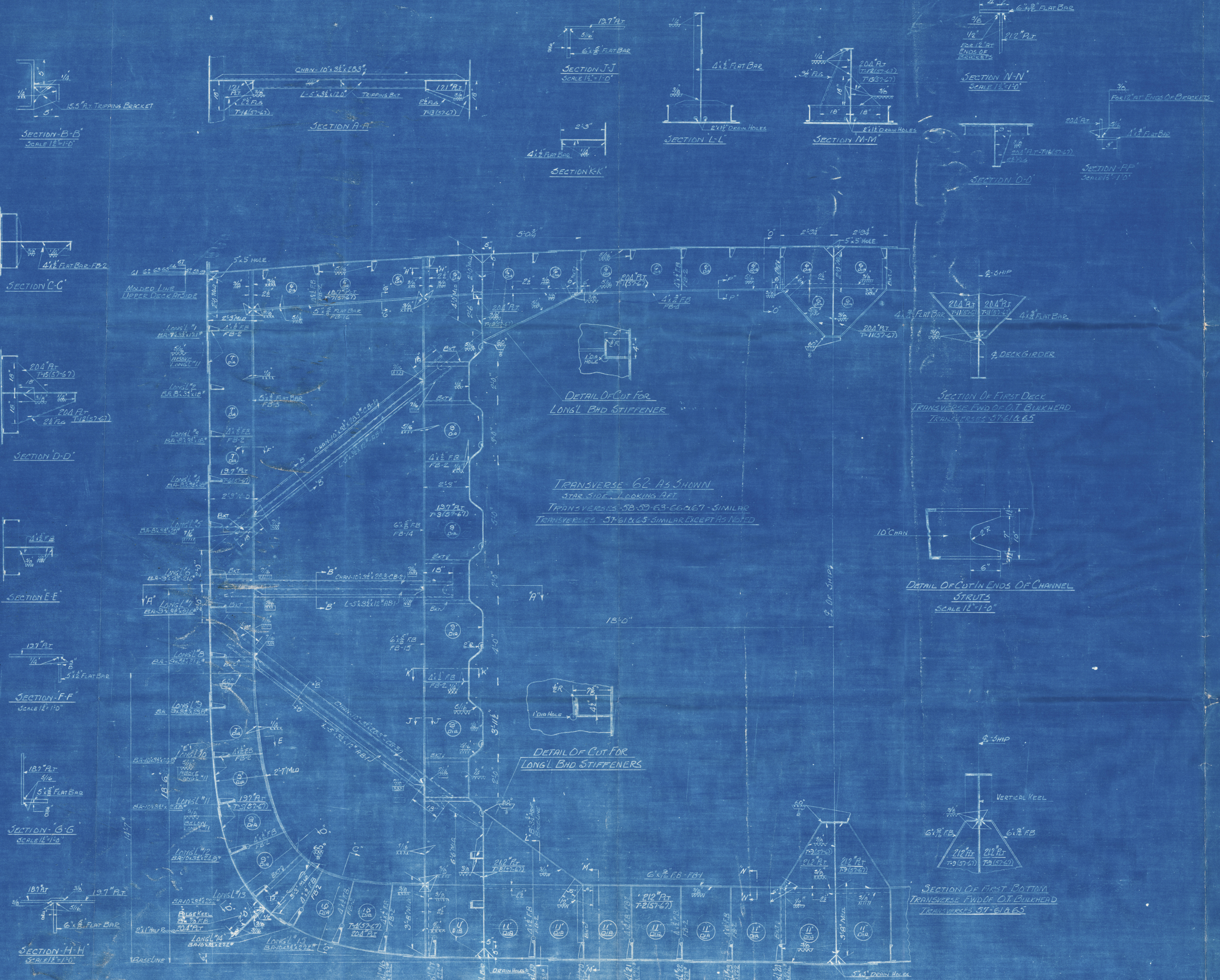


ALTERATION			
No.	DESCRIPTION	DATE	MADE BY



WELDING SYMBOLS			
No.	LOCATION	CONTINUOUS FILLET WELDS	INTERMITTENT WELDS
1	NEER SIDE	1/4"	1/4" 8"-10"
2	FAR SIDE	1/4"	1/4" 8"-10"
3	FOOTHOLDS	1/4"	1/4" 8"-10"
4	WELD ALL AROUND	1/4"	
5	SIZE OF FILLET WELD IS NOMINAL 1/4TH OF LEG		
6	INTERMITTENT SYMBOLS GIVE SIZE LENGTH & NO. OF INCREMENTS THUS		
7	V-BUTT WELD - INCLUDED ANGLE OF BEVEL OPENING AT ROOT & LOCATION OF REINFORCEMENT & BEVEL INDICATED THUS		
8	METAL ARC WELDING - USE COVERED ELECTRODES		
9	ALL REINFORCEMENTS OF BUTT WELDS TO BE 25% OF PLATE THICKNESS, UNLESS OTHERWISE STATED		

- # GENERAL NOTES #
1. ALL SURFACES TO BE WELDED MUST HAVE ALL SCALE, RUST & GREASE THOROUGHLY REMOVED PRIOR TO WELDING.
 2. MEMBERS TO BE WELDED ARE TO BE SNUGLY FITTED METAL TO METAL BEFORE WELDING.
 3. THE PAINTING SURFACES OF WELDED LAP JOINTS ARE NOT TO BE PAINTED.
 4. WHERE WELDING IS CLOSE TO RIVETING - THE WELDING IS TO BE DONE BEFORE RIVETS ARE DRIVEN.
 5. WELDS ON MATERIAL 3/8" THICK OR LESS MAY BE MADE IN ONE LAYER PROVIDED BUCKLING & LOCKED STRESSES ARE AVOIDED. WHERE MULTIPLE LAYERS ARE DEPOSITED EACH LAYER MUST BE CLEANED BY WIRE BRUSH BEFORE THE DEPOSITION OF ANOTHER LAYER.

MATERIAL ORDERED -
PLATES - SHEET 2
SHAPES - SHEETS 1, 4, 5

"R.W. GALLAGHER"
Drawing Baltimore Report # 6600
CHARGE ED-545 JOB No 122

H-4306-12-5
BETHLEHEM SHIPBUILDING CORP., LTD.
FAIRPORT, POINT, MD.
TRANSVERSES 57-67
SCALE 1/2"=1'-0" DATE SEPT 24-1936
DRAWN R. STEWART APPROVED
TRACED " APPROVED
CHECKED C.S. APPROVED

APPROVED - AMERICAN BUREAU OF STANDARDS OIL CO. N.Y. SEPT. 21ST 1936 OCT. 14TH 1936

GROUP 1

MATERIAL ORDERED -

PLATES _____ SHEET 2

SHAPES _____ SHEETS 1, 4, 5

"R. W. GALLAGHER"

Baltimore Report # 6600

CHARGE ED-545 JOB No 122

H-4306-12-5

BETHLEHEM SHIPBUILDING CORP., LTD.

SPARROWS POINT, MD.

TRANSVERSES 57-67

SCALE $\frac{1}{2}" \& \frac{1}{2}" = 1'-0"$

DATE SEPT 24-1936

DRAWN R. STEWART APPROVED

TRACED

"

APPROVED

96

CHECKED C.S.

APPROVED

SEPT. 26TH 1936
OCT. 14TH 1936

W155-0118

Lloyd's Register

		WELDS	
1	NEAR SIDE	XXXX	1/4"-3"-10" XXXX
2	FAR SIDE	1/4" TTTTT	1/4"-3"-10" TTTTT