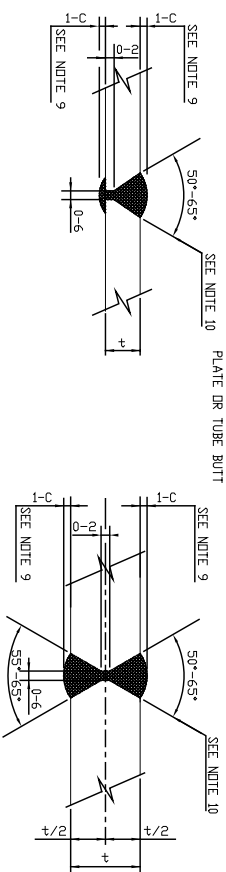


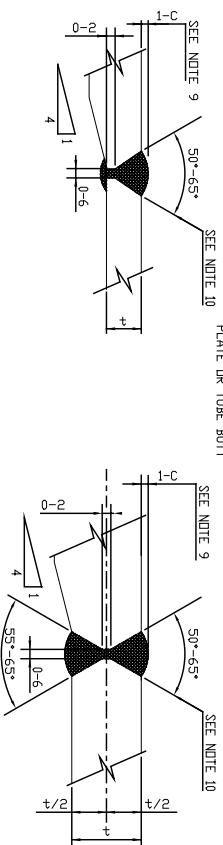
① DETAIL
SCALE : /

EQUAL THICKNESS BUTT



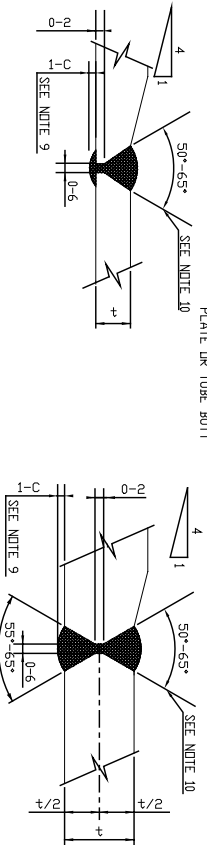
② DETAIL
SCALE : /

UNEQUAL THICKNESS BUTT-
MATCHING FRONT SURFACE



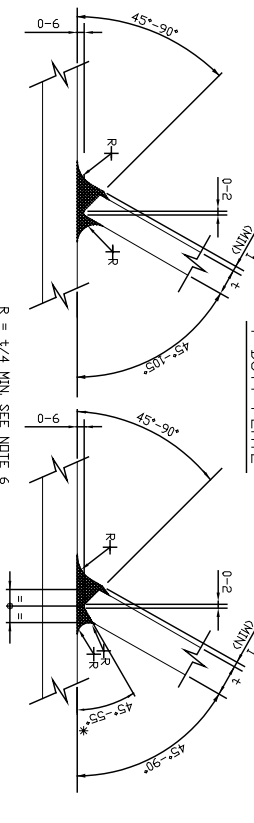
③ DETAIL
SCALE : /

UNEQUAL THICKNESS BUTT-
MATCHING REAR SURFACE



④ DETAIL
SCALE : /

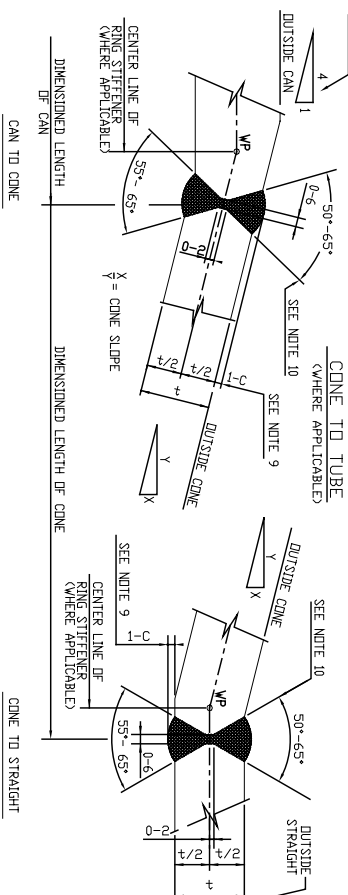
T BUTT-PLATE



R = t/4 MIN. SEE NOTE 6

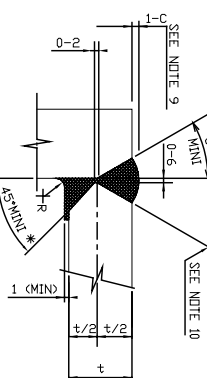
⑤ DETAIL
SCALE : /

CONE TO TUBE
(WHERE APPLICABLE)



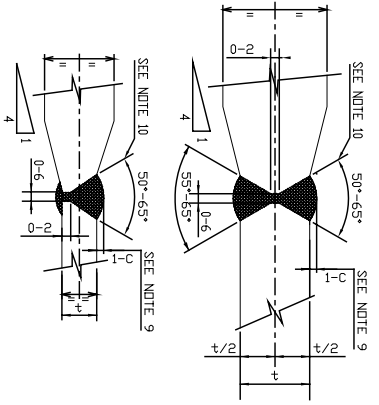
⑥ DETAIL
SCALE : /

CORNER



⑦ DETAIL
SCALE : /

UNEQUAL THICKNESS BUTT-
MATCHING CENTER LINE



GENERAL NOTES:

- 1- ALL GROOVE WELDS SHALL BE WELDED FROM BOTH SIDES UNLESS AGREED IN WRITING BY COMPANY TO BE IMPRACTICAL OR UNLESS SHOWN AS WELDED FROM ONE SIDE ONLY ON THE DESIGN DRAWINGS.
- 2- UNLESS NOTED OTHERWISE, ALL STEEL SHALL BE JOINED BY COMPLETE PENETRATION GROOVE WELDS.
- 3- WELD DETAILS DESCRIBED ON THESE WELDING DETAIL DRAWINGS ARE APPLICABLE UNLESS EXPLICITLY NOTED OTHERWISE ON THE DESIGN DRAWINGS.
- 4- DETAILS SHOWN ARE APPROPRIATE FOR SAW OR SAW, PROCESSES ONLY. IF OTHER WELDING PROCESSES ARE ALLOWED BY COMPANY DIMENSIONS, ANGLES AND TOLERANCES MAY BE REVISED SUBJECT TO AGREEMENT BY THE COMPANY.
- 5- DIMENSIONS AND ANGLES OF WELDING PREPARATIONS MAY BE SUBJECT TO VARIATION DEPENDING ON WELDING PROCEDURES AGREED WITH THE COMPANY.
- 6- ALL WELD PROFILES SHALL CONFORM TO THE REQUIREMENTS OF THE APPROPRIATE FABRICATION SPECIFICATION.
- 7- WELD PROFILE PAINT INDICATE THE REQUIRED AVERAGE AS WELDED SHAPE ONLY AND DO NOT CALL FOR SURFACE GRINDING UNLESS SPECIFIED ELSEWHERE.
- 8- BALANCED WELD PREPARATIONS ARE RECOMMENDED FOR T > 20 mm.
- 9- THE MAXIMUM BUTT WELD REINFORCEMENT 'C' SHALL NOT EXCEED THE FOLLOWING

PLATE THICKNESS t (mm)	C (mm)
6 < t < 25	3
25 < t < 50	4
50 < t	5

10- ALL BEVELS SHALL BE INDIVIDUALLY 20°, 30°, 45° WITH REGARD TO THE UT INSPECTION SURFACE.

TYPICAL WELDING DETAILS

PLATE

DOUBLE SIDED WELDS