

[illegible]

WELDING SPECIFICATIONS & DETAILS

SURFACES FOR WELDING TO BE EXPOSED TO A GOOD FIT UP & GAPS SPECIFIED TO BE MAINTAINED AS SHOWN IN DETAILS. WHERE MULTI-PASS ARE SPECIFIED THE SURFACES OF EACH LAYER ARE TO BE THOROUGHLY CLEAN & FREE FROM SLAG. BACK OF WELDS TO BE CHIPPED DOWN TO THE SOLID METAL BEFORE APPLYING THE SEALING RUN. ELECTRODES TO BE USED AS FOLLOWS: RED/WHITE "A" FOR SHIELD METAL WELDING & QUINACRYL ARC WORTIC FOR POSITIONAL WELDING. ALUMINUM FILLETS MADE WITH N°6G. ELECTRODES. ALUMINUM FILLETS MADE WITH N°6T. ELECTRODES.

TANK CONSTRUCTION

OF 5/16" SIDE & BOTTOM PLATES 1" TOP PLATE & CENTRE WASH PLATE. WITH 4X3/4" FLAT BAR STIFFENERS & 2Y2 X 2Y2 X 1/4" BRACING ANGLES ALL WELDED COMPLETE.

LADDERS

TWO PER TANK FROM 3/4" DIA M.S. ONE EACH SIDE OF CENTRE WASH PLATE.

SUMP

OF 5/16" PLATE. OFFSET FROM 1" AS SHOWN.

LIFTING LUGS

FROM 1" THICK M.S. PLATE SPACED AT 8'-0" CTRS. PROVIDED WITH 2" DIA HOLES. LUGS SHOWN WELDED ON E OF TANK WITH 5/16" CONTINUOUS FILLET WELD.

MANHOLE

ONE PER TANK AS DETAILED ON DRG. N° 8806/60 ON E OF TANK LENGTH.

SUCTION PIPE

1" DIA M.S. FABRICATED PIPE PER TANK. BOTTOM OF PIPE TO HAVE CUP TO TANK END.

DIP CUPS

AS DETAILED 2 PER TANK.

TESTING

TANKS TO BE TESTED TO 240" HEAD BEFORE INSTALLATION IN RANGE.

PAINTING

AS DETAILED ON DRG. N° 806157.

NOTE:-
ALL STIFFENERS TO SIDE PLATE TOP &
BOTTOM PLATE & DIVISION PLATE - DOUBLE
INTERMITTANT $\frac{1}{4}$ " FILLET WELD 3"
DEPOSIT 4" GAP. 6" CONTINUOUS AT ENDS

TYPICAL SECTION
SHOWING BRACING.

BOTH MATING FLANGES
MACHINED FOR JOINT

M.S. FABRICATED SUCTION PIPE. 1 READ PER TANK. 2/

2-REED. PER BARGE. FLAME CUT FROM 3/4" M.S. PLATE

DETAIL SHOWING FIXING OF
TANKS IN BARGE HOLD.

note:- When tanks are tested prior to installation in barge tanks to be supported by beams having spacing 1/4 same as that indicated (18 remove and no less)

GENERAL NOTES:-
TWO TANKS COMPLETELY AS DRAWN ARE REQUIRED FOR EACH BARGE BUILT TO G.A.K. DETAILS DRAWN
NO 8346/58.
TANK CAPACITY:- 75 TONS PETROLEUM SPIRIT AT 77° SR GR WITH ULLAGE ALLOWANCE OF 5"
TANK WEIGHT:-

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ENGINEER'S
 DEPARTMENT

W.M.
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 & SON LTD.

ERITH WHARF
 KENT

CORY TANK LIGHTERAGE

TITLE: ARRANGEMENT DETAILS OF TANKS FITTING
 & FIXINGS FOR 150 TON WELDED TANK BARGE

SCALE: 3" = 6' 6" 12" = 1 FOOT

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CHARRINGTON GARDNER & LOCKER (LONDON) L^{TD}

DARTFORD

PETROLEUM BARGE "STONERACE" LONDON REP N^o 135754
5 PTB 3275

STONERIG LONDON REP N^o 136489
5 PTB

STONERACE LONDON REP
5 PTB

ARRANGEMENT & DETAILS OF TANKS, FITTINGS &

FIXINGS FOR 150 TON WELDED TANK BARGE

PLAN N^o 8.420/65A

APPROVED
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