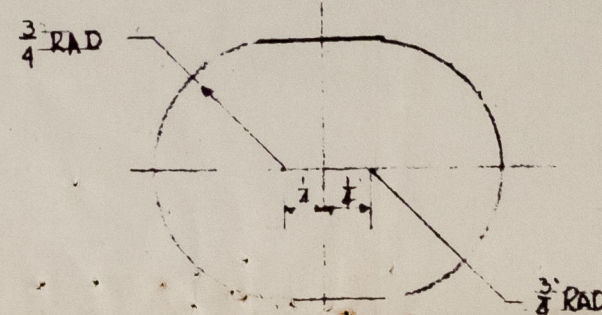
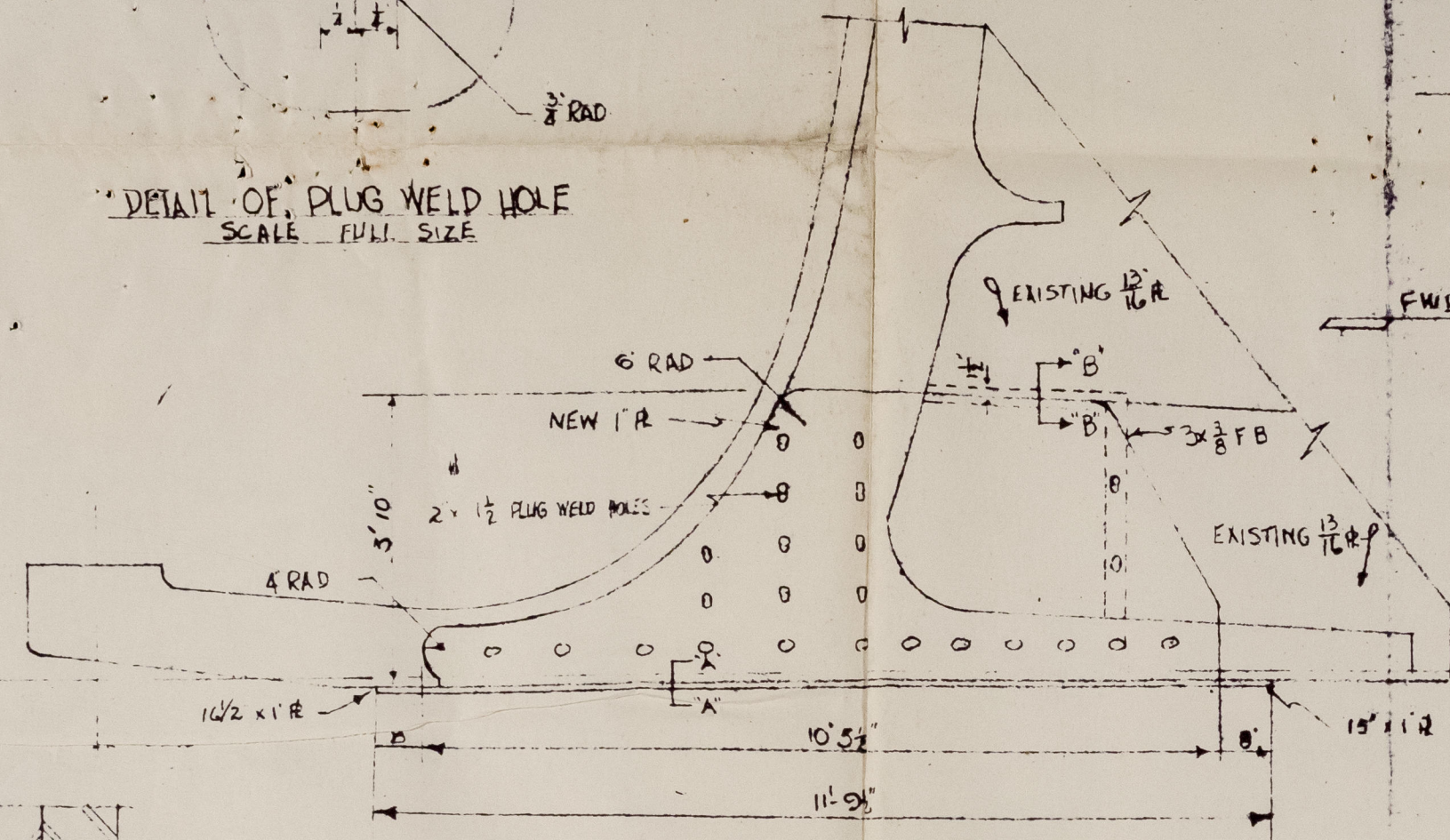


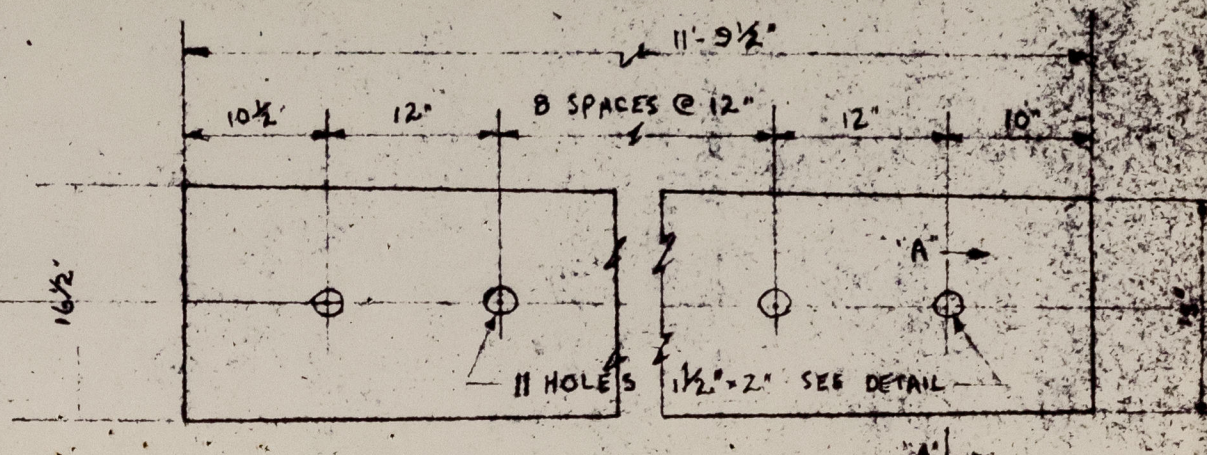
SECTION B-B
SCALE FULL SIZE



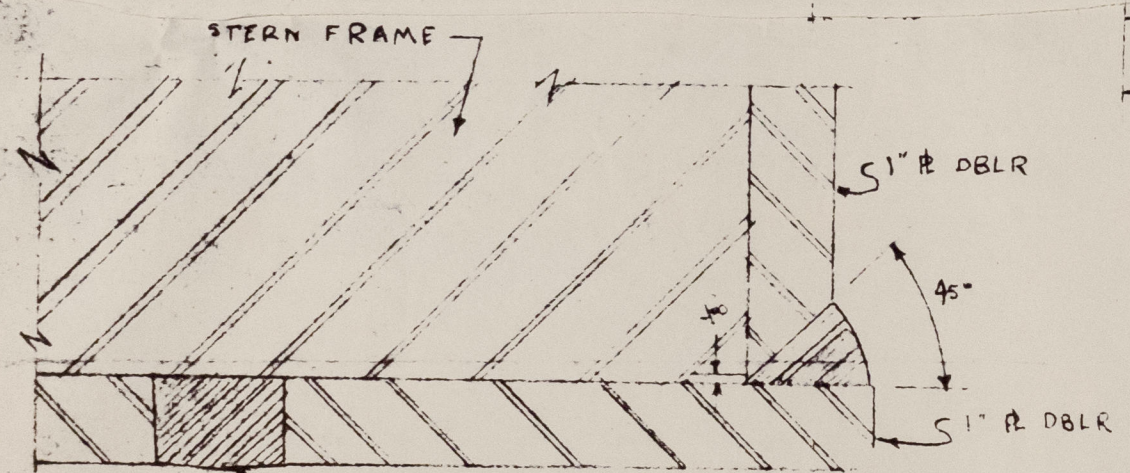
DETAIL OF PLUG WELD HOLE
SCALE FULL SIZE



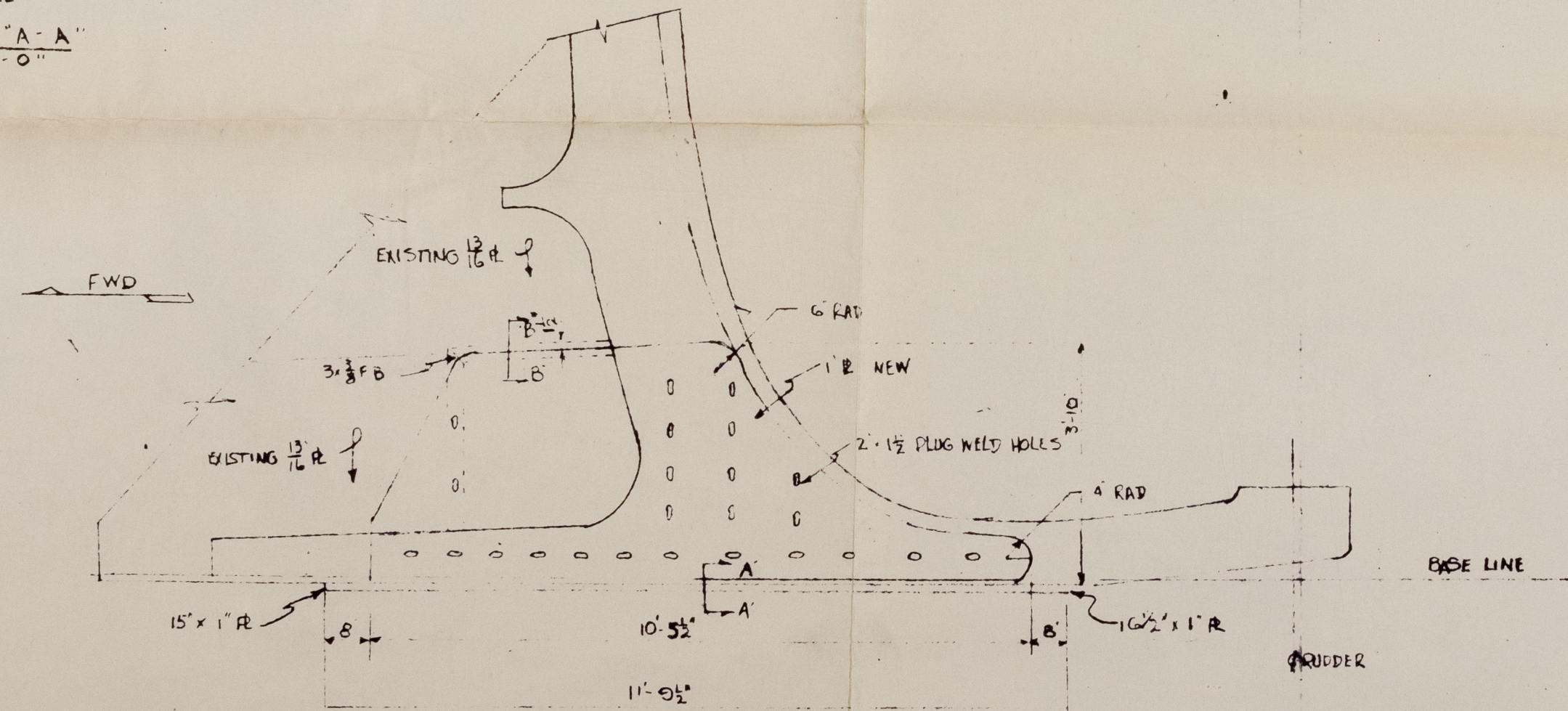
STBD ELEVATION STERN FRAME
SCALE 1" = 1'-0"



PLAN VIEW OF BOTTOM DOUBLER
SHOWING PLUG WELDS
SCALE 1" = 1'-0"



SECTION A-A
SCALE 6" = 1'-0"



PORT ELEVATION STERN FRAME
SCALE 1" = 1'-0"

CRACK REPAIRING PROCEDURE

1. DRILL HOLES AT END OF FRACTURES
2. CHIP OUT FRACTURE TO DEPTH OF FRACTURES
3. MAGNETIC PARTICLES TO ASSURE SOUNDNESS OF METAL
4. PREHEAT FRACTURE FRAMES SIMULTANEOUSLY TO A TEMPERATURE OF 400°F BEFORE WELDING
5. BLOCK WELD STERN FRAME TO BE SIMULTANEOUSLY USING SUE 501 LON (VACUUM) WELDING WIRE
6. MAGNETIC PARTICLES TO ASSURE SOUNDNESS OF METAL
7. UPON COMPLETION OF WELDING STERN FRAME TO BE PREHEATED TO TEMPERATURE OF 1000°F P/S SIMULTANEOUSLY AND COVERED WITH ASBESTOS TO FACILITATE SLOW COOLING

WELDING SEQUENCE

1. WELD PLUG WELD HOLES P/S SIMULTANEOUSLY
2. BLOCK WELD STERN FRAME P/S SIMULTANEOUSLY
3. UPON COMPLETION OF WELDING DOUBLES TO BE COVERED WITH ASBESTOS TO FACILITATE SLOW COOLING

TO ACCOMPANY
REPORT NO. 10249
DATED 5/54

SHELL OIL CO. OF CANADA LTD.

9/5 PINNACLES
STERN FRAME CRACK REPAIR

SCALE AS SHOWN

CHECKED

DATE

APPROVED

DRAWN BY

NO.	REVISION	DATE	BY	CHK'D
1	DISPOSAL			
1	HOME OFFICE			
1	MR. CASE NEW YORK			
1	MR. PAVSEN BALTIMORE	X		
1	MR. PALLAS CSI TORONTO			
1	ABS BALTIMORE			

Sternframe crack repair

'Pinnacles'

Bal 10249.

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Foundation