

COPY.

GLASGOW REPORT No. 62040.

# Lloyd's Register of Shipping.

Port

GLASGOW.

26th February, 1940.

This is to Certify that

G. ANDERSON.

the undersigned Surveyor to this Society did at the request of Messrs. Babcock & Wilcox, Ltd., visit their Renfrew Works on 9th August 1939 and subsequently, for the purpose of examining during construction Three Fusion Welded Steel Boiler Drums manufactured by them under Contract No. 1362 and intended for Messrs. Swan Hunter & Wigham Richardson Yard No. 1640.

The drum shell plates are 1½" thick rolled or bent to give an external diameter of 3'-9½", the heads or ends being made from 17/16" thick plates. The design, welding, and testing are in accordance with the Society's Requirements for a working pressure of 450 lbs. per square inch.

Before bending, test plates were cut from shell plates and attached at each end of the longitudinal seam in such a manner that the edges welded are a continuation and duplication of the corresponding edges of the longitudinal joint.

On completion of the welding the whole of the seams were examined by X-Ray, Film Series BD9, BE3 and BE5 and on the results being considered satisfactory the drums were stress-relieved at a temperature of 650°C. Following this they were examined under hydraulic pressure to 725 lbs. per square inch at which pressure they/

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they were well hammered on both sides of, and close to the welded seams. On subsequent examination the drums with their welded seams and nozzles were found, so far as could be seen, to be sound and free from defect. On release of the pressure, no permanent set was noted.

For purposes of identification they have been stamped:-

Drum A.

No. 39808  
Lloyd's Test  
725 lbs.  
S.V.L. 450 lbs.  
G.A. 12.12.39.

Drum B.

No. 39845  
Lloyd's Test  
725 lbs.  
S.V.L. 450 lbs.  
G.A. 22.12.39.

Drum C.

No. 39846  
Lloyd's Test  
725 lbs.  
S.V.L. 450 lbs.  
G.A. 22.12.39.

For results of mechanical tests see separate sheet.

*G. H. Jones*

Surveyor to Lloyd's Register.



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