

SCALE: 1"=1 FOOT & AS MARKED.

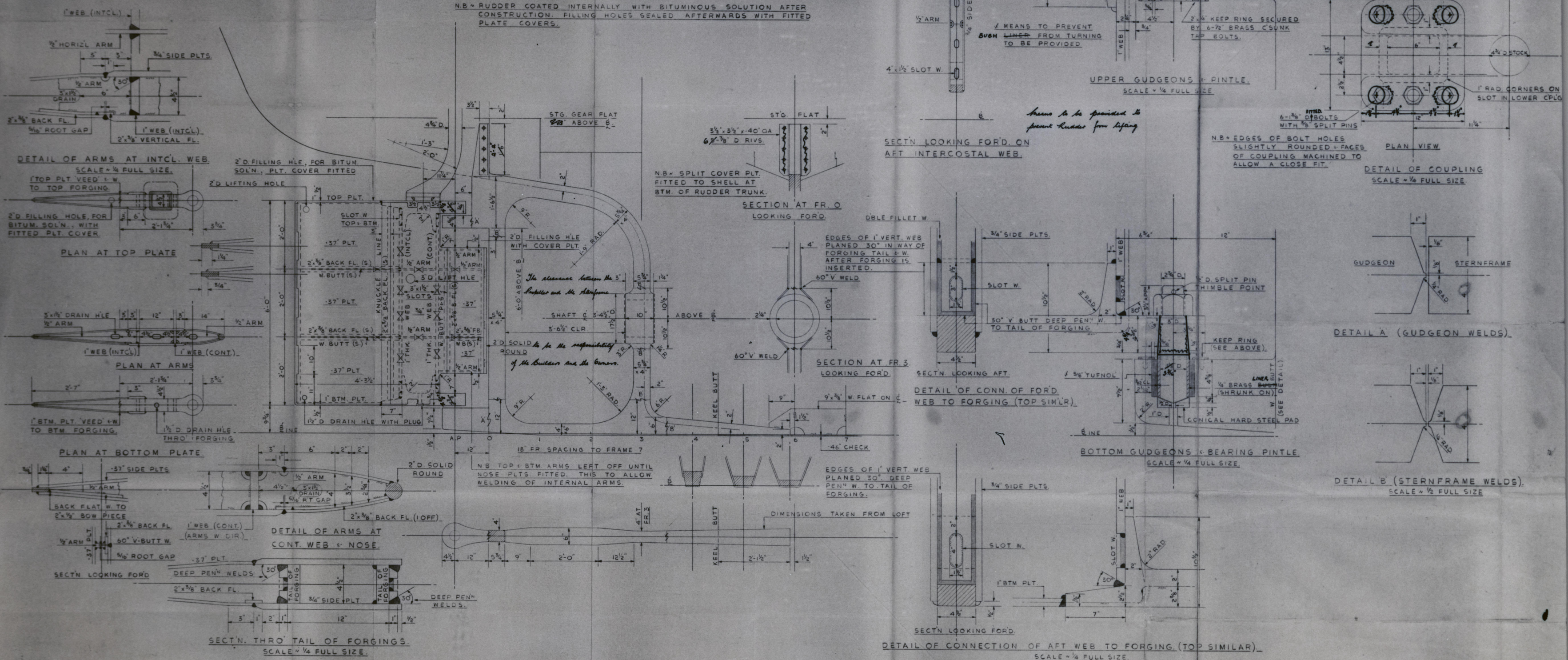
STERNFRAME TO BE FABRICATED FROM BEST MILD STEEL
BILLET IN ACCORD'CE WITH LLOYDS' REQUIREM'TS & TESTS



N4 PORT SIDE VERTICAL PLATE 1/2 DOWN - FORD 1/2 VERT WEB CONNECTED. W/ HORIZ. ARMS W. TO A PORT SIDE PLT. F.D. WEB 5/8 STD. 1/2 VERT. PLATE TO ARMS. FORD WEB TO BOTTOM FORDS. W/ INFL. PLAC. IN FORD BOX. 1/2 PERM. 1/2 OF FORD. WEB TO FORGING TAILS NOW COMPLETED. 1/2 VERT. WEB W. INTERCOSTALLY BETWEEN HORIZ. ARMS. CENTRE BOX PORTION NOW COMPLETE. FORD ARMS (EXCEPTING TO BTM ARMS) W/ FORD WEB. FORD 1/2 PORT SIDE PLATE. 1/2 VERT. PLATE WITH 5/8 D. SOLID ROUND. 5/8 D. NOSE PLATE ADDED IN SECTIONS E-W IN PLACE. TOP - BTM. FORD ARMS NOW CONNECTED. - 3/7 PORT SIDE PLATE CONNECTED TO ARMS ETC. 1/2 TOP - BTM. PLATES ADDED. 1/2 D. SOLID 1/2 IN. 5/8 D. IN PLACE. - 3/7 BTM. PLATES ADDED IN SECTIONS 1/2 WELDED.

CARE TO BE TAKEN TO AVOID UNDERCUTTING AT WELD BOUNDARIES
WELDS TO PENETRATE FULL THICKNESS OF MATERIALS.
PREHEATING TO ABOUT 200°C TO PRECEDE WELDING. WELDING TO
BE CARRIED OUT WITH LARGE ELECTRODES USING HIGHEST
CURRENTS SUITABLE TO SIZE & TYPE, & ONCE COMMENCED TO
PROCEED, WITHOUT INTERRUPTION, ON BOTH SIDES SIMULTANEOUSLY
TO MINIMISE DISTORTION, UNTIL COMPLETE WITHOUT ALLOWING WORK
TO COOL. FINISHED WELDS BLANKETED TO ENSURE SLOW COOLING.

N.B ~ RUDDER COATED INTERNALLY WITH BITUMINOUS SOLUTION AFTER CONSTRUCTION. FILLING HOLES SEALED AFTERWARDS WITH FITTED PLATE COVERS.



APPROVED
LLOYD'S REGISTER OF SHIPPING
W. T. B.
Date 3/12/10