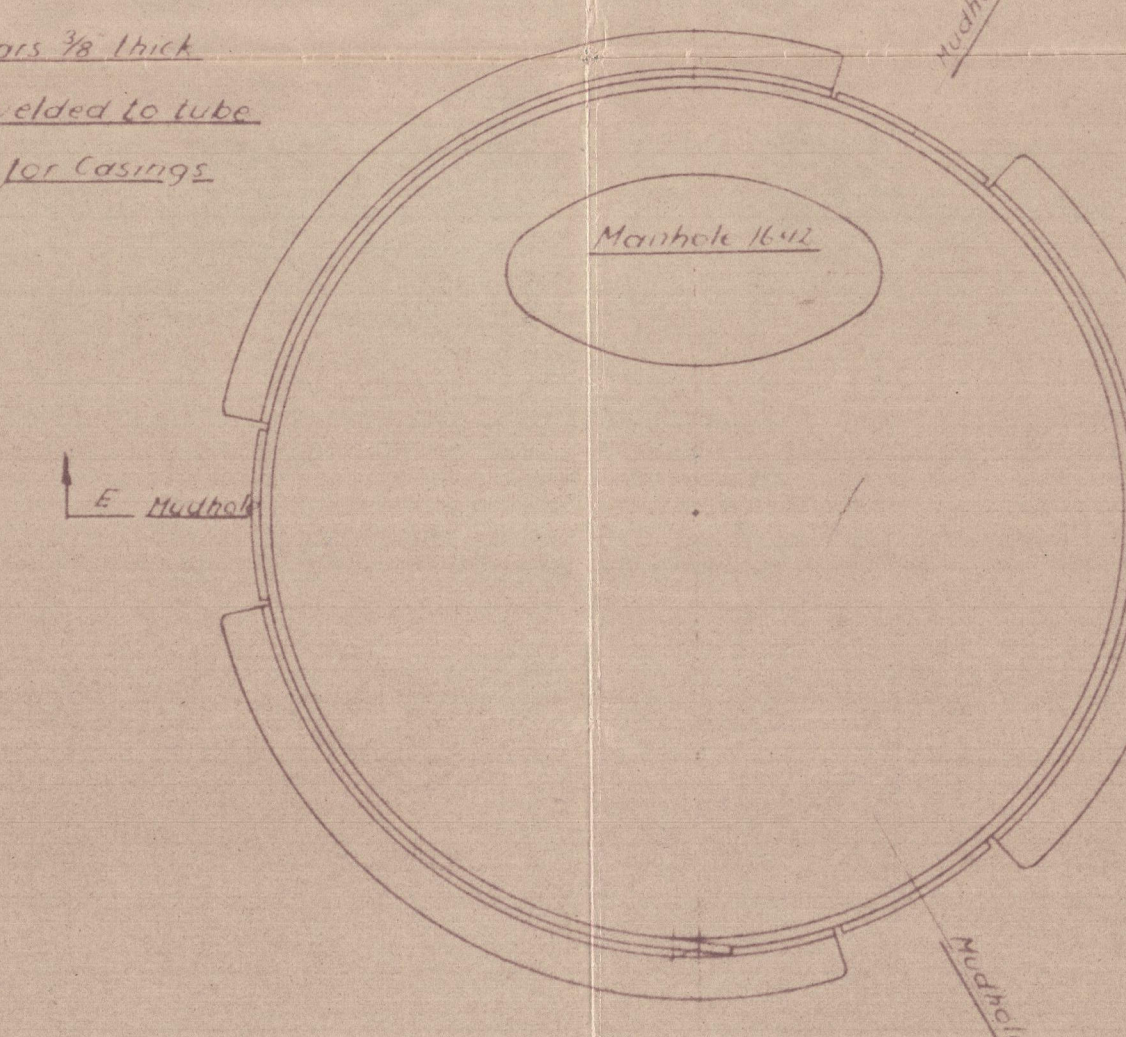
Holes drilled in place after bending, hydraulic riveting

	sq. feet	m ²
Heating surface (exhaust-fired) 121-1 $\frac{1}{2}$ " ex diam boiler tubes ~	147.0	13.63
Heating surface of fire-box ~	26.0	2.42
Heating surface of 72-1 $\frac{1}{2}$ " ex diam boiler tubes (oil-fired)	115.0	10.95
Total Oil-fired Heating surface ~	144.0	13.37
Total Heating surface	291.0	27.00

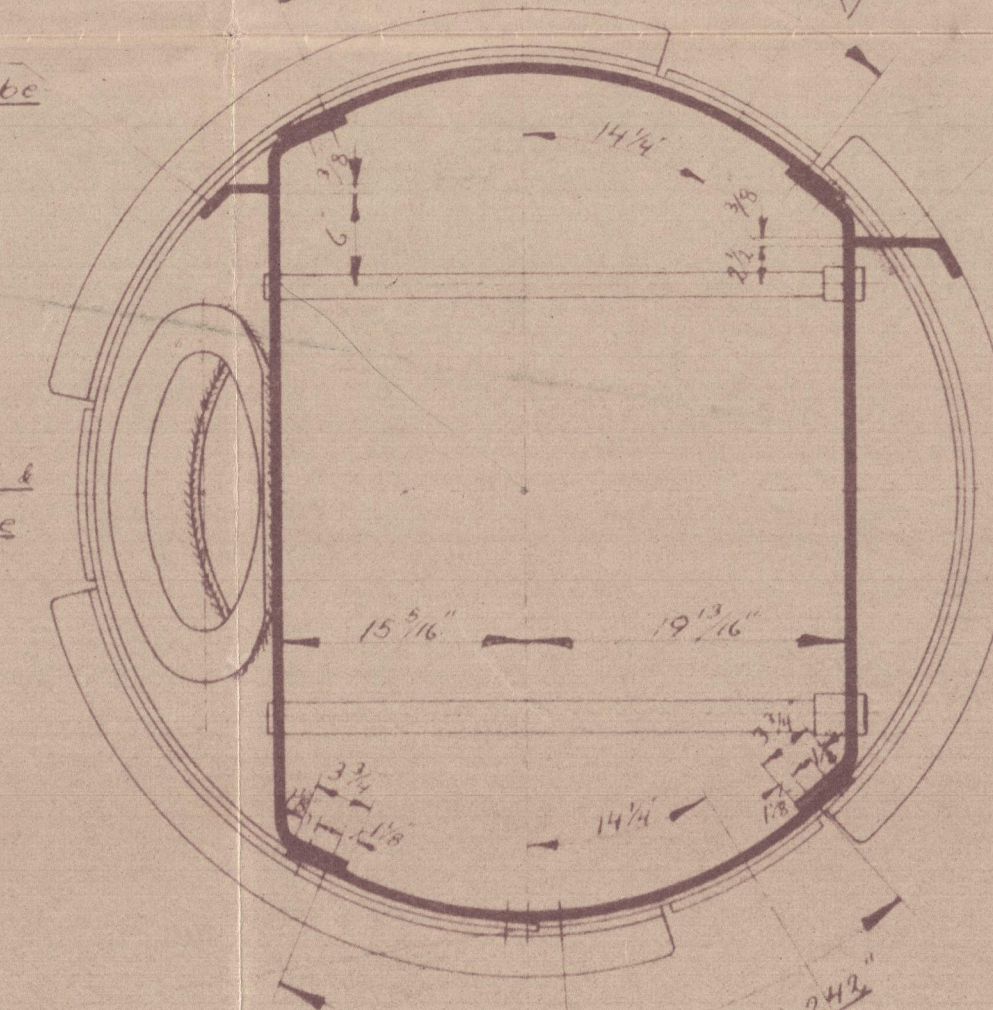


Detail of back tube plate and flue pipe flange

3 x 1/2" Angles secured to shell by 3/8" bolts about 9" pitch



Plan C-C



Section B-B

6-3/4" Bolts on 4" 2 3/8" p.c.d securing base-plate to angle

Flat bars 3/8" thick elect. welded to tube plates for casings

Welding of fire-box - (Bottom and top part)
Electric welding. Electrodes to be approved by British Lloyd's REGISTER.
Electrodes mark QK 47 of stabilend to be used

Shell vertical seam

Welding seams in fire-box

Section E-E

1 1/2" rivets 2 3/4" holes 13 pitches at 2.4"

Shell vertical seam

3 x 3/8" casing bars welded to tube plates. Tube plates annealed after welding

Caulking edges of flue pipe elect. welded where marked. Two runs of 1/8" electrode

2 1/4" rivets 2 3/4" holes 2 1/8" pitch 2 3/8" lap C 1/2" inside C chamber

1 1/2" pitch 1 1/2" rivets 2 3/4" holes

3/4" rivets 2 3/4" holes 2 1/8" pitch 2 3/8" lap C 1/2" inside flue pipe

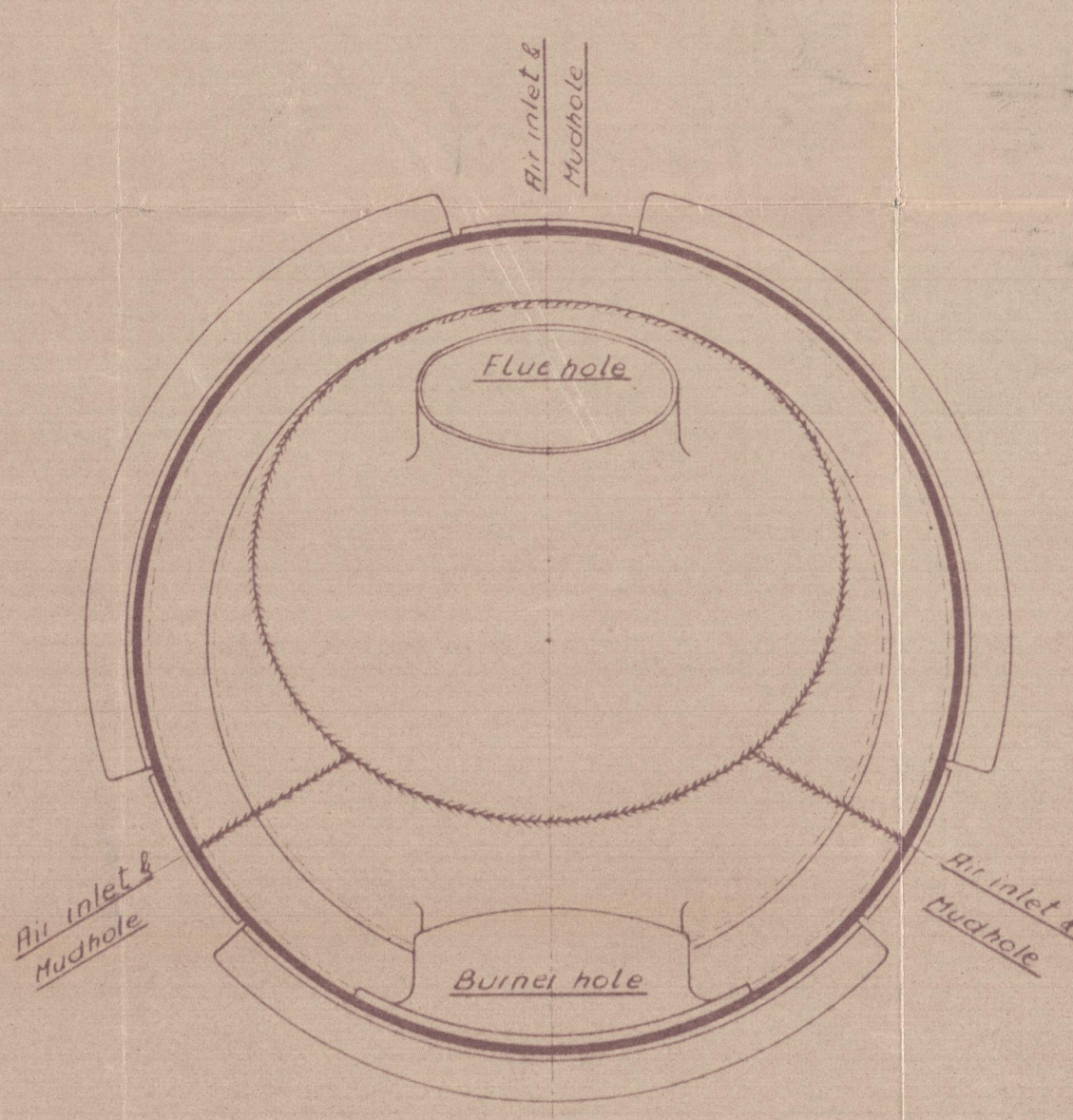
3/4" rivets 2 3/4" holes 2 1/8" lap C 1/2" both sides, 2 pitch

1 1/2" pitch 1 1/2" rivets 2 3/4" holes

1 1/2" rivets 2 3/4" holes 2 3/8" pitch

Mudhole 5-1/2" doubling 3-1/8" 1/2" rivets 2 3/4" holes abt. 1 1/8" pitch

Section D-D



Section D-D

Comb. exhaustgas-and oilfired boiler

Working pressure = 100 ^{lb}/in². Tested to 200 ^{lb}/in²

British Lloyd's Rules.

Scale 1" = 1'-0"

English measures

Lowest tensile strength for shell plates	28 tons/in ² = 44 kg/mm ² (plates from stock have 43.5 kg/mm ²)
" " " " flanged plates	26 " = 41 " (" " " " 41.6 ")
" " " " rivets	26 " = 41 "

W278-0136

Lidjeres for Mask Nr	konto	Antal Gange	Kedel bygge Nr	Skibs bygge Nr	Skibsnavn	Tegning i værksted
374.	V.	1.	982.	266.		



Transparent of Tracing Nr. 21166.
Kopi med ændring fra Cochran & Co. Tegning Nr. E. 39111.

BELSINGORS JERNSKIDS OG MASKINBYGGERI	
Lign. Nr.	21513A
Datum	22-10-40
Klasse	351

bohringham

Donkey boiler
for
Yard No 266.
by.
M/s. Helsingør's Jernskits og Maskinfabrik
Copenhagen.



M/s. "Eros" af Helsingborg.
Opn. Aft. No. 113. 48

London



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Lloyd's Register
Foundation

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