



ALTERATIONS					
NO.	DESCRIPTION	DATE	MADE BY	OWNERS	APPROVED BY
I	ADDITIONAL BKT. & FLAT BAR ADDED FOR HULLS 4353-4355	NOV 10-1940	K.F.	NOV 29/40	NOV 29/40
II	REINFORCEMENT COLLAR AS SHOWN IN WAY OF CORN. ST. TEARS AND LONG. BND. 4353	1-20-41	CL.B.	NOV 15/41	MAY 7/41
	SETS OF COLLAR RS. AND BRACKET				

GENERAL NOTES:-

1. ALL SURFACES TO BE WELDED MUST HAVE ALL SCALE, RUST & GREASE REMOVED PRIOR TO WELDING.
2. MEMBERS TO BE WELDED ARE TO BE THUSLY FITTED METAL TO METAL BEFORE WELDING.
3. THE PAVING SURFACES OF WELDED LAP JOINTS ARE NOT TO BE PAINTED.
4. WHERE WELDING IS CLOSE TO RIVETING, THE WELDING IS TO BE DONE BEFORE RIVETS ARE DRIVEN.
5. WELLS ON MATERIAL 1/2" THICK OR LESS MAY BE MADE IN ONE LAYER PROVIDED BUCKLING & LOCKED STRESSES ARE AVOIDED. WHERE MULTIPLE LAYERS ARE DEPOSITED EACH LAYER MUST BE CLEANED BY WIRE BRUSH BEFORE DEPOSITION OF ANOTHER LAYER.
6. LIGHTENING HOLES ARE TO BE 10" CLEAR OF LONGITUDINAL CUTOUTS.
7. 2" DIA. DRILL HOLES ABOUT 18" APART IN ALL LONGITUDINALS CLOSE TO PLATING.

WELDING SYMBOLS			
LOCATION	FILLET WELD	REINFORCEMENT	BUTT WELD
NEAR SIDE			
FAR SIDE			
BOTH SIDES			
SIZE OF A 45° FILLET WELD IS THE NOMINAL LENGTH OF LEG. ALL WELDS CONTINUOUS UNLESS OTHERWISE STATED. SIZE OF CONTINUOUS FILLET WELDS INDICATED THUS: SIZE, LENGTH, AND 6" TO 6" SPACING OF INCREMENTS OF CHAIN INTERMITTENT WELDING INDICATED THUS: ALL REINFORCEMENTS ON BUTT WELDS TO BE 25% OF PLATE THICKNESS UNLESS OTHERWISE STATED. INCLUDED ANGLE OF BEVEL, OPENING AT ROOT, AND LOCATION OF REINFORCEMENT AND BEVEL INDICATED THUS: FIELD WELD, WELD ALL AROUND, METAL ARC WELDING TO BE USED UNLESS OTHERWISE STATED			

DUPLICATE FOR H-4357
 DUPLICATE FOR H-4358
 DUPLICATE FOR H-4359

DEPT.	DATE	ISSUED
OWNERS		
AM. BUREAU		
LYONS		
CHARTER		
SHIP		
ENGINEER		
PAINTER		
WELDER		
SHIP		
ENGINEER		
PAINTER		
WELDER		

H-4353-12-11
BETHLEHEM STEEL COMPANY
 SHIPBUILDING DIVISION SPARROWS POINT, MD.
TRANSVERSES
 NOS. 54, 55, 57, 58, 60 & 61.

SCALE 1/2" = 1'-0"
 DRAWN F.M.M. APPROVED *[Signature]*
 TRACED APPROVED *[Signature]*
 CHECKED APPROVED *[Signature]*

APPROVED BY: AMERICAN BUREAU OF SHIPPING --- MAR 7 1940
 JOCONY VACUUM OIL CO. --- MAR 25 1940
 LLOYD'S REGISTER OF SHIPPING MAR 22 1940

TRANSVERSE 57 - PORT SIDE LOOKING FORWARD
 TRANSVERSES 54, 55, 58, 60 & 61 ARE
 SIMILAR EXCEPT AS NOTED

S.S. "Indiana"
Ball Rpt. # 7677