

WELDING TABLE:

SHIP SECTIONS	SHEET NO.
GENERAL INFORMATION	1, 2 & 3
DOUBLE BOTTOM BETWEEN FRAMES #6 AND # 47	4
SIDE STRUCTURE ABOVE DECK 1 (T.T.)	4
WATERTIGHT BULKHEADS	5
DECK 2	5
FUEL OIL TANKS	5
FORE AND AFT SHIP	5
BULKHEADS AND GUTTER ABOVE DECK 2	6
DECKS ABOVE DECK 2	6
WET AREA ABOVE DECK 2	6
DRY AREA ABOVE DECK 2	6
DETAILS STAGGERED WELD	7
DETAILS ALUMINIUM SECTIONS ABOVE DECK 3	8

CORRESPONDING DRAWINGS:

- 62-208-101 TRANSVERSE FRAMES AND BULKHEADS SHEET 1 - 10
- 62-208-102 PROFILE AND PLAN. SHEET 1 - 2
- 62-208-106 FRAMING PLAN
- 62-208-107 SHELL EXPANSION

BUREAU VERITAS Section ...25182Y....

REVIEWED

only for parts concerning Classification.
All particulars not shown on this drawing and concerning
Classification to be as per Rules.

Turku, 11-Sep-2013

[Electronic document]
The plan approval office

REFERENCE DRAWINGS:

- 62-101-001 GENERAL ARRANGEMENT
- 62-152-101 TANKPLAN
- 62-200-101 REFERENCE DRAWING

B	Corrected acc. to comments from BV	05.09.13	HJB
A	Issued for approval / comments	13.06.13	HJB
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CLIENT WESTERN BALTIJA SHIPBUILDING		CLIENT REFERENCE	
TITLE WELDING TABLE		SCALE 1:50	DRAWN HJB 13.06.13
Sheet 1 of 8		CK'D	
APPR.		APPR.	
PROJECT NO. 297/2		YARD NO. 62	SFI 200
FILE NAME / DRAWING NO. 62-200-102		REV.NO. B	

OWNER	YARD	CLASSIFICATION	MARITIME AUTH.
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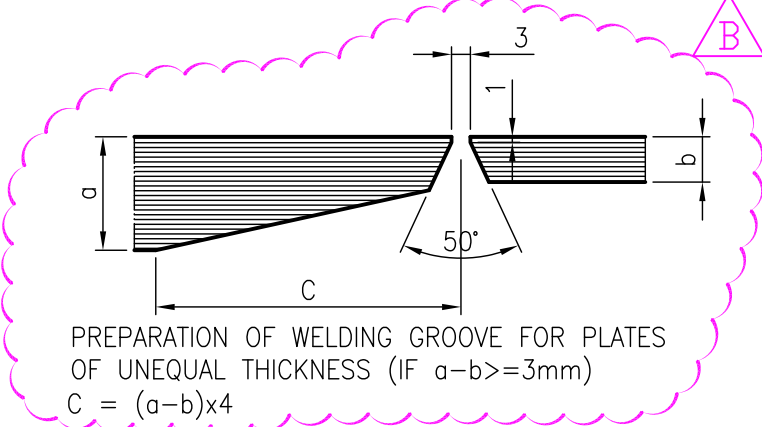
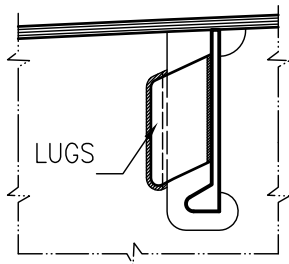
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AS SHOWN ON UNIT DRAWINGS CUT OUTS IN FRAMES & WEBS ARE TO BE SUPPLIED WITH LUGS WHERE IS NECESSARY

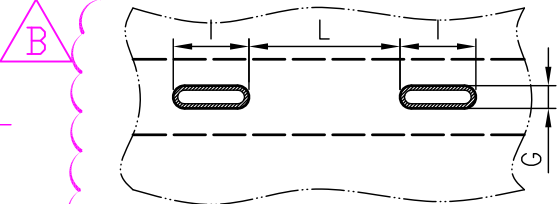


PREPARATION OF WELDING GROOVE FOR PLATES OF UNEQUAL THICKNESS (IF $a-b \geq 3\text{mm}$)
 $C = (a-b) \times 4$

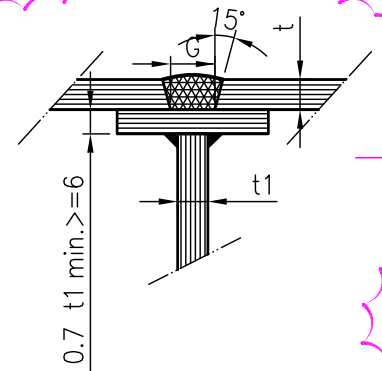
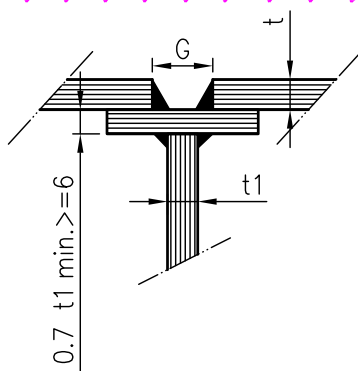
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TYPICAL WELDING DETAIL

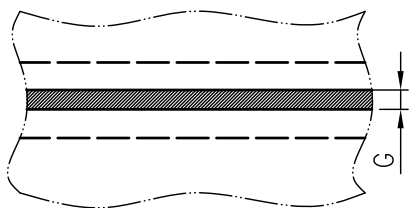
SLOT WELDING MAY BE USED FOR CONNECTION OF PLATING TO INTERNAL WEBS, WHERE ACCESS FOR WELDING IS NOT PRACTICABLE. SLOT WELDS ARE NOT TO BE USED IN CASE OF PRESSURE FROM ABUTTING PLATE SIDE OR IN TANK BOUNDARIES.



SLOT WELD DETAIL



FILLED UP SLOT WELD



CONTINUOUS SLOT WELD DETAIL

- $t \leq 12 \text{ mm}$
 $G = 20 \text{ mm}$
 $l = 80 \text{ mm}$
 $2l \leq L \leq 3l, \text{ max } 250 \text{ mm}$

- $t > 12 \text{ mm}$
 $G = 2t$
 $l = 100 \text{ mm}$
 $2l \leq L \leq 3l, \text{ max } 250 \text{ mm}$

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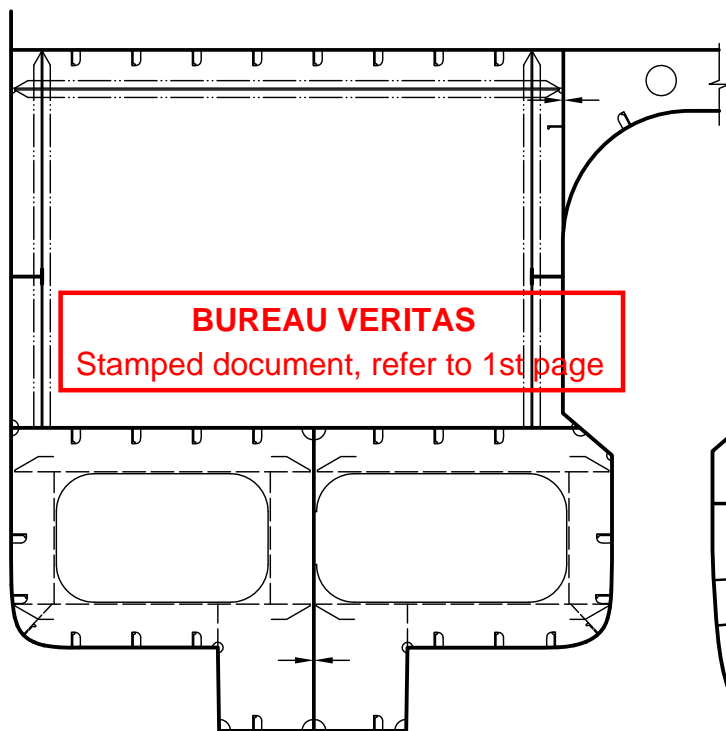
TITLE **WELDING TABLE** SCALE **1:50**
Sheet 3 of 8 DRAWN HJB 13.06.13
 CK'D
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	MULTI MARITIME AS P.O.Box 90, N-6801 FØRDE	PROJECT NO. 297/2	YARD NO. 62	SFI 200
	Phone 47 57823000 Telefax 47 57828451 E-mail: firmapost@multi-maritime.no	FILE NAME / DRAWING NO. 62-200-102	REV.NO. B	

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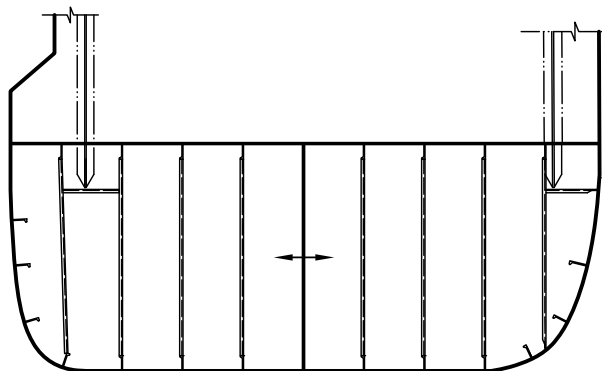
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DOUBLE BOTTOM BETWEEN FRAMES #6 AND # 47	DOB. CONT. MIN. a HEIGHT	INTERMITTED MIN. a HEIGHT & PARTITION
CENTRE GIRDER TO SHELL & TANK TOP IN GENERAL t=7mm	3.0	
CENTRE GIRDER TO SHELL & TANK TOP W.B. t=7mm	3.5	
FLOORS TO SHELL AND T.TOP (t=7)	2.8	
WATERTIGHT FLOORS TO SHELL AND T.TOP (t=7,8mm)	3.0, 3.5	
GIRDERS TO SHELL, FLOORS AND T.TOP (t=8mm)	2.8	
LONGITUDINALS TO TANK TOP (t=6, 7)	2.5, 2.8	
LONGITUDINALS TO SHELL (t=6, 7)	2.5, 2.8	
TRANSVERSE STIFFENERS TO FLOORS (t=6, 7)	2.5, 2.8	
STIFF./BRACKETS TO FLOORS AND GIRDER (t=8mm)	2.8	
SEA CHEST BOUNDARIES	FULL PENETRATION	



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NOTE:
Theoretical values are specified in the table.
Minimum throat thickness of plating with t=6,0 mm or more is (a) = 3,5 mm.
In case of automatic or semi automatic deep penetration weld, a = 3,0 mm



SIDE STRUCTURE BETWEEN FRAMES ±31	DOB. CONT. MIN. a HEIGHT	INTERMITTED MIN. a HEIGHT & PARTITION
WEBFRAMES TO SHELL AND FLANGE (t=7, 9mm)	2.8	
FRAMES TO SHELL (t=6, 7, 9mm)	2.5, 2.8	
LONG. ICE-STRINGER TO SHELL AND FLANGE (t=7, 9mm)	2.8	
LONGITUDINALS TO SHELL (t=6mm)	2.5	
BRACKETS (t=7, 8mm)	3.0	

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TITLE WELDING TABLE		SCALE 1:50	DRAWN HJB 13.06.13
Sheet 4 of 8		CK'D	
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WATERTIGHT BULKHEADS	DOB. CONT. MIN. α HEIGHT	INTERMITTED MIN. α HEIGHT & PARTITION
BOUNDARIES TO SHELL, DECK AND TANK TOP (t=7, 8, 9)	2,8	
BULKHEAD STIFFENERS (t=6, 7mm)	2.5/2.8	


DECK 2	DOB. CONT. MIN. α HEIGHT	INTERMITTED MIN. α HEIGHT & PARTITION
DECK 2 TO SHELL (t=7, 9mm)	2.8	
WEBFRAMES TO SHELL (t=7mm)	2.8	
GIRDERS TO MAINDECK AND FLANGE (t=6, 7mm)	2.5, 2.8	
LONGITUDINALS TO MAIN DECK (t=6mm)	2.5	
PILLARS TO GIRDERS/WEB FRAMES, DOUBLING PLATE	FULL PENETRATION	

FUEL OIL TANKS	DOB. CONT. MIN. α HEIGHT	INTERMITTED MIN. α HEIGHT & PARTITION
OIL TIGHT CONNECTIONS (t=6, 7mm)	2.5, 2.8	
INTERNAL STIFFENERS, GIRDERS & BULKHEADS (t=6mm)	2.5	
EXTERNAL STIFFENERS, GIRDERS (t=8,10mm)	2.8/3.0	

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FORE AND AFT SHIP	DOB. CONT. MIN. α HEIGHT	INTERMITTED MIN. α HEIGHT & PARTITION
FLOORS PL. 9 TO SHELL, GIRDER & TANK TOP	3.3	
CENTER GIRDER PL. 25 TO SHELL, GIRDER & FLOORS	9.4	
FORE HOOKS TO SHELL AND FLANGE (t=9mm)	3.3	
LONG. GIRDER PL.10 TO SHELL	3.5	
ENGINE GIRDER PL.10 TO THRUSTER MOTOR FLANGE	FULL PENETRATION	
THRUSTERS TRUNKS TO SHELL AND TOP FLANGE	FULL PENETRATION	
GIRDERS TO THRUSTER TRUNK	FULL PENETRATION	
GIRDERS PL.7 IN THRUSTER AREA TO SHELL, END CONNECTIONS&FLANGE	2.8	
ICE STRINGER PL.9 TO SHELL	3.5	
DECK 2 TO SHELL (t=6mm)	2.5	
LONGITUDINALS TO MAIN DECK (t=6mm)	2.5	
GIRDERS TO MAINDECK AND FLANGE (t=7mm)	2.8	
ALL OTHER WELDING IN THE AREA - t<10	3.0	

NOTE: Theoretical values are specified in the table.
 Minimum throat thickness of plating with t=6,0 mm or more is (α) = 3,5 mm.
 In case of automatic or semi automatic deep penetration weld, α = 3,0 mm

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TITLE	WELDING TABLE Sheet 5 of 8		DRAWN HJB 13.06.13 CK'D APPR.
	MULTI MARITIME AS P.O.Box 90, N-6801 FØRDE Phone 47 57823000 Telefax 47 57828451 E-mail: firmapost@multi-maritime.no	PROJECT NO. 297/2	YARD NO. 62 SFI 200
		FILE NAME / DRAWING NO. 62-200-102	REV.NO. B

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A

A

BULKHEADS AND GUTTER ABOVE DECK 2	DOB. CONT. MIN. a HEIGHT	INTERMITTED MIN. a HEIGHT & PARTITION
WATERTIGHT BULKHEADS TO SHELL, DECK (t=6mm)	2.5	
WEBFRAMES TO SHELL, DECK AND FLANGE (t=7mm)	2.8	
LONGITUDINALS TO BULKHEAD, SHELL (t=6mm)	2,5	
GUTERBAR PL.8/10 TO MAIN DECK	3.0	

B

B

DECKS ABOVE DECK 2	DOB. CONT. MIN. a HEIGHT	INTERMITTED MIN. a HEIGHT & PARTITION
DECK 3 TO SHELL (t=6mm)	2.5	
GIRDER WEB TO DECK & FLANGE (t=6mm)	2.5	
LONGITUDINALS TO DECK 3 (t=6mm)	2.5	
BRACKETS & END CONNECTIONS AT GIRDERS	2.8	
BULWARK SUPPORTS TO SHELL (t=7,8mm)	3.0/3.5	

C

C

WET AREA ABOVE DECK 2	DOB. CONT. MIN. a HEIGHT	INTERMITTED MIN. a HEIGHT & PARTITION
LONGITUDINAL ABOVE DECK 2 (t=6mm)	2.5	
WATER TIGHT CONNECTIONS T=6	2,5	
STIFFENERS AT BULKHEADS (t=6mm)	2.5	
LONGITUDINALS TO DECK/BULKHEAD (t=6-8mm)	2.5/3.0	

NOTE:

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 Minimum throat thickness of plating with t=6,0 mm or more is (a) = 3,5 mm.
 In case of automatic or semi automatic deep penetration weld, a = 3,0 mm

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E

E


F

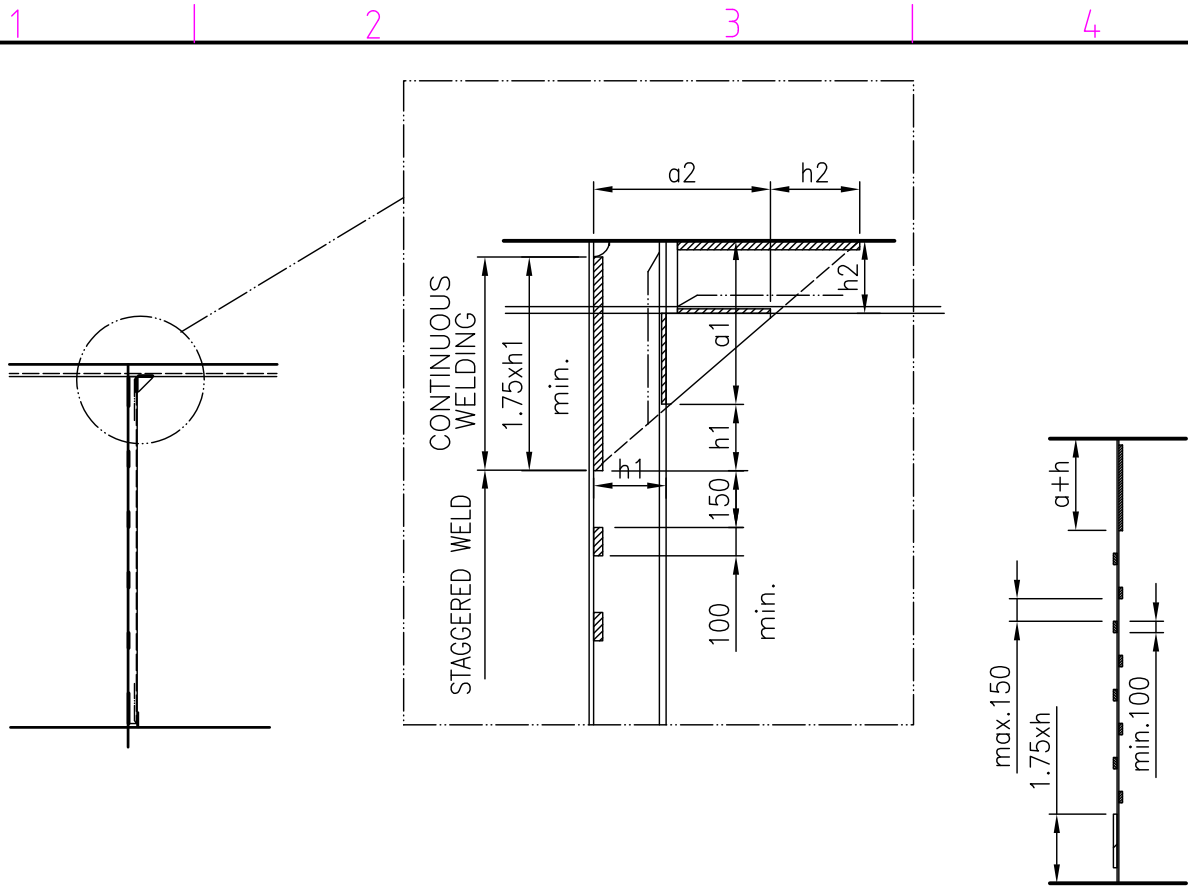
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CLIENT	WESTERN BALTIJA SHIPBUILDING		CLIENT REFERENCE
TITLE	WELDING TABLE Sheet 6 of 8		DRAWN HJB 13.06.13
	SCALE	CK'D	
	1:50	APPR.	
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	297/2	62	200
	FILE NAME / DRAWING NO.	REV.NO.	
	62-200-102	B	



**TYPICAL DETAIL:
STAGGERED WELD 100/250**

NOTE! "AT INTERMITTENT WELDING, MEMBERS AS FRAMES AND GIRDERS ETC. ARE IN GENERAL TO BE FULLY WELDED THE DISTANCE TO THE BRACKET TOE + A DISTANCE EQUIVALENT TO THE HEIGHT OF MEMBER."

*** IN GENERAL DOUBLE CONTINUOUS WELDING IS TO BE ADOPTED THROUGHOUT THE CONSTRUCTION. INTERMITTENT WELDING WILL ONLY BE ALLOWED ABOVE MAIN DECK IN DRY COMPARTMENTS. DEFINITION OF DRY COMPARTMENTS:**

ABOVE DECK 2: ACCOMMODATION AREA EXCEPT GEO LAB, BIO LAB AND GALLEY

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TITLE **WELDING TABLE** SCALE **1:50** DRAWN HJB 13.06.13
Sheet 7 of 8 CK'D
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ISO-A/

1 | 2 | 3 | 4

A | A

B | B

C | C

D | D

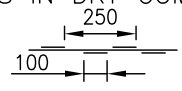
E | E

F | F



DETAILS ALUMINIUM SECTIONS ABOVE DECK 3	DOB. CONT. MIN. α HEIGHT	INTERMITTED MIN. α HEIGHT & PARTITION
WATERTIGHT BULKHEADS (t=6mm)	4,0	
GIRDER WEB TO DECK ,SIDE& FLANGE (t=8mm)	4,0	
DECK TO BHD./SIDE (t=6mm)	4,0	
LONGITUDINALS TO TOP OF WHEELHOUSE (t=6mm)		STAGGERED 2,5x100/250*
GIRDERS TO TOP OF WHEELHOUSE (t=6mm)	4,0	
BRACKETS & END CONNECTIONS AT GIRDERS	4,0	

* MIN. 300 MM CONTINUOUS WELD ON BOTH SIDES FROM ENDS.
STIFFENERS IN DRY COMPARTMENS , STAGGERED WELDING:



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TITLE	WELDING TABLE Sheet 8 of 8		SCALE 1:50
		PROJECT NO. 297/2	YARD NO. 62
		FILE NAME / DRAWING NO. 62-200-102	SFI 200
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