

NOTES

GENERAL

INSIDE OF NOZZLE TO BE COATED WITH BITUMINOUS SOLUTION DURING CONSTRUCTION. WHEN THE HALVES OF MAIN SHROUD RING ARE TACK WELDED AND MAIN WEB IS ATTACHED, BALKS OF TIMBER, CHECKED INTO EACH OTHER, ARE TO BE JAMMED INSIDE NOZZLE SHROUD RING TO PREVENT DISTORTION DURING SUBSEQUENT WELDING OPERATIONS, AND ARE TO REMAIN IN PLACE DURING TRANSIT FROM SHIP TO DRY DOCK. TEMPORARY DIAPH 6 TO BE USED IN MAKING UP & REMOVED PRIOR TO ERECTION. MAIN FRAME & ALL PLATING EXCEPT 5/8 SHROUD PLATING TO BE REMOVED BETWEEN W/T DIAPH 5 & TEMPORARY DIAPH 6. PART MAIN REMOVED, TO BE CUT TO SHAPE & WELDED TO STERN FRAME BEFORE REMAINDER OF PORTABLE PLATING IS LOCATED.

PLATES MARKED THUS TO BE FULLY FASHIONED AND ATTACHED BY TACK WELDING ON ONE EDGE. THE OTHER EDGE TO HAVE FOUR INCHES OF TOLERANCE, TO BE TRIMMED TO TEMPLATE ON SITE.

NOZZLE BETWEEN WATERTIGHT DIAPHRAGM TO BE TESTED TO A HEAD OF 8 FT OF WATER OR 5 LBS AIR PRESSURE. WATERTIGHT PLUGS TO BE FITTED IN DIAPHRAGMS AND TO BE REMOVED AFTER NOZZLE BODY IS ERECTED TO ENABLE TEST OF COMPLETE NOZZLE. APRONS AND THAT PART OF NOZZLE BETWEEN THE LOWER WATERTIGHT DIAPHRAGMS IN WAY OF SOLEPIECE. ALL WELDS TO BE HAMMERED UNDER TEST PRESSURE.

WELDING

BUTT WELDS SHOWN THUS

CONTINUOUS FILLET WELDS SHOWN THUS

INTERMITTENT FILLET WELDS SHOWN THUS

EDGES OF PLATES AT BUTT WELDS TO BE VEE TO AN ANGLE OF NOT LESS THAN 60° WITH A GAP OF NOT LESS THAN 1/16" AT BOTTOM (SEE DETAIL)

INTERMITTENT WELDS TO BE 3" IN LENGTH AND 7/8" APART CENTRE TO CENTRE AND ON ALTERNATE SIDES OF THE PLATE EXCEPT AT ENDS AND IN WAY OF OUTSIDE BUTTS, WHERE THEY MUST BE OPPOSITE EACH OTHER. WHERE THIS IS NOT POSSIBLE, WELD TO BE MADE CONTINUOUS AND TO EXTEND TO THE FULL THICKNESS OF PLATE. (SEE DETAIL) WELDING GENERALLY TO BE IN ACCORDANCE WITH CLASSIFICATION SOCIETY'S RULES. BUTT WELDS TO BE DRESSED SMOOTH. CIRCUMFERENTIAL WELDS TO BE FINISHED FLAT AND SMOOTH. CIRCUMFERENTIAL BUTT WELDS IN WAY OF CYLINDRICAL SHROUD AND FLARED ENTRY PLATES TO BE GROUND DEAD FLUSH & SMOOTH. LONGITUDINAL BUTTS MAY BE LEFT SLIGHTLY PROUD AS SHOWN IN DETAIL. MODIFICATION OF WELDED BUTTS CAN BE MADE, SUBJECT TO APPROVAL OF CLASSIFICATION SOCIETY'S SURVEYOR. WHERE POSSIBLE, ANY ADDITIONAL BUTTS RAISED TO BE CLOSE TO THE JUNCTION WITH INTERNAL DIAPHRAGM OR WEB STIFFENER, AS SHOWN IN DETAIL. THIS IS IMPORTANT WHERE SUCH BUTTS ARE LIKELY TO RECEIVE IMPACT IN SERVICE.

ALL PLATING DIAPHS - WEBS & DEEP FLOORS 1/4" EXCEPT MAIN SHROUD AT 5/8"

DEEP FLOORS

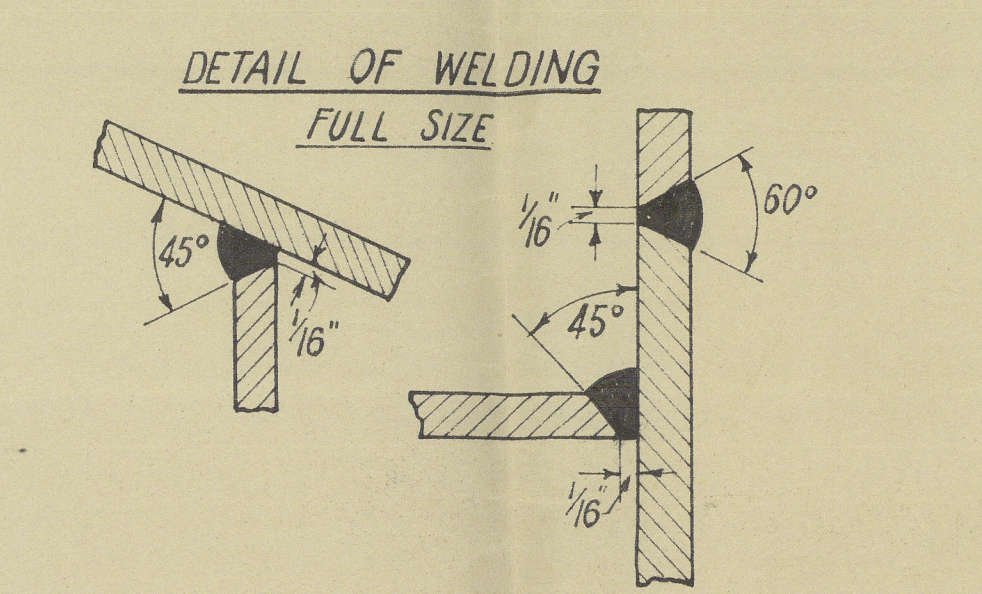
	A	B	C	D	E	F	G	H	J
FR 1	—	—	—	1'6 1/2"	—	—	—	—	—
2	—	—	—	2'6"	5'3"	6'5"	—	—	*
3	—	—	—	3'11 1/4"	4'6"	5'10 1/2"	—	2'1 1/8"	—
4	4'8"	3'10"	4'	4'8 3/4"	4'0"	5'6 3/4"	1'3"	9"	10 3/4"
5	4'9 1/8"	4'6 1/2"	7 1/2"	5'4 1/4"	3'2"	5'4 1/2"	—	2'3"	1'6 5/8"
6	4'10 1/4"	5'2 1/4"	11"	5'9 1/4"	2'7 1/2"	5'3"	—	3'3"	2'2 1/2"

* FR 2 SCRIBE A LINE 3/8" OUTSIDE CONTOUR AS FOR 4'10 DIA TO ALLOW FOR DIFFERENCE BETWEEN 1/4" PLATE & 5/8 SHROUD PLATE G & H ALLOW FOR TRIMMING TOLERANCE

RADIAL DIAPHRAGMS

	A	B	C	D	E	F	6"	FOR D 12"	OF 18"	BUTT 21"	24"
12 & 3	3'9 1/8"	3'11 1/8"	2 1/4"	1'5 1/8"	7 1/2"	3 1/4"	2 1/4"	5'1 1/8"	8'4"	—	—
4	1'8 3/8"	3'10 1/8"	3'9 1/8"	1 1/4"	1'1 1/8"	5'2"	3 1/4"	2'8"	5"	6'4"	8'1/2"
5	3'10 1/8"	3'9 1/8"	1 1/4"	1'1 1/8"	4'4"	3'8"	2'1 1/8"	4"	5'2"	7'3/8"	—
6	3'10 1/8"	3'9 1/8"	1 1/4"	1'1 1/8"	4'8"	3'2"	2"	3'8"	5'8"	7'1/8"	—

☒ TO & 4" PIPE ☒ TO & 2" PIPE
ALL DIMENSIONS FOR DEEP FLOORS & DIAPHRAGMS ALLOW FOR THICKNESS OF PLATE & ARE CORRECT FOR CUTTING TO



S. T. FOREMOST
DETAILS OF STEELWORK
FOR KORT NOZZLE
SCALE 1" = 1'0" & AS SHOWN.
KORT PROPULSION CO. LTD.
BLACKWALL YARD, LONDON E 14

S/T. "Foremost".

Add rept No. 3050.

Details of steelwork for Kort-
nozzle. Foremost.



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