

SHIP N° 386. RUDDER

SCALE 3/4" = 1 FOOT

PLAN № 6.

DRAFT 24'-4 1/4' ABOVE TOP OF KEEL

L.B.P. =  $420' - 7\frac{1}{2}''$

SPEED ~~IN~~ KNOTS  $\times 1.85$  per Double.

A - AREA OF RUDDER - 148.75 SQ. FT.

D - CG OF RUDDER ABAFT  $\frac{1}{2}$  OF RUDDER POST - 1.42 FT.

A.D. 24. B. A. x D. = 225 (Afr of 4 Stock.)

RUDDER HEAD 9" DIA.

INTERNAL SURFACES OF RUDDER TO BE COVERED

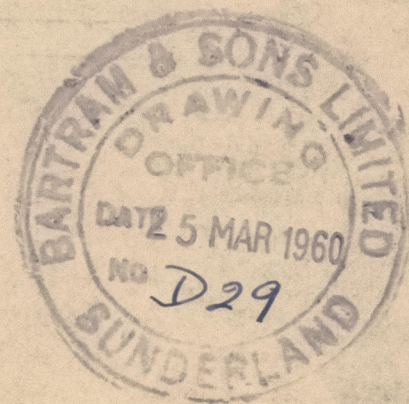
WITH TWO COATS OF BITUMINOUS SOLUTION.

RUDDER TESTED TO A PRESSURE 516/59. IN.

ALL MATERIAL TO BE IN ACCORDANCE WITH LLOYD'S RULES

ALL MATERIAL TO BE IN ACCORDANCE WITH LLOYDS RULES.

1



BARTRAM & SONS, LTD.,  
SOUTH DOCK, SUNDERLAND.

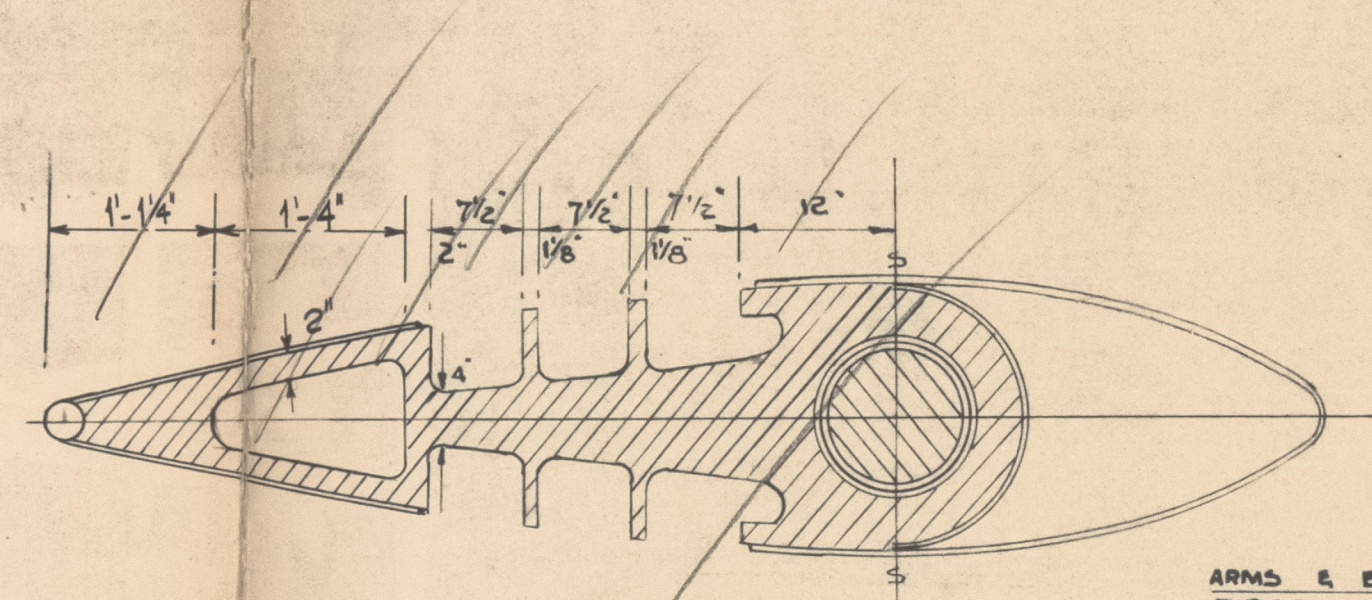
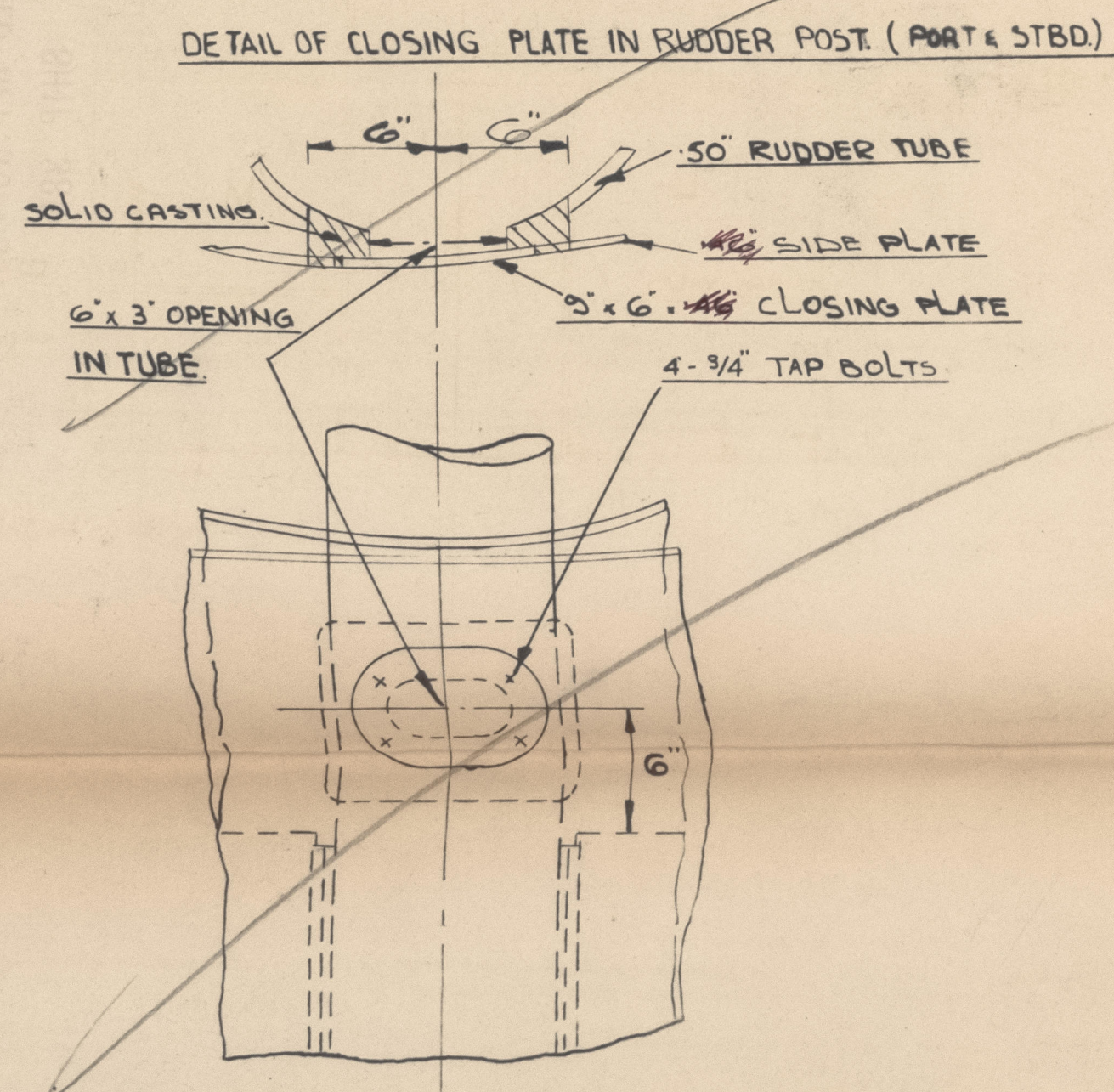
Messrs

LLOYDS

0059/

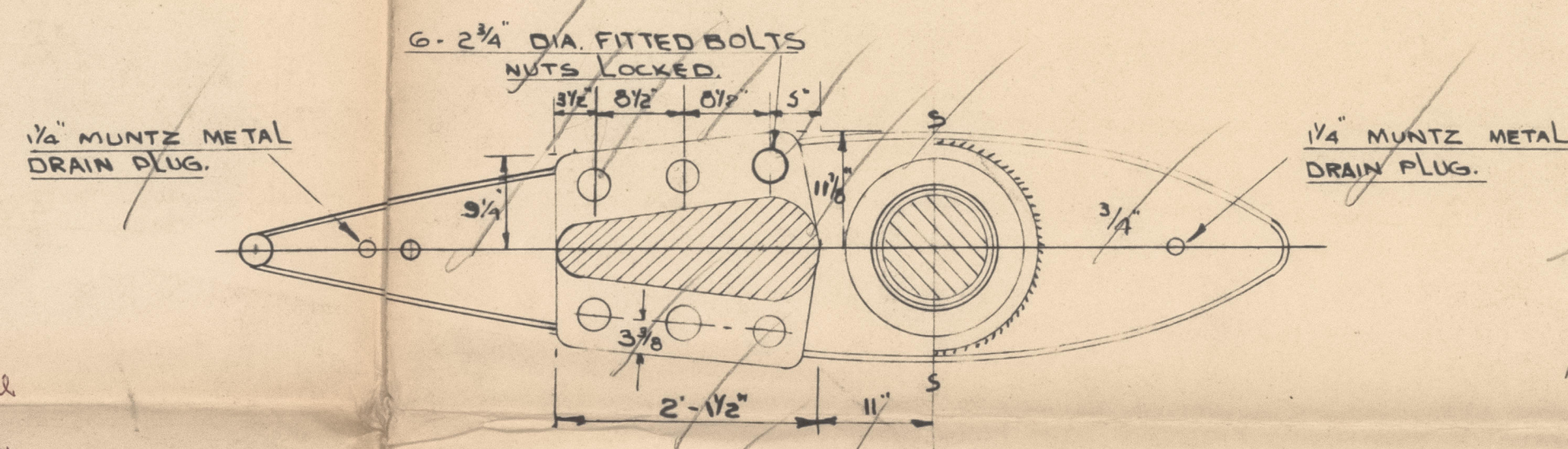
1. WELD TUBE, BEARING BLOCKS, HORIZ. WEBS, VERT'L WEB, S. DIA. ROUND AND TOP ARM INTO POSITION.  
(NOTE - BOTTOM PLATE OMITTED).
2. WELD PANELS 'A' & 'C' TO PORT SIDE OF RUDDER.
3. TURN RUDDER OVER AND WELD PANEL 'A' IN POSITION  
ON STBD. SIDE, FOLLOWED BY C, E, G & J.
4. TURN RUDDER OVER AND WELD PANEL 'E' IN POSITION ON  
PORT SIDE FOLLOWED BY G, J & L.
5. TURN RUDDER OVER AND WELD PANEL 'L' IN POSITION ON STBD.
6. WELD PANELS B, D, F, H, K & M IN POSITION ON STBD. SIDE.  
TURN RUDDER OVER & WELD PANELS B, D, F, H, K & M IN POSITION  
ON PORT SIDE.
7. WELD NOSE PLATE IN POSITION.
8. FINALLY WELD BOTTOM PLATE IN POSITION.

Not applicable in present case  
where existing mudder to be dissolved  
in benzol.

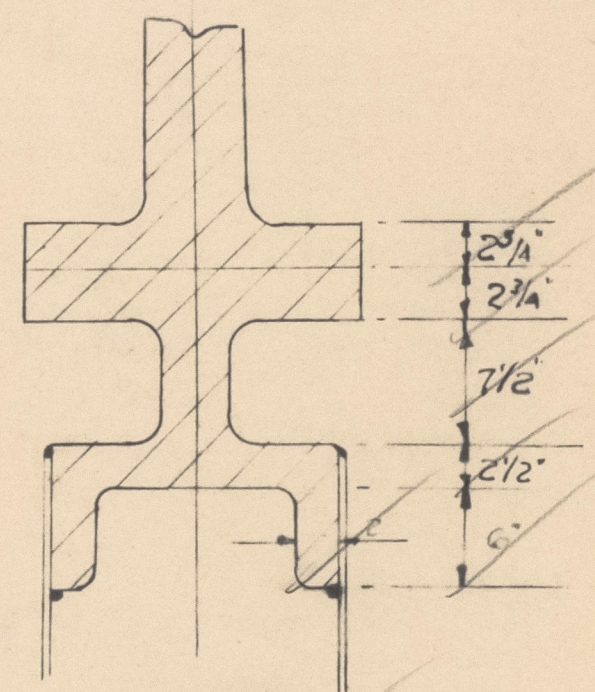


SECTION AT B'-B'

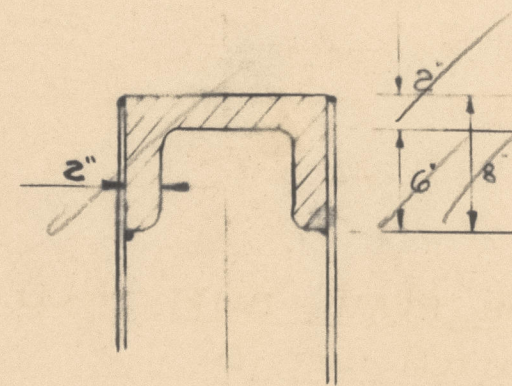
~~ARMS & BOSS CAST IN ONE  
PIECE. CARBON CONTENT NOT  
TO EXCEED 0.25%.~~



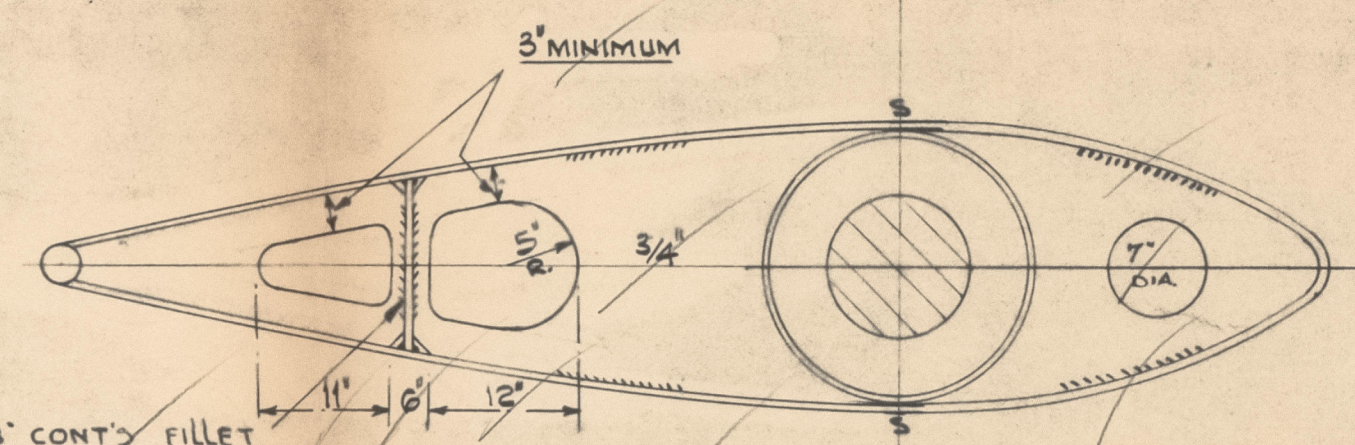
SECTION AT A-A



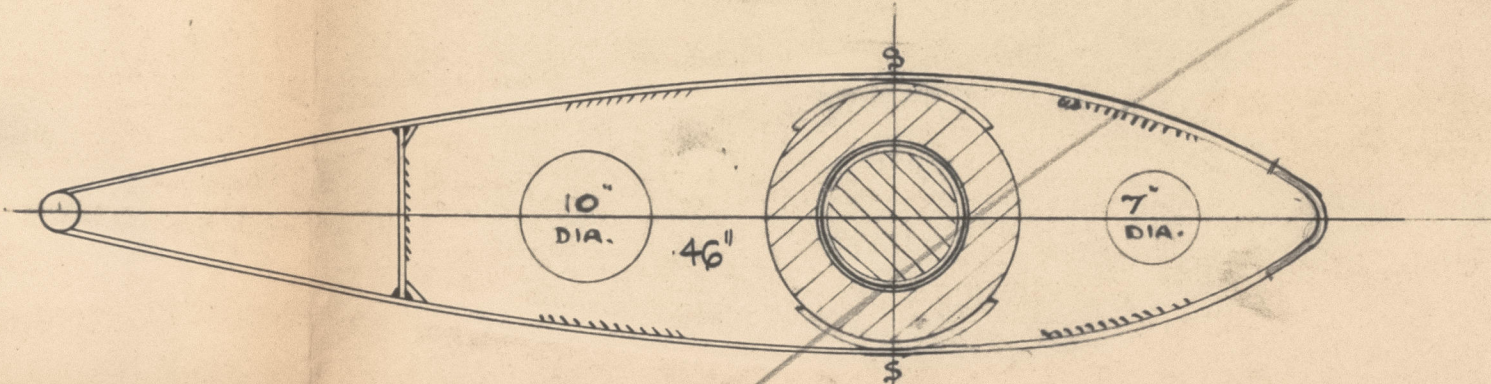
SECTION AT E-E



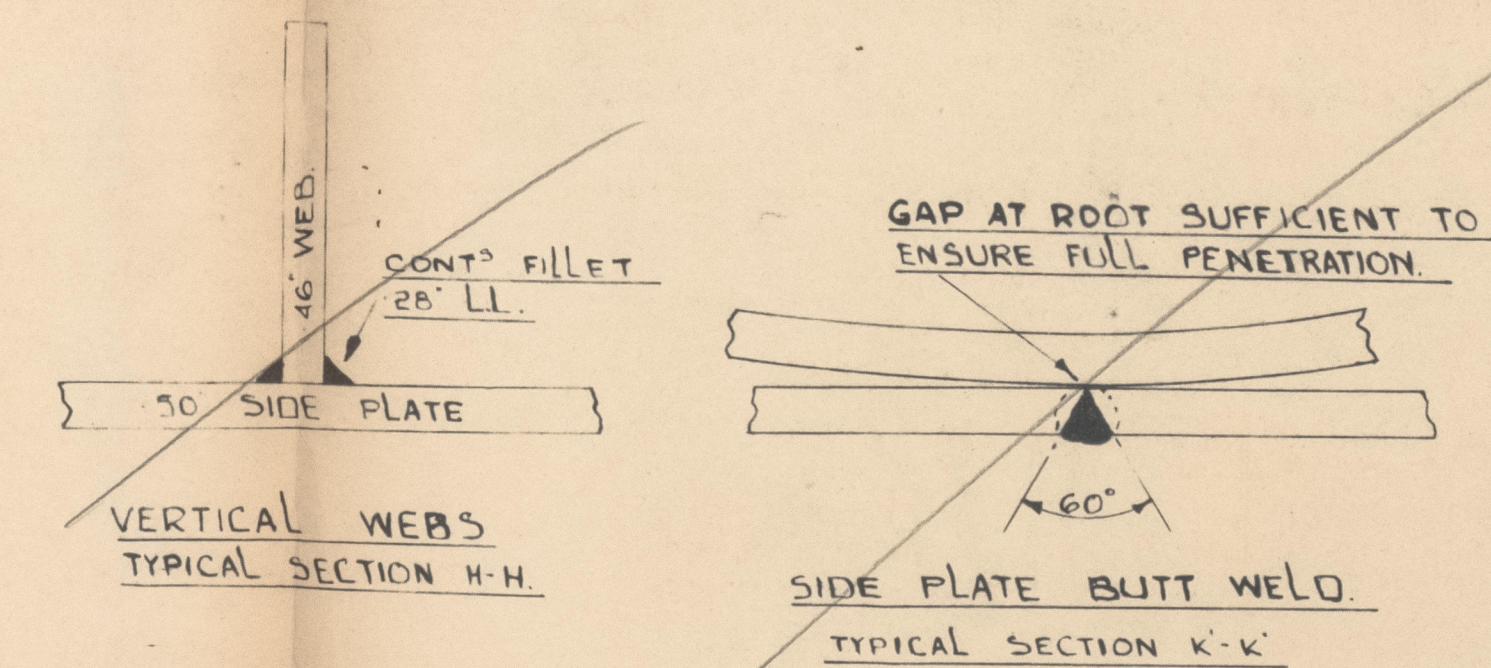
SECTION AT F-F



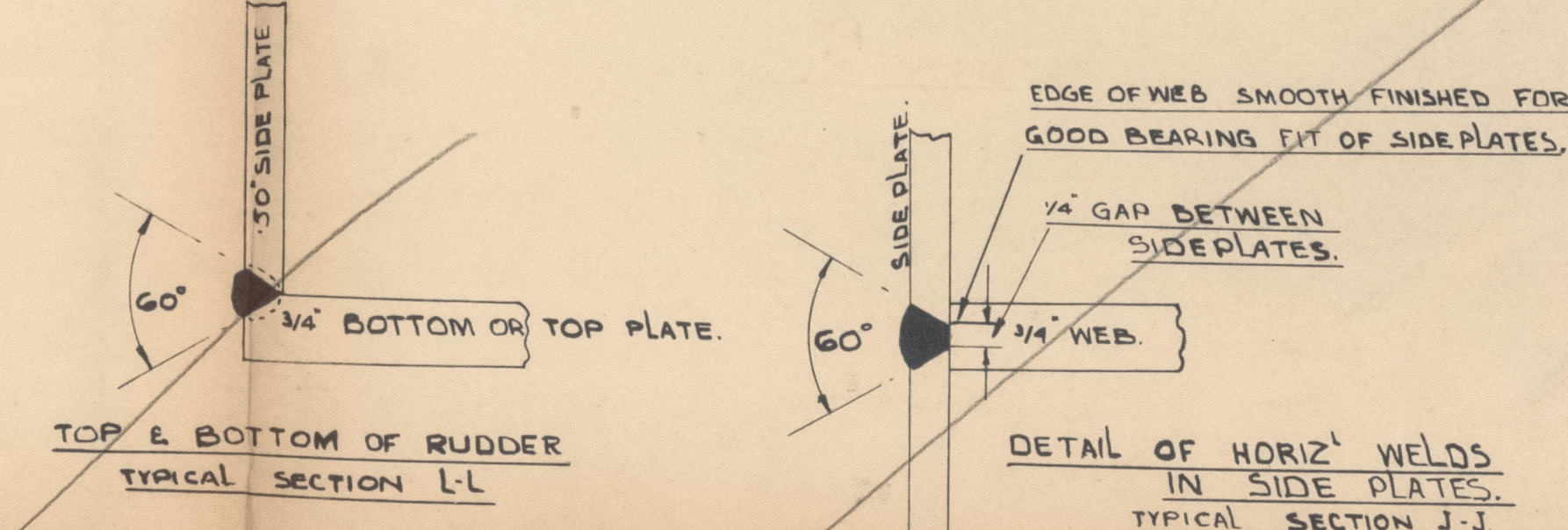
SECTION AT C'-C'



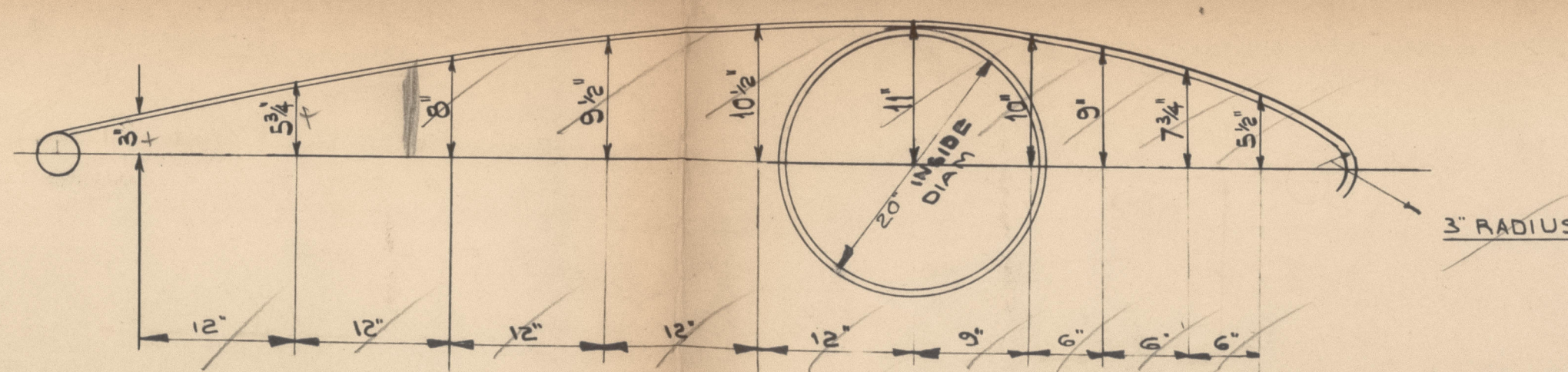
SECTION AT D-D'



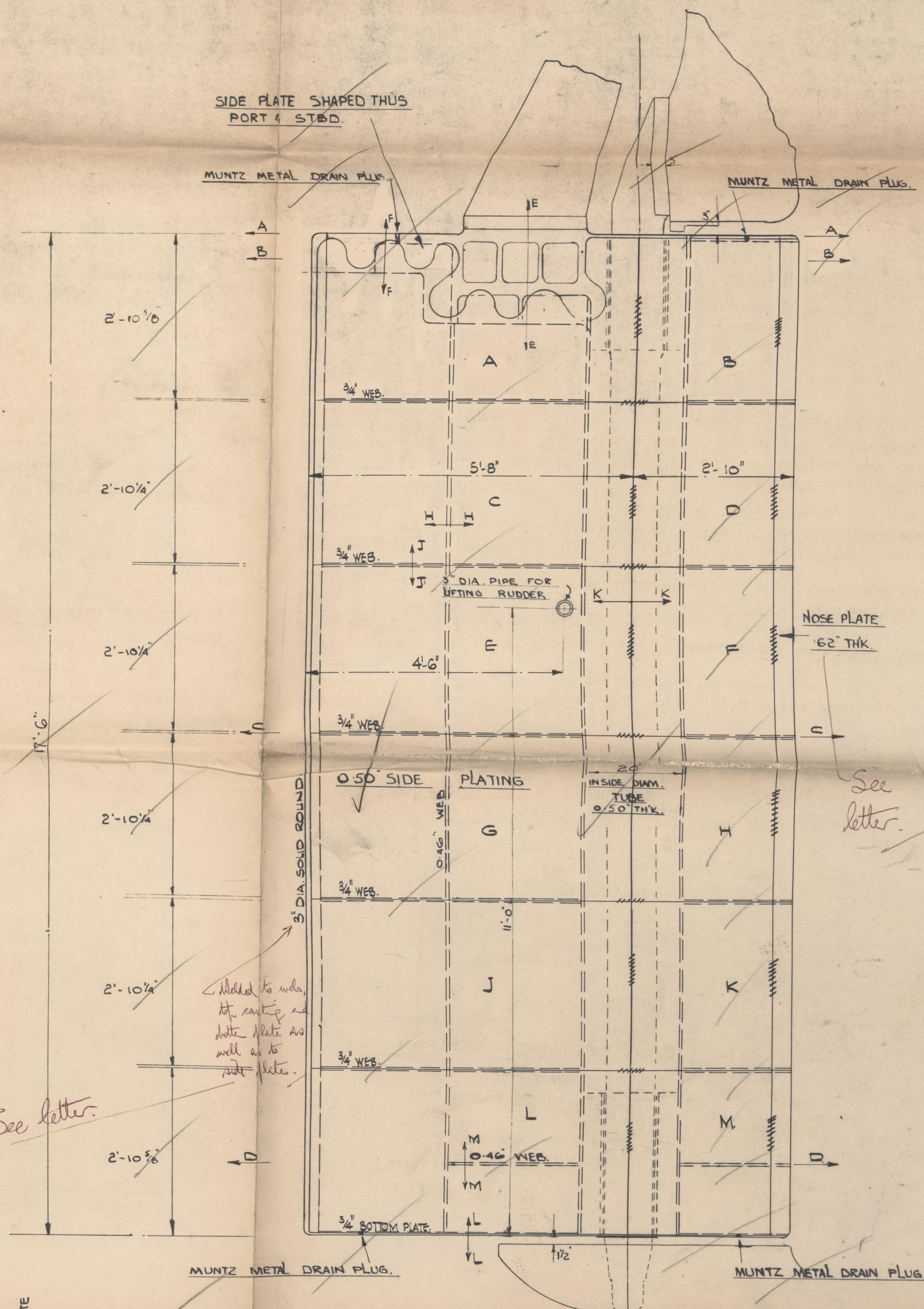
SIDE PLATE BUTT WELD.  
TYPICAL SECTION K-K'



DETAIL OF HORIZ<sup>l</sup> WELDS  
IN SIDE PLATES.  
TYPICAL SECTION J-J



RUDDER OFFSETS (TO OUTSIDE OF PLATING)



SECTION M-M'

VEED FOR WELD ON LOWER SIDE ONLY. WELDED BEFORE BOTTOM PLATE IS FITTED.

Office - *Alford*

REGISTER OF  
SHIPPING  
- 4 APR 1960



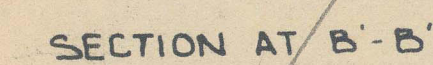
PLAN № 6.

A circular purple ink stamp. The outer ring contains the text "BARTRAM &amp; SONS LIMITED" at the top and "SUNDERLAND" at the bottom. The inner circle contains the text "DRAWING OFFICE" at the top, "DATE 5 MAR 1960" in the middle, and "No. D29" at the bottom.

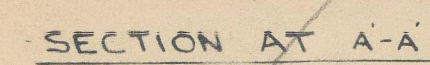
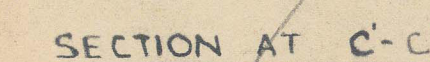
1. WELD TUBE, BEARING BLOCKS, HORIZONTAL WEBS, VERTICAL WEB,  
S DIA. ROUND AND TOP ARM INTO POSITION.  
(NOTE - BOTTOM PLATE OMITTED).
2. WELD PANELS 'A' & 'C' TO PORT SIDE OF RUDDER.
3. TURN RUDDER OVER AND WELD PANEL 'A' IN POSITION  
ON STBD. SIDE, FOLLOWED BY C, E, G & J.
4. TURN RUDDER OVER AND WELD PANEL 'E' IN POSITION ON  
PORT SIDE FOLLOWED BY G, J & L.
5. TURN RUDDER OVER AND WELD PANEL 'I' IN POSITION ON STBD.
6. WELD PANELS B, D, F, H, K & M IN POSITION ON STBD. SIDE.  
TURN RUDDER OVER & WELD PANELS B, D, F, H, E, K IN POSITION  
ON PORT SIDE.
7. WELD NOSE PLATE IN POSITION.
8. FINALLY WELD BOTTOM PLATE IN POSITION.

POSITION  
PLATE IN POSITION.

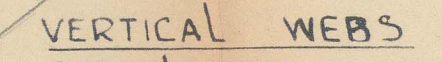
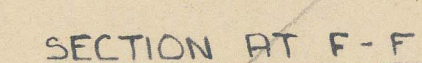
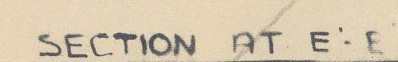
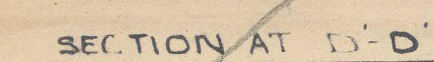
Not applicable in first case  
where existing mounds to be dissolved  
in breadth.



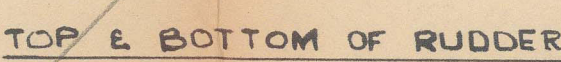
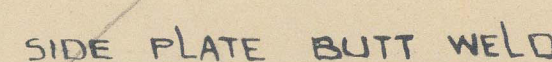
ARMS & BOSS CAST IN ONE  
PIECE. CARBON CONTENT NOT  
TO EXCEED 0.23%.



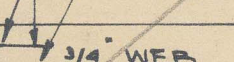
1/4" MUNTZ METAL  
DRAIN PLUG.



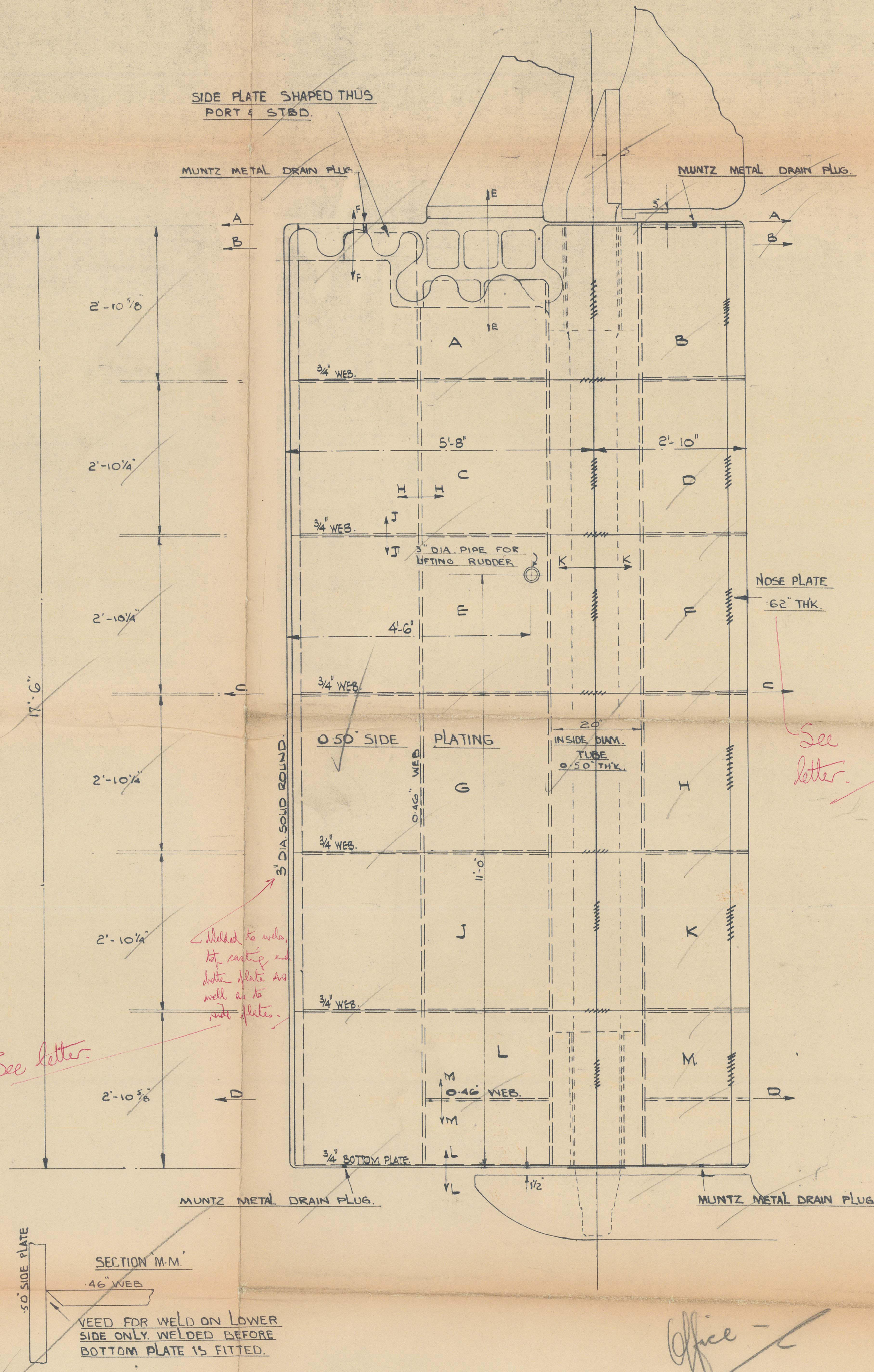
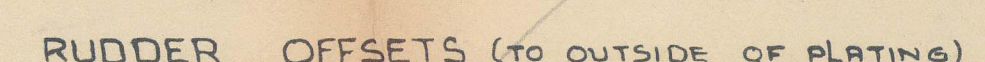
GAP AT ROOT SUFFICIENT TO  
ENSURE FULL PENETRATION



EDGE OF WEB SMOOTH FINISHED FOR  
GOOD BEARING FIT OF SIDE PLATES



DETAIL OF HORIZ<sup>L</sup> WELDS  
IN SIDE PLATES.  
TYPICAL SECTION J-J.



See  
letter

See letter.

Office - *Alfred*

REGISTER OF  
SHIPPING  
- 4 APR 1960



(S) **BARTRAM & SONS, LTD**  
**SHIP NO. 386**

*Reedder,*

*CONCORDIA LAEO*

*EX*

**MONTROSE**

**SLD RPT. NO A38**

**SHIP 386**



© 2021

Lloyd's Register  
Foundation