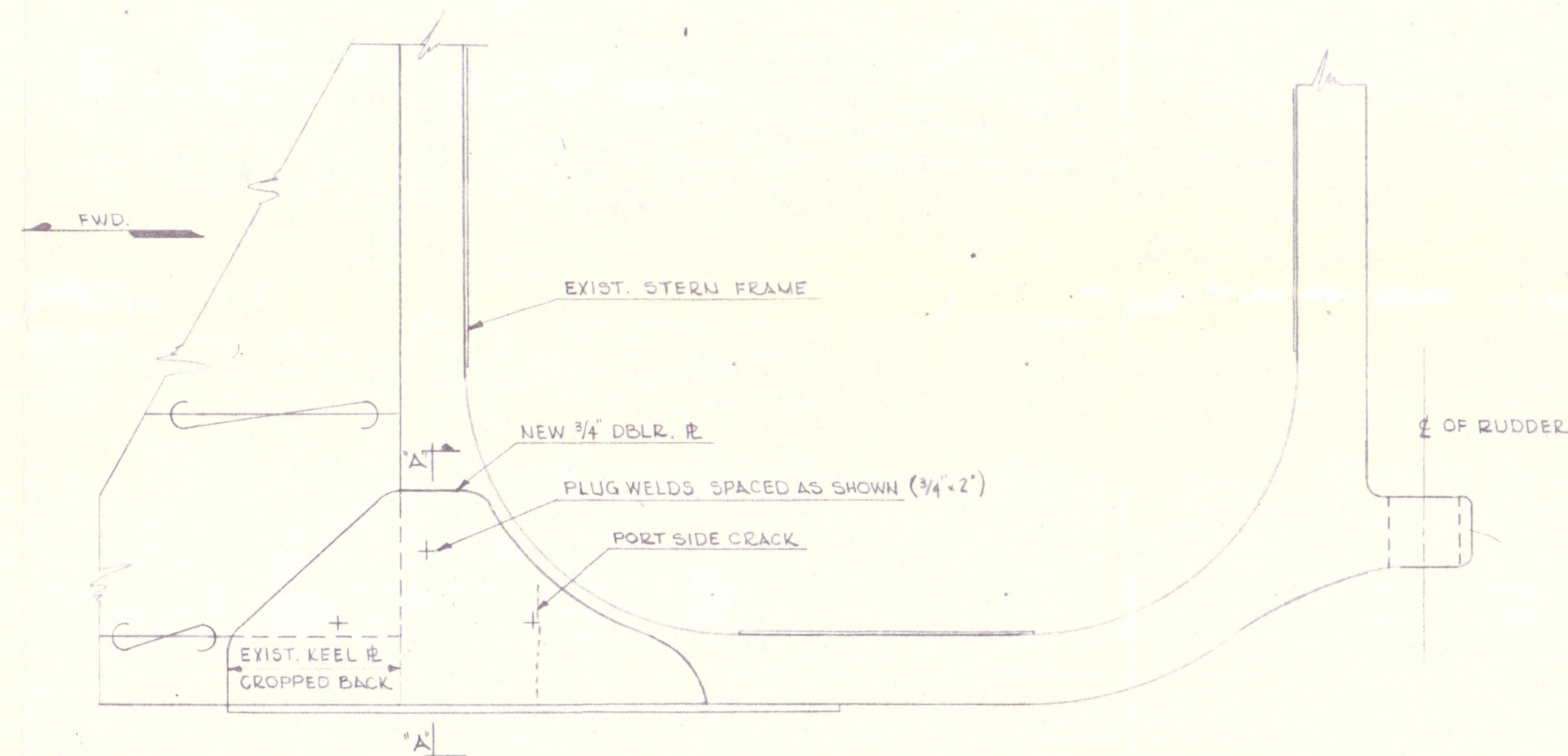
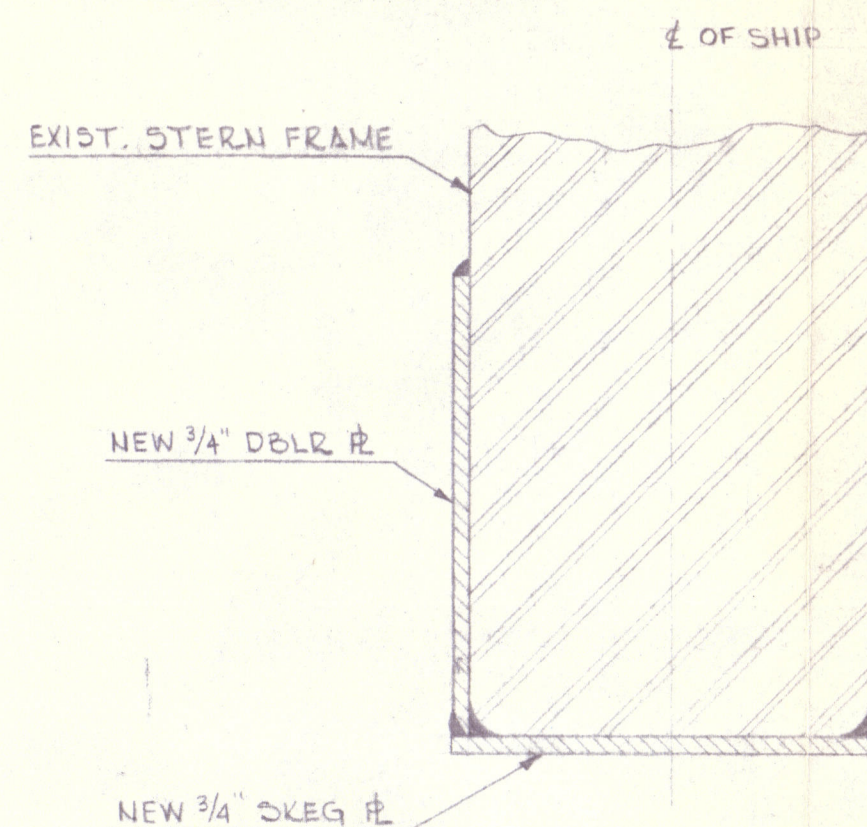


ELEVATION OF STERN FRAME
STAR SIDE LOOKING TO PORT



ELEVATION OF STERN FRAME
PORT SIDE LOOKING TO STAR



SECTION "A-A"

ALTERATIONS				
Authorization	ALT. No.	DATE	DESCRIPTION	APP'D.

CRACK REPAIRING PROCEDURE:

- 1-V-OUT STAR. CRACKS - 1/4" DEEP
- 2-V-OUT PORT CRACK
- 3-MAGNAFLUX CASTING P/S SIDES
- 4-HEAT CASTING TO 400°F. P/S SIDES
- 5-WELD UP CRACKS P/S SIDES
- 6-HEAT CASTING TO 1000°F & WRAP WITH ASBESTOS TO ASSURE PROPER STRESS RELIEVING
- 7-MAGNAFLUX CASTING P/S SIDES

WELDING SEQUENCE:

- 1-PLUG WELD SKEG R. TO CASTING
- 2-WELD UP GAP BETWEEN SKEG R. & CASTING WORKING FORWARD TO AFT P/S SIDES SIMULTANEOUSLY
- 3-ERECT P/S DBLR R. & TACK WELD TO STERN FRAME & SHELL R.
- 4-PLUG WELD DBLR R. TO SHELL R. & CASTING
- 5-WELD FWD END OF DBLR R. P/S SIMULTANEOUSLY WORKING FROM BOTTOM TO TOP
- 6-WELD LOWER EDGE OF DBLR R. P/S SIMULTANEOUSLY WORKING FROM FWD END AFT
- 7-WELD TOP EDGE OF DBLR R. P/S SIMULTANEOUSLY WORKING FROM FWD END AFT
- 8-WELD AFT END OF DBLR R. P/S SIMULTANEOUSLY WORKING FROM TOP DOWN

GENERAL NOTE:

THIS DWG. SHOWS THE REINFORCING AS CONSTRUCTED ON SHIP.

Baltimore Report No. 9986

Noted



DEPT.	DATE ISSUED
YARD SUPT.	7/23/53
ESTIMATING	7/23/53
PIPE	
ELECTRIC	
SHEET METAL	
OUTSIDE MACH.	
MOLD LOFT	
HULL	
ORDER	
OFFICE	
SHIP SUPR.	
RIGGER	
FORGE	
WELDING	
CARPENTER	
JOINER	
PATTERN	
MACHINE	
PAINT	
U.S.C.G.	
CLASS. MGRS.	
OWNER	

3/5 MARCELLA

APPROVED
APPROVED
APPROVED
APPROVED

CONTRACT JQ-1673

BETHLEHEM STEEL COMPANY
SHIPBUILDING DIVISION
BALTIMORE YARD BALTIMORE, MD.

STERN FRAME REINFORCING

Drawn By Gene Smith Chief Draftsman gms
Traced By H. A. L. Chief Engineer
Checked By H. A. L. Inspector
Scale 1" = 1/2" = 1'-0" Date 7-20-53

DRAWING No. B-3749 ALT. 0