

PRINCIPAL DIMENSIONS

LENGTH B.P.	416'-0"
BREADTH EXT.	57'-11"
BREADTH MID.	56'-10 1/2"
DEPTH MID. UPPER DECK	37'-4"
DEPTH MID. SECOND DECK	28'-7"
DEPTH TO LENGTH UPPER DECK CLASS	11'-14"
CLASS	* 100 A1 WITH FREEBOARD
RAFT MID.	26'-10"

SHEER STRAKE

1/4" - 20.00" PLATING (WITH TWEEN DECK FRAMES ON EVERY FRAME) TO 7/16" - 17.00" PLATING AT BOTH ENDS

STRAKE BELOW SHEER STRAKE

3/8" - 25.5" PLATE TO 3/16" - 17.00" AT ENDS

SIDE SHELL

SIDE SHELL 3/8" - 25.5" PLATE WITH 30" SPACING TO 7/16" - 17.00" AT ENDS. SIDE SHELL 25% ABOVE END THICKNESS - 3/16" IN WAY OF PAINTING IN LIEU OF STIFFENERS FOR A DISTANCE AFT OF KEEL POSITION AT COLLISION BULKHEAD EQUAL TO 10% OF L OF VESSEL

DETAIL OF BILGE BRACKETS

AFT OF FRAME 60 & FORWARD OF FRAME 100 (EXCEPT NO. 1 HOLD)

UPPER DECK STRINGER PLATES

ELECTRIC WELD TO SHEER STRAKE AT ENDS
3/4" - 30.6" TO 3/4" - 15.50"
STRINGER ANGLE - 6° 0' - 7/16" TO 4° 4' - 3/16"

UPPER DECK PLATING

56' - 25.5" TO 56' - 15.50"
ALL BUTTS WELDED SEAMS RIVETED

UPPER DECK BEAMS

FORE PEAK 8" - 3 1/2" x 54" B ANGLE 16°
THROUGH BEAMS 8" - 5 1/2" x 46" " " 20°
HALF BEAMS 8" - 5 1/2" x 46" " " 20°
THROUGH BEAMS 10" - 3 1/2" x 46" " " 20°
AFTER PEAK 8" - 3 1/2" x 46" " " 20°
7" - 3 1/2" x 30" " " 15.6"

SECOND DECK PLATING

1 1/2" - 14" TO 1 1/2" - 12.50"
BUTTS WELDED SEAMS RIVETED

SECOND DECK BEAMS

FORE PEAK 7" - 5 1/2" x 32" B ANGLE 15.6°
THROUGH BEAMS 10" - 4" x 40" CHANNEL 35°
HALF BEAMS 8" - 3 1/2" x 46" B ANGLE 20°
AFTER PEAK 8" - 3 1/2" x 46" B ANGLE 20°
7" - 3 1/2" x 30" B ANGLE 15.6°

CENTRE LINE BULKHEAD

STEEL C/L BULKHEAD 3/16" - 12.50"
STIFFENERS TWO FRAME SPACES APART DOUBLE AT HATCH ENDS
BRACKETS AT TOP & BOTTOM AT HATCH ENDS
CONNECTION TO 2ND DECK WELDED
CONNECTION TO 1ST DECK WELDED
12" - 3 1/2" x 30" CHANNEL STIFFENERS

FLOORS

FLOORS ON EVERY PK 3/8" - 15.5" IN HOLDS WITH STIFFENERS AS SHOWN 1/2" x 20" SOLID
MT - 01 FLOORS
1/2" (ONE BRIDGE DECK) WITH STIFFENERS 6" x 3 1/2" x 3/16" 30" SPACED 30"
TANK TOP COVER STIFFENERS
80" - 15.5" x 80" - 10" 1/2" x 17.0" BULK SPACE 3/16" - 25.5"
4 1/2" PK DECK 3/4" RIVETS & DIAS. APART

TANK TOP PLATING

1/16" - 1.9" TO 3/16" - 10.9" EX - 1/2" (20.5) BK - 3/16" - 20.50"
FRAMES IN TANK
3 1/2" x 3 1/2" x 1/16" - 9.8"

REVERSE BEAMS IN TANK

3 1/2" x 3 1/2" x 1/16" - 9.8" - 14.9" IN BK 6" x 1/2" - 10.9"
UNDER ENGINES 3 1/2" x 3 1/2" x 1/16" - 9.8" DOUBLE UNDER THRUST BLOCK
6" x 3 1/2" x 24" UNDER BULKHEAD

BOTTOM FRAMES

FROM 1/2" L FORWARD TO COLLISION BULKHEAD 6" x 3 1/2" - 14.9" WITH RIVETS TO SHELL 3/8" DIAS. APART, 6 DIAS. IN VERTICAL FLANGE

GIRDERS

(ONE EACH SIDE) 6" x 3 1/2" x 1/16" - 10.9" B ANGLE CONTINUOUS
TOP & BOTTOM BARS AND 6" x 3 1/2" x 1/16" - 10.9" B ANGLE AT EACH
FOOT WITH 3/8" DIAS. RIVETS TOP & BOTTOM

INTERCOSTAL PLATE GIRDERS (SEE PLAN OF TANK TOP)

3/16" - 14.92" PLATE IN HOLDS 7/16" - 17.00" IN EX - 1/2" - 20.5" IN BK
WITH VERTICALS 7" x 5 1/2" x 1/16" - 7.0" 3/16" x 3 1/2" x 1/16" - 9.8" BK
BOTTOM CONNECTIONS 3/16" x 3 1/2" x 1/16" - 9.8" TOP CONNECTIONS
3/16" x 3 1/2" x 1/16" - 9.8" 6" x 3 1/2" - 14.9" UNDER ENGINES & THRUST
4" x 4 1/2" - 12.0" ADDITIONAL GIRDERS UNDER ENGINES & FORWARD OF 1st
CENTRE GIRDERS

4" x 5 1/2" UNDER KEEL - 10.92" TO 10" - 17.00" 3/8" - 20.50" BK
TOP BARS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK
BOTTOM BARS 4" x 4 1/2" - 12.0" ALL FIVE 4" x 4 1/2" - 12.0" BK
VERTICALS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK 6" x 3 1/2" - 14.9" UNDER
ENGINES & THRUST BLOCK 6" x 3 1/2" - 14.9" UNDER BULKHEAD

CEILING GIRDERS

4" x 5 1/2" UNDER KEEL - 10.92" TO 10" - 17.00" 3/8" - 20.50" BK
TOP BARS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK
BOTTOM BARS 4" x 4 1/2" - 12.0" ALL FIVE 4" x 4 1/2" - 12.0" BK
VERTICALS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK 6" x 3 1/2" - 14.9" UNDER
ENGINES & THRUST BLOCK 6" x 3 1/2" - 14.9" UNDER BULKHEAD

CEILING GIRDERS

4" x 5 1/2" UNDER KEEL - 10.92" TO 10" - 17.00" 3/8" - 20.50" BK
TOP BARS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK
BOTTOM BARS 4" x 4 1/2" - 12.0" ALL FIVE 4" x 4 1/2" - 12.0" BK
VERTICALS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK 6" x 3 1/2" - 14.9" UNDER
ENGINES & THRUST BLOCK 6" x 3 1/2" - 14.9" UNDER BULKHEAD

CEILING GIRDERS

4" x 5 1/2" UNDER KEEL - 10.92" TO 10" - 17.00" 3/8" - 20.50" BK
TOP BARS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK
BOTTOM BARS 4" x 4 1/2" - 12.0" ALL FIVE 4" x 4 1/2" - 12.0" BK
VERTICALS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK 6" x 3 1/2" - 14.9" UNDER
ENGINES & THRUST BLOCK 6" x 3 1/2" - 14.9" UNDER BULKHEAD

CEILING GIRDERS

4" x 5 1/2" UNDER KEEL - 10.92" TO 10" - 17.00" 3/8" - 20.50" BK
TOP BARS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK
BOTTOM BARS 4" x 4 1/2" - 12.0" ALL FIVE 4" x 4 1/2" - 12.0" BK
VERTICALS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK 6" x 3 1/2" - 14.9" UNDER
ENGINES & THRUST BLOCK 6" x 3 1/2" - 14.9" UNDER BULKHEAD

CEILING GIRDERS

4" x 5 1/2" UNDER KEEL - 10.92" TO 10" - 17.00" 3/8" - 20.50" BK
TOP BARS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK
BOTTOM BARS 4" x 4 1/2" - 12.0" ALL FIVE 4" x 4 1/2" - 12.0" BK
VERTICALS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK 6" x 3 1/2" - 14.9" UNDER
ENGINES & THRUST BLOCK 6" x 3 1/2" - 14.9" UNDER BULKHEAD

CEILING GIRDERS

4" x 5 1/2" UNDER KEEL - 10.92" TO 10" - 17.00" 3/8" - 20.50" BK
TOP BARS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK
BOTTOM BARS 4" x 4 1/2" - 12.0" ALL FIVE 4" x 4 1/2" - 12.0" BK
VERTICALS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK 6" x 3 1/2" - 14.9" UNDER
ENGINES & THRUST BLOCK 6" x 3 1/2" - 14.9" UNDER BULKHEAD

CEILING GIRDERS

4" x 5 1/2" UNDER KEEL - 10.92" TO 10" - 17.00" 3/8" - 20.50" BK
TOP BARS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK
BOTTOM BARS 4" x 4 1/2" - 12.0" ALL FIVE 4" x 4 1/2" - 12.0" BK
VERTICALS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK 6" x 3 1/2" - 14.9" UNDER
ENGINES & THRUST BLOCK 6" x 3 1/2" - 14.9" UNDER BULKHEAD

CEILING GIRDERS

4" x 5 1/2" UNDER KEEL - 10.92" TO 10" - 17.00" 3/8" - 20.50" BK
TOP BARS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK
BOTTOM BARS 4" x 4 1/2" - 12.0" ALL FIVE 4" x 4 1/2" - 12.0" BK
VERTICALS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK 6" x 3 1/2" - 14.9" UNDER
ENGINES & THRUST BLOCK 6" x 3 1/2" - 14.9" UNDER BULKHEAD

CEILING GIRDERS

4" x 5 1/2" UNDER KEEL - 10.92" TO 10" - 17.00" 3/8" - 20.50" BK
TOP BARS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK
BOTTOM BARS 4" x 4 1/2" - 12.0" ALL FIVE 4" x 4 1/2" - 12.0" BK
VERTICALS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK 6" x 3 1/2" - 14.9" UNDER
ENGINES & THRUST BLOCK 6" x 3 1/2" - 14.9" UNDER BULKHEAD

CEILING GIRDERS

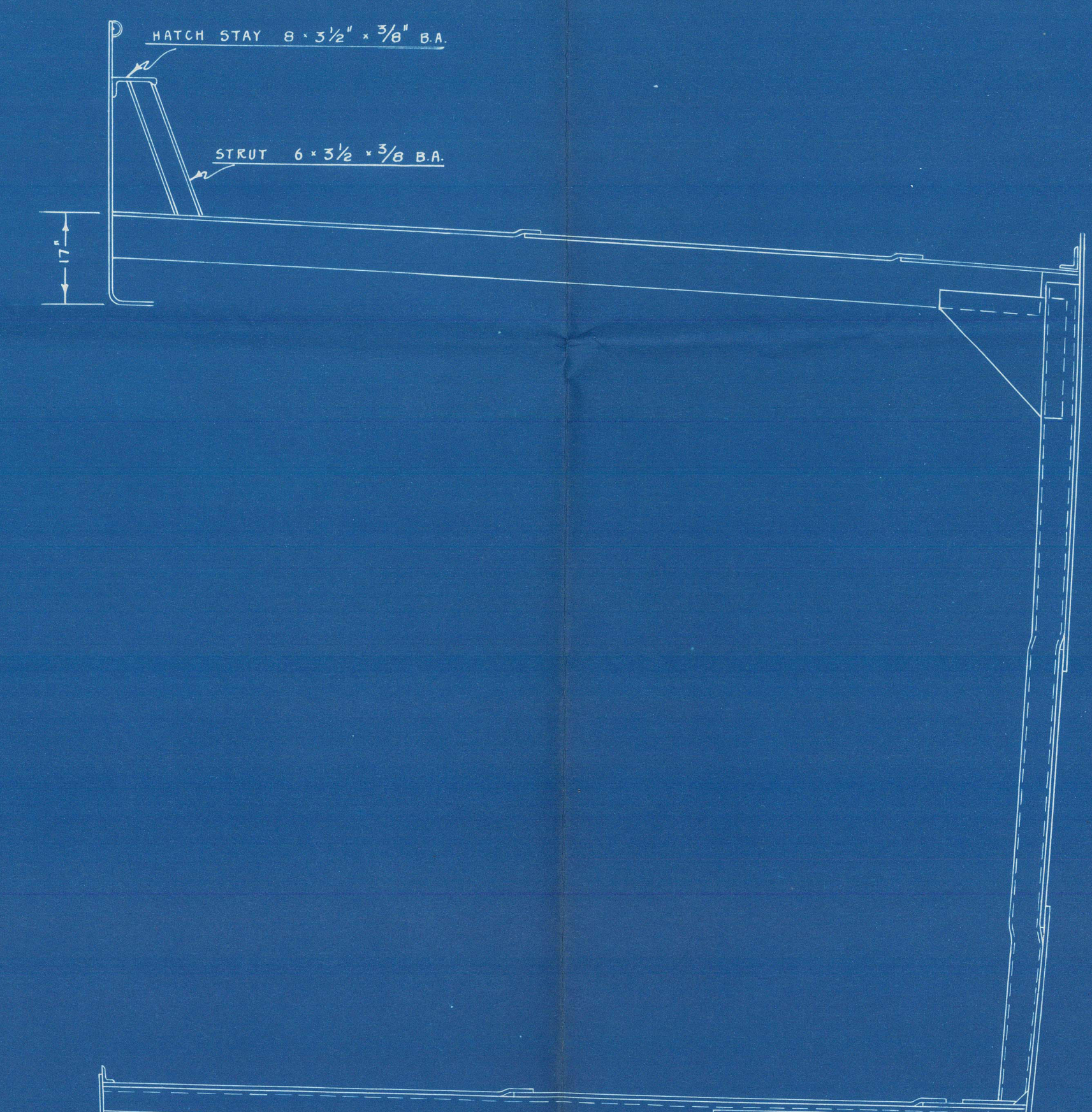
4" x 5 1/2" UNDER KEEL - 10.92" TO 10" - 17.00" 3/8" - 20.50" BK
TOP BARS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK
BOTTOM BARS 4" x 4 1/2" - 12.0" ALL FIVE 4" x 4 1/2" - 12.0" BK
VERTICALS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK 6" x 3 1/2" - 14.9" UNDER
ENGINES & THRUST BLOCK 6" x 3 1/2" - 14.9" UNDER BULKHEAD

CEILING GIRDERS

4" x 5 1/2" UNDER KEEL - 10.92" TO 10" - 17.00" 3/8" - 20.50" BK
TOP BARS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK
BOTTOM BARS 4" x 4 1/2" - 12.0" ALL FIVE 4" x 4 1/2" - 12.0" BK
VERTICALS 3 1/2" x 3 1/2" x 1/16" - 9.8" 4" x 4 1/2" - 12.0" BK 6" x 3 1/2" - 14.9" UNDER
ENGINES & THRUST BLOCK 6" x 3 1/2" - 14.9" UNDER BULKHEAD

UPPER DECK HATCHES

UPPER DECK HATCH COAMING
7/16" - 3'-0" HIGH AT 4
UPPER DECK HATCH GIRDERS
7/16" - 17" FLANGE 10 1/2"



SECOND DECK HATCHES

HATCH COAMING 3" - 1 1/2" - 1/2" BK
HATCH GIRDERS 3/16" - 24"
FLANGE 8" - 20" WITH RIVER PLATES TO SUIT

WEB FRAME

NO. 1 HOLD ONLY
WEB FRAME SITUATED ON FRAME 140
1 1/2" x 48" WEB PLATE
2 - 15" x 4" x 1/4" @ 31.8"/FT. FACE BARS
1" x 10" RIVER PLATE

STRINGER

NO. 1 HOLD ONLY
STRINGER IN NO. 1 HOLD FRAMES 150-162
1 1/2" x 48" PLATE
15" x 4" x 1/4" @ 31.8"/FT. FACE BARS

WELDING NOTES



SINGLE VEE BUTT WELD

TO BE USED ON ALL MANUALLY WELDED SHELL BUTTS,
DECK & TANK TOP BUTTS, TUNNEL BUTTS ETC.
FULL PENETRATION CONTINUOUS WELD ON TOP SIDE
LIGHT STAYING WELD ON UNDER SIDE

UNION MELT AUTOMATIC WELD

TO BE USED ON PRE-ASSEMBLED WALKWAY & DECKHOUSE
PANELS ETC.
EDGES OF PLATE NOT BEVELLED BUT LEFT SQUARE &
BUTTED TOGETHER
CONTINUOUS BEAD WELDED FROM UPPER SIDE
PANEL RECESS & CONTINUOUS BEAD WELDED ON
BOTTOM SIDE

VERTICAL SINGLE BEVEL BUTT WELD

TO BE USED ON HORIZONTAL SEAMS ON SIDE SHELL &
STRAKE SIMILAR POSITIONS
BOTTOM PLATE TO RETAIN SQUARE EDGE
UPPER PLATE TO BE BEVELLED TO GIVE 50° INCLUDED
ANGLE

SINGLE BEVEL BUTT WELD

TO BE USED ON SECOND DECK TO SHELL CONNECTION
UPPER DECK TO SECOND DECK TO HATCH COAMING
STRAKE PLAT & TUNNEL RECESS TO SHELL
FULL THICKNESS WELD DOWNWARD SINGLE PASS WELD
OVERHEAD

CONTINUOUS & INTERMITTENT FILLET WELD

USED ON STRINGER & WEB FRAME CONNECTIONS TO SHELL
DECK GIRDERS TO PEEL - BULKHEAD STRINGERS TO
BULKHEAD ETC.
CONTINUOUS FULL THICKNESS FILLET WELD DOWNWARD
INTERMITTENT WELD OVERHEAD

INTERMITTENT FILLET WELD

USED ON BULKHEAD STIFFENER TO BULKHEAD ETC.
INTERMITTENT WELDS

ALL WELDING TO MEET SURVEYORS' APPROVAL - WELDING RODS
TO BE APPROVED BY CLASSIFICATION SOCIETY
ALL BUTTS & BEVELLED FILLET WELDS TO HAVE STAYING
WELD ON EXPOSED SIDE
BULKHEAD STIFFENERS & WELDS TO BE INTERMITTENT
WELDED WITH SIZES & SPACING OF TACKS

EQUIPMENT

2 STOCKLESS ANCHORS	8400 LBS. EACH
1 STOP LINK CHAIN CABLE	270 FATHOMS 2 1/4" HT. STEEL
1 STREAM ANCHOR (STOCKLESS)	23 3/4 CWS
1 STEAM WIRE	90 FATHOMS
1 TOWLINE	120 " "
2 HAWSEERS EACH	90 " "
2 WARPS EACH	90 " "

ISSUED BY THE ROYAL NAVAL ARCHITECTS
Star
55 MOUNT ROBSON PARK
HULL NO. 144

REVISIONS

WE COAST SHIPBUILDERS LTD.

10,000 TON VICTORY SHIP (1944 SERIES)

MIDSHIP SECTION

DESIGNED DRAWN TRACED CHECKED

APPROVED REVISED DATE SCALE

DEC 7 1945 DEC 29 1946 1/8" = 1 FT

HULL NO. 138 - 145 DWG. NO. H-701 A