

17/9/24

BOILER ORDER N° 347.B-352.B

DONKEY BOILER FOR 862 c.- 875

SIR W.G. ARMSTRONG WHITWORTH & COY. LTD. SHIP N° 1010- 1036

TO BE CONSTRUCTED TO PASS LLOYDS REQUIREMENTS
AND HAMBURG POLICE AUTHORITIES

ONE OFF.

SCALE 1" TO 1'-0"

BOILER TO BURN EITHER COAL OR OIL FUEL UNDER NATURAL DRAUGHT.

30/3/1925.
1.

PLATE = 81.4%
RIVET = 85.2%

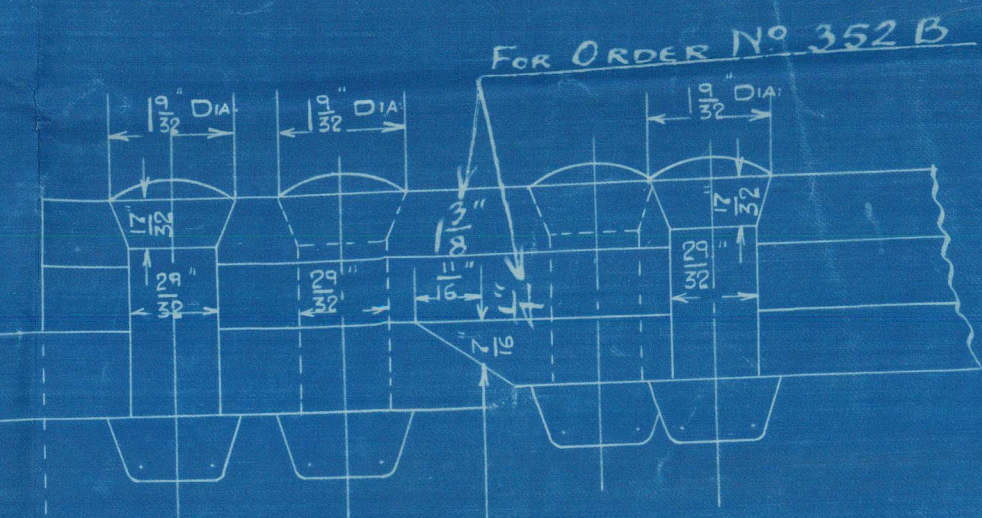
HEATING SURFACE.

TUBES	923	SQ. FEET.
FURNACES	111	"
COMBUSTION CHAMBERS	149	"
BACK TUBE PLATE	29	"
FRONT TUBE PLATE	23	"
TOTAL	1235	"

GRATE SURFACE 5'-0" FIREBARS 40 #

WORKING PRESSURE 120 LBS. PER Q.

TEST PRESSURE 230 LBS. PER Q.

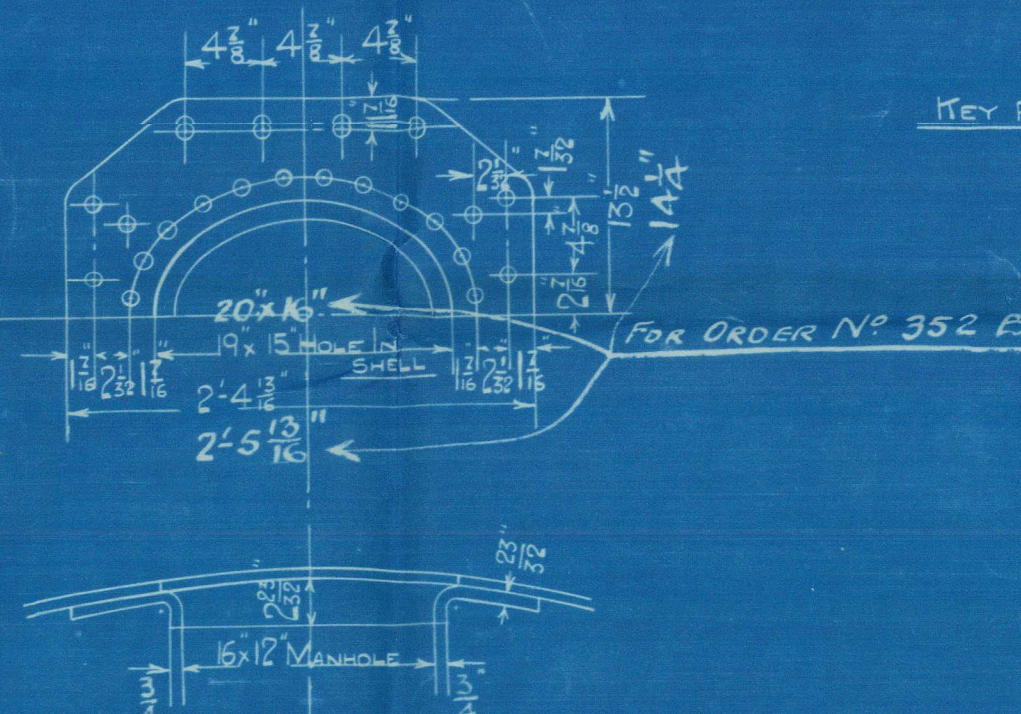


DETAIL OF SHELL RIVETING

MATERIALS.

	MATERIAL	TENSILE STRENGTH
SHELL PLATES & BUTT STRAPS	STEEL	28 TO 32 TONS Q.
C.C. GIRDER PLATES	"	28 TO 32 TONS Q.
WRAPPER & FLANGED PLATES	"	28 TO 32 TONS Q.
LONGITUDINAL STAYS	"	28 TO 32 TONS Q.
C.C. SCREWED STAYS & RIVET BARS	"	26 TO 30 TONS Q.
TUBES	IRON	

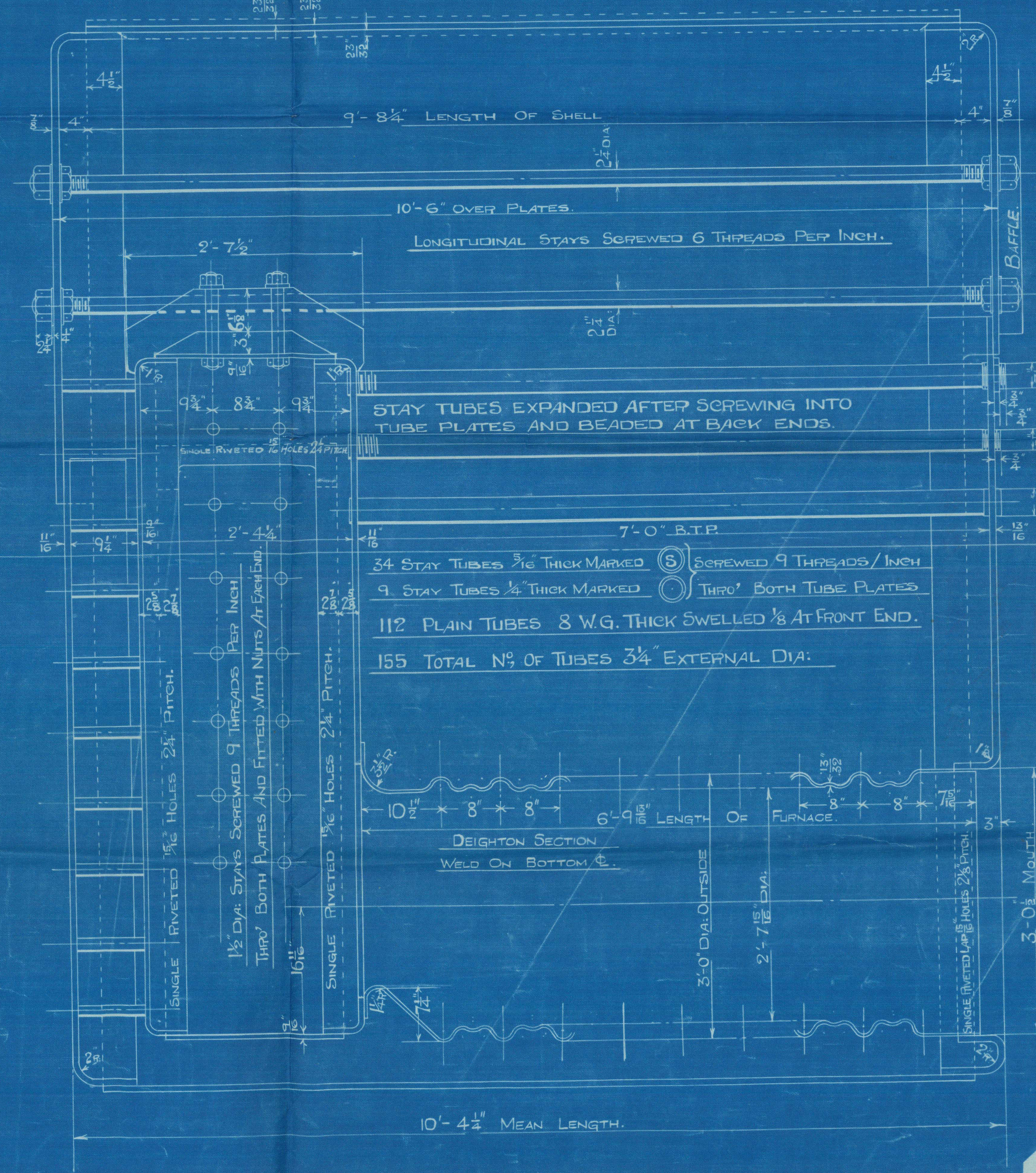
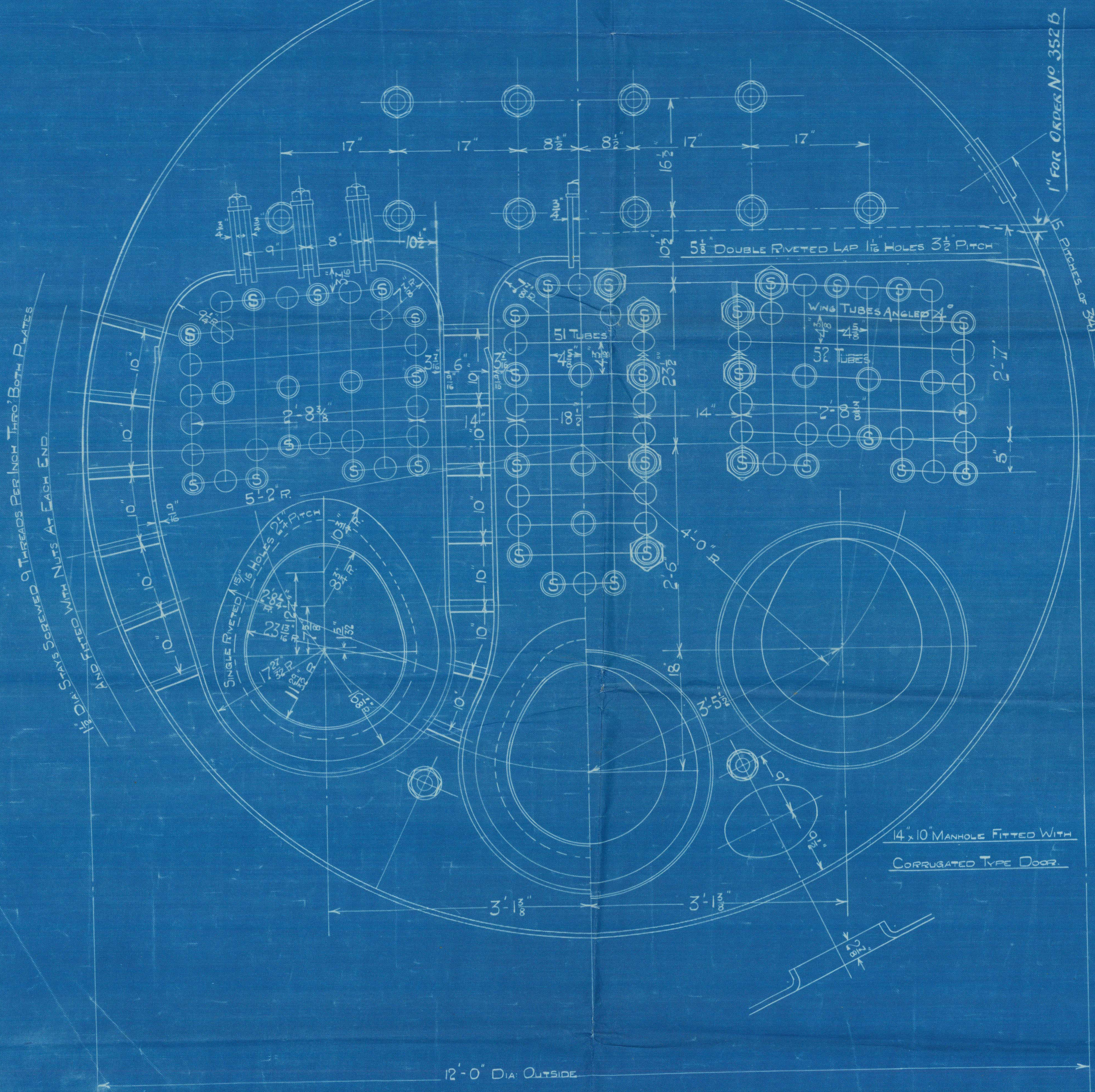
16" x 12" MANHOLE FITTED WITH
CORRUGATED TYPE DOOR.
DOUBLING SECURED TO SHELL
BY 44 RIVETS 3/8" DIA. HOLES.



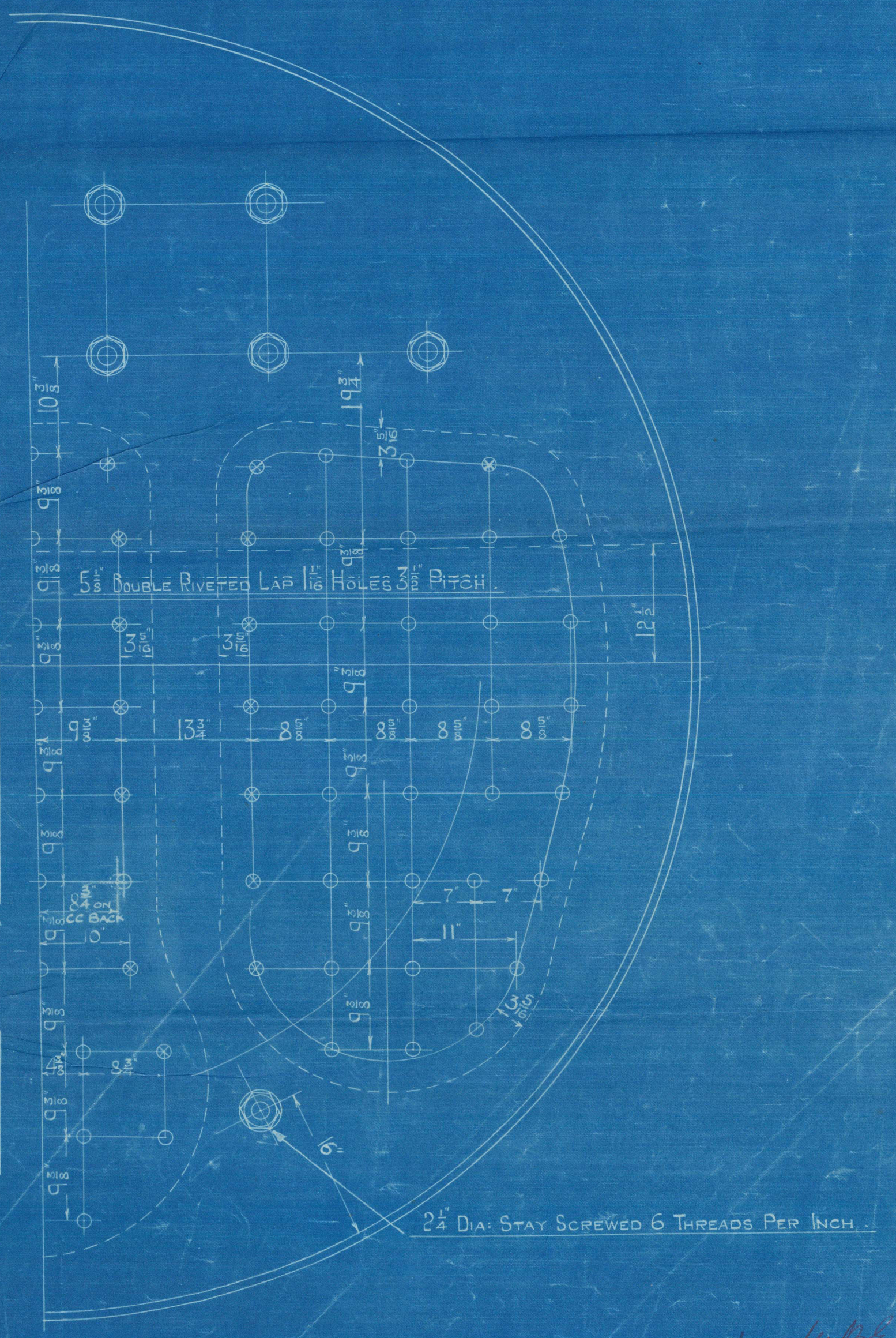
KEY PLAN SHOWING POSITION OF BUTT STRAP & MANHOLE.

SPARE GEAR
112 PLAIN TUBES
9 STAY TUBES WITH NUTS 3/8" THICK
3 STAY TUBES WITHOUT NUTS 3/8" THICK

SHELL HYDRAULIC RIVETED WHEREVER PRACTICABLE.
ALL HOLES DRILLED IN PLACE AFTER BENDING.
CIRCUMFERENTIAL SEAM DOUBLE RIVETED 3/8" DIA. HOLES.
132 PITCHES OF 3-4 1/2 MEASURED ON MEAN CIRCUMFERENCE.
PLATES TAKEN APART AFTER DRILLING THE BURRS
TAKEN OFF & HOLES SLIGHTLY COUNTERBORN.
NO DRIFTS TO BE USED.
ALL BEAMS FITTED METAL TO METAL AND HOLES
PAIRED BEFORE RIVETING.



1 1/2" DIA. STAYS MARKED (S) SCREWED 9 THREADS PER INCH. TWO BOTH PLATES
1 1/2" DIA. STAYS (O) AND FITTED WITH NUTS AT EACH END.



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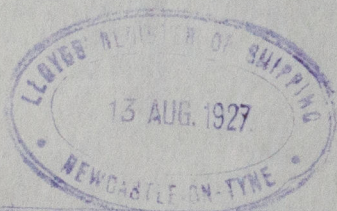
Walls & Shipway & Co. Ltd.

Contract No 862. 48 1/5

Armstrong & Co. Ltd. 11. 10. 1926.

Donkey Boiler

Working Press 120 lbs.



S. S. "Caspia"

NEWCASTLE ON TYNE.

Report No. 83200.

RETAIN



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Lloyd's Register
Foundation

W1125-0017 1/2

WALLSEND SLIPWA
Enclosure to Lloyd
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