

S. S. FORT McLEOD

WELDING NOTES

FLAT KEEL WELD BUTTS FROM INSIDE (WELD IN WAY OF C.V.K. BARS AND SEAMS ONLY). DO NOT COMPLETE WELD UNTIL C.V.K. AND GARBBOARD STRAKES ARE BOLTED UP.

C.V. KEEL WILL COME RIVETED COMPLETE EXCEPT IN WAY OF BUTTS OF PLATING. SHORT BARS APPROX. 15" x 30" LONG TO BE INTRODUCED HERE AND FITTED AFTER C.V.K. IS IN PLACE AND BUTTS WELDED.

BOTTOM SHELL PLATING

WELD 3" EACH SIDE OF BUTT. ON SEAMS (BOTH INSIDE AND OUTSIDE)

ALL BUTTS OF BOTTOM SHELL TO BE VEEED OUT AND WELDED FROM THE INSIDE. THIS IS DONE TO OBTAIN DOWN HAND WELDING TO THE FULLEST EXTENT.

BUTTS OF INSIDE STRAKES WILL BE VEEED OUT FULL WIDTH. THE BUTTS OF OUTSIDE STRAKES TO BE VEEED INSIDE AND WELDED BETWEEN THE LANDING EDGES OF INSIDE STRAKES ONLY. THIS WELD WILL BE COMPLETED BY VEEING OUTSIDE ON THE SHIP AND WELDING BOTH SEAMS. THESE TO BE VEEED OUT 1" WIDER THAN LANDINGS.

INSIDE STRAKES TO BE VEEED OUT AND WELDED FROM THE INSIDE. OUTSIDE STRAKES TO BE VEEED OUT AND WELDED FROM THE OUTSIDE.

THIS IS A CLINKER STRAKE. THE BUTTS TO BE VEEED AND WELDED FROM OUTSIDE, AND LOWER EDGE WHICH IS INSIDE IS TO BE FINISHED IN THE SAME MANNER AS OUTSIDE PLATES, THAT IS, VEEED 1" WIDER THAN LANDING AND WELDED FROM INSIDE. NOTE: ALL SHELL LANDINGS TOP AND BOTTOM FOR 3" EACH SIDE OF SHELL BUTTS TO BE WELDED.

ALL TANK TOP PLATING SEAMS AND FLOOR ANGLES TO BE RIVETED. ALL BUTTS TO BE WELDED FROM TOP SIDE. TANK TOP SEAMS TO BE WELDED FOR 3" EACH SIDE OF BUTT. SHAFT TUNNEL PLATING TO BE FILLET WELDED TO TANK TOP SIMILAR TO BHDS. NO FOUNDATION BARS TO BE FITTED. PLATING TO HAVE SAME PROCEDURE AS TANK TOP.

TOP AND BOTTOM ANGLES TO BE LINERED. ENDS OF BOTH BARS NEXT CENTRE KEEL TO BE CUT 1/2" SHORT OF TOL OF CENTRE KEEL TOP AND BOTTOM FORE AND AFT ANGLES. OUTER ENDS TO BE CUT 1/2" SHORT OF MARGIN PLATE. THESE BARS TO BE ELECTRIC WELDED TO FLOOR PLATE WITH HEELS PROTECTING 1/2" OVER EDGE OF FLOOR PLATE FOR THAT PURPOSE. NO COLLARS TO BE FITTED ON EITHER ENDS OF FLOOR PLATE. THE ENDS OF FLOOR PLATES ARE TO BE FITTED NEATLY TO BUTT AGAINST CENTRE KEEL AND TANK MARGIN FOR FILLET WELDING. PLUG WELDS ABOUT 18" APART TO BE MADE THROUGH FLOOR PLATE FLANGE OF TOP AND BOTTOM BARS. TOP AND BOTTOM FLOOR ANGLES TO BE RIVETED TO TANK TOP AND SHELL RESPECTIVELY.

FLANGED ON TOP AND LAP RIVETED TO TANK TOP PLATING. BOTTOM EDGE TO BE BUTTED ON SHELL PLATE AND FILLET WELDED INSIDE AND OUTSIDE. THE ORDINARY FLOORS AS WELL AS W.T. FLOORS WILL BE WELDED TO THIS PLATE INSIDE AND BILGE BRACKETS WELDED ON OUTSIDE. NO ANGLE CONNECTIONS WILL BE FITTED ON EITHER SIDE OF TANK MARGIN PLATE. ALL BUTTS OF TANK MARGIN PLATES WELDED FROM OUTSIDE, WITH FINISHING BEAD INSIDE TO BE ALL RIVETED EXCEPT IN WAY OF TANK TOP AND TANK MARGIN NO FOUNDATION ANGLE TO BE FITTED TO TANK TOP OR MARGIN BHD. PLATING AND STIFFENER BRACKETS BUTTED HARD ON TANK TOP AND TANK MARGIN AND FILLET WELDED. BULKHEAD SHELL BARS TO BE CARRIED DOWN BILGE AND STOPPED 1/2" SHORT OF MARGIN PLATE.

RIVETED TO FRAME AND BILGE ANGLE AND WELDED TO TANK MARGIN. GUSSET PLATE WELDED TO FLANGE OF BILGE BRACKET AND WELDED TO TANK TOP.

TO BE WELDED TO TANK TOP.

DOUBLE WITH GUILT RIVETS TO TANK TOP

INTERCOSTAL

STERN FRAME AS PER DETAIL PLAN

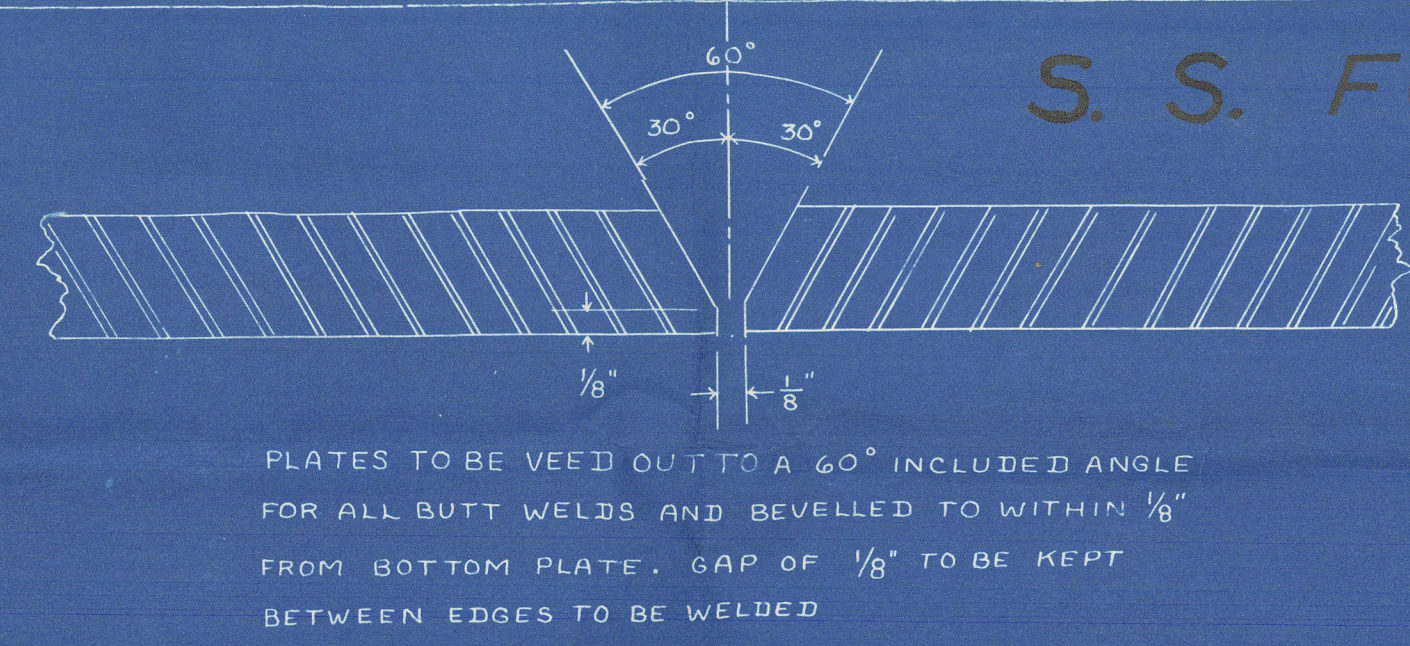
STEM BAR 10"x2 1/2" TO LWL.

PLATE STEM ABOVE LWL.

RUDDER AS PER DETAIL PLAN

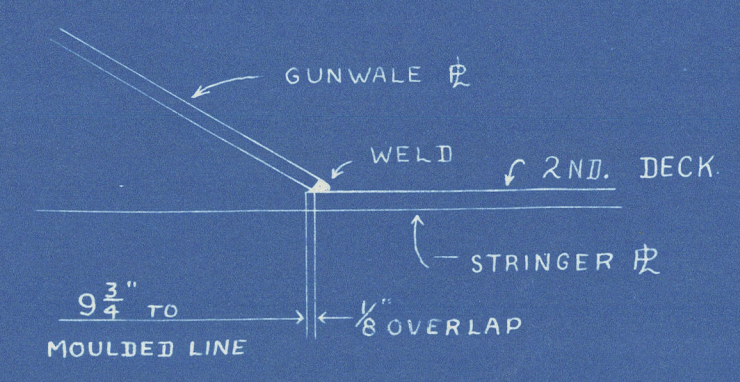
PRINCIPAL DIMENSIONS		
LENGTH B.P.	416'-0"	
BREADTH EXTR.	57'-1"	
BREADTH MLD.	56'-10 1/2"	
DEPTH MLD. UPPER DK.	37'-4"	
DEPTH MLD. SECOND DK.	28'-7"	
DEPTHS TO LENGTH-UPPER DK.	11.14	

NOTE: DO NOT USE LARGER ROD THAN 3/8" DIAMETER. NO RIVETING TO BE DONE UNTIL WELDING IS COMPLETED. BUTT WELDS IN ALL CASES TO HAVE A FINISHING BEAD. FIRST TWO BEADS IN BUTT WELDS TO BE WELL PEENED.

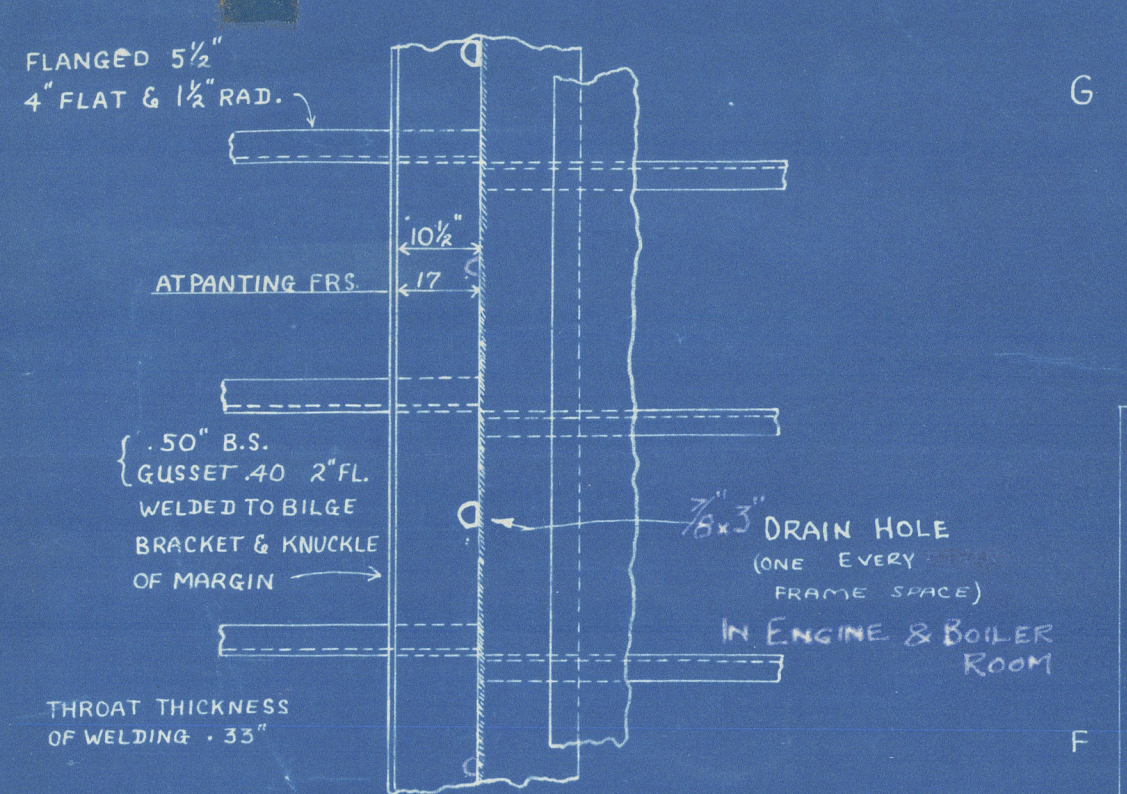
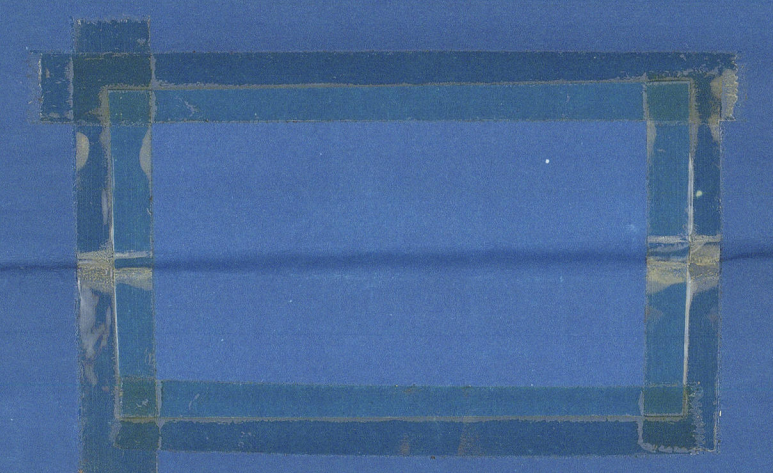


PLATES TO BE VEEED OUT TO A 60° INCLUDED ANGLE FOR ALL BUTT WELDS AND BEVELLED TO WITHIN 1/8" FROM BOTTOM PLATE. GAP OF 1/8" TO BE KEPT BETWEEN EDGES TO BE WELDED

SHEERSTRAKE .70" WITH TWEEN DK. FRAMES ON EVERY FRAME TO .45" AT ENDS STRAKE BELOW SHEERSTRAKE .61" TO .45" AT ENDS



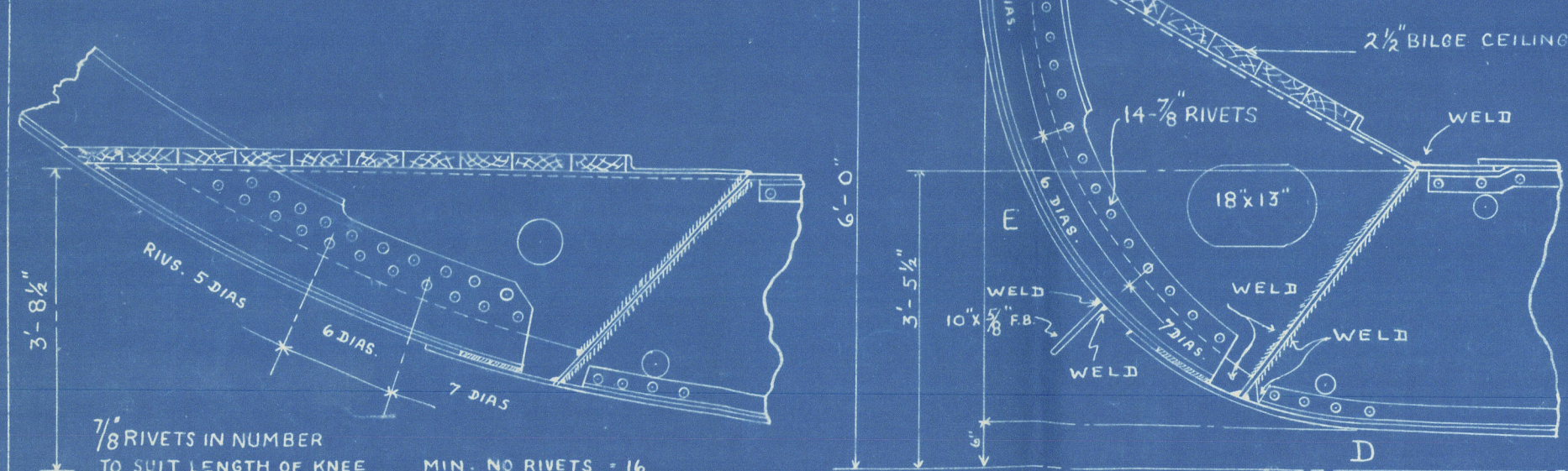
DETAIL AT "AA"



DETAIL OF TANK GUSSETS

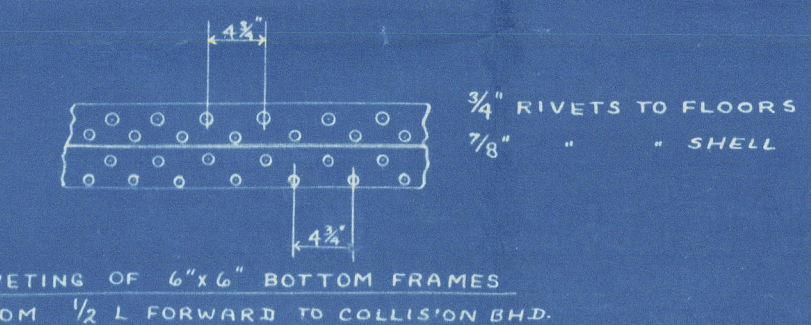
IN HOLDS FORD, ONE HOLE EVERY 6 FRAME SPACES

IN HOLDS AFT, ONE HOLE EVERY 3 FRAME SPACES

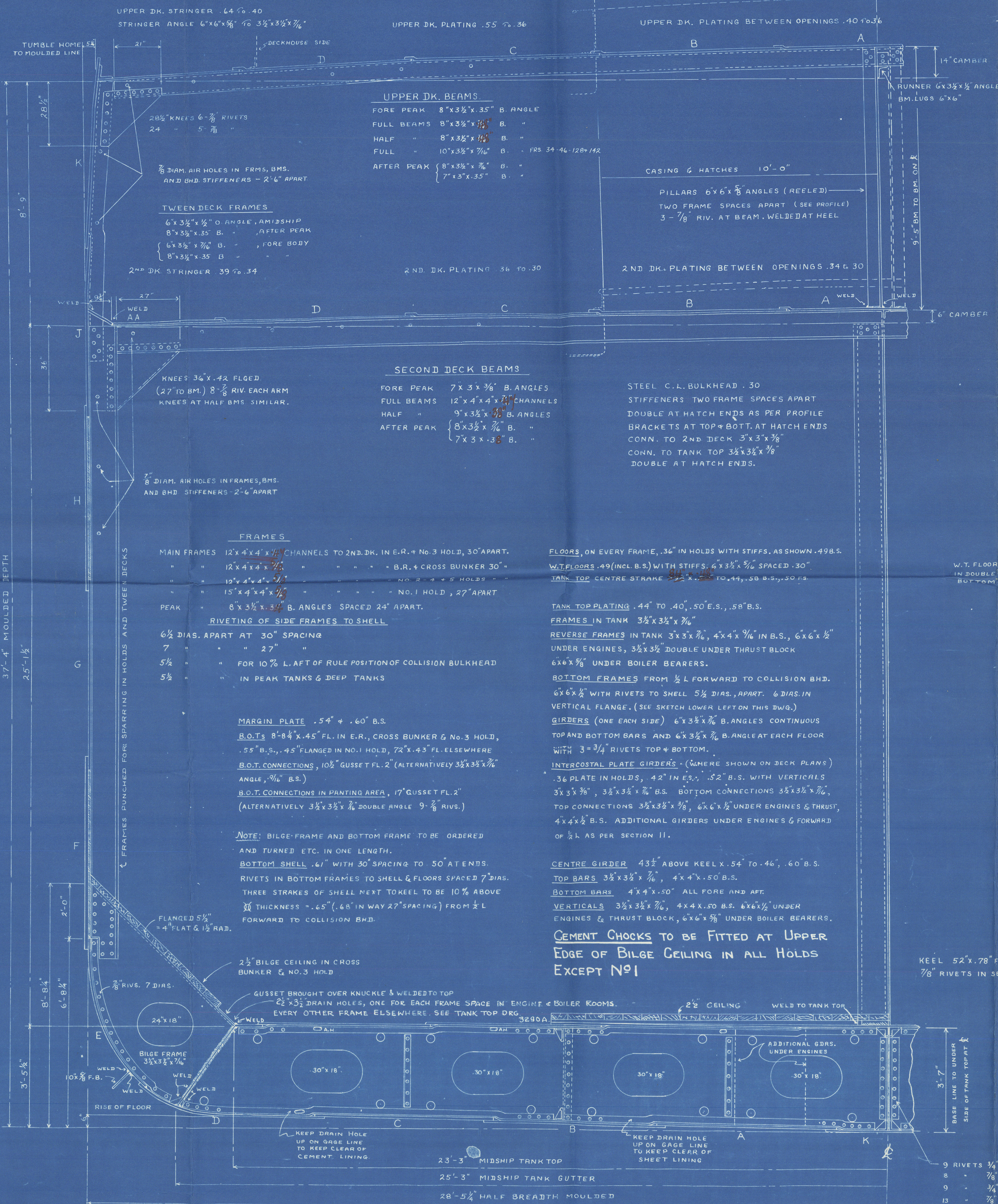


ARRGT. OF BILGE BRACKETS IN NO. 1 HOLD

DETAIL OF BILGE BRACKETS AFT OF FRAME 66 & FORD OF FRAME 106 (EXCEPT NO. 1 HOLD)



DETAIL OF DRAIN HOLES (SCALE 3" = 1'-0")



UPPER DK. BEAMS

FORE PEAK 8"x3 1/2"x.35" B. ANGLE

FULL BEAMS 8"x3 1/2"x.35" B. "

HALF " 8"x3 1/2"x.35" B. "

FULL " 10"x3 1/2"x.35" B. " FRS. 34-46-128-142

AFTER PEAK 8"x3 1/2"x.35" B. "

7"x5"x.35" B. "

SECOND DECK BEAMS

FORE PEAK 7"x3 1/2"x.35" B. ANGLES

FULL BEAMS 12"x4"x.45" CHANNELS

HALF " 9"x3 1/2"x.35" B. ANGLES

AFTER PEAK 8"x3 1/2"x.35" B. "

7"x3 1/2"x.35" B. "

STEEL C.L. BULKHEAD .30

STIFFENERS TWO FRAME SPACES APART

DOUBLE AT HATCH ENDS AS PER PROFILE

BRACKETS AT TOP & BOTTOM AT HATCH ENDS

CONN. TO 2ND DECK 3"x3 1/2"x.35"

CONN. TO TANK TOP 3 1/2"x3 1/2"x.35"

DOUBLE AT HATCH ENDS.

FLOORS, ON EVERY FRAME, .36" IN HOLDS WITH STIFFS, AS SHOWN .49 B.S.

W.T. FLOORS .49 (INCL. B.S.) WITH STIFFS, 6"x3 1/2"x.35" SPACED .30"

TANK TOP CENTRE STRAKE 3 1/2"x3 1/2"x.35" TO 141, .50 B.S., .50" IS

TANK TOP PLATING .44" TO .40", .50" E.S., .58" B.S.

FRAMES IN TANK 3 1/2"x3 1/2"x.35"

REVERSE FRAMES IN TANK 3 1/2"x3 1/2"x.35" IN B.S., 6"x6"x.35"

UNDER ENGINES, 3 1/2"x3 1/2"x.35" DOUBLE UNDER THRUST BLOCK

6"x6"x.35" UNDER BOILER BEARERS.

BOTTOM FRAMES FROM 1/2 L FORWARD TO COLLISION BHD.

6"x6"x.35" WITH RIVETS TO SHELL 5 1/2" DIAS., .30" APART. 6 DIAS. IN VERTICAL FLANGE. (SEE SKETCH LOWER LEFT ON THIS DWG.)

GIRDERS (ONE EACH SIDE) 6"x3 1/2"x.35" B. ANGLES CONTINUOUS

TOP AND BOTTOM BARS AND 6"x3 1/2"x.35" B. ANGLE AT EACH FLOOR

WITH 3 1/4" RIVETS TOP & BOTTOM.

INTERCOSTAL PLATE GIRDERS (WHERE SHOWN ON DECK PLANS)

.36" PLATE IN HOLDS, .42" IN E.S., .52" B.S. WITH VERTICALS

3 1/2"x3 1/2"x.35", 3 1/2"x3 1/2"x.35" B.S. BOTTOM CONNECTIONS 3 1/2"x3 1/2"x.35"

TOP CONNECTIONS 3 1/2"x3 1/2"x.35", 6"x6"x.35" UNDER ENGINES & THRUST, 4"x4"x.35" B.S. ADDITIONAL GIRDERS UNDER ENGINES & FORWARD OF 1/2 L AS PER SECTION 11.

CENTRE GIRDER 4 1/2" ABOVE KEEL .54" TO .46", .60" B.S.

TOP BARS 3 1/2"x3 1/2"x.35", 4"x4"x.50" B.S.

BOTTOM BARS 4"x4"x.50" ALL FORE AND AFT

VERTICALS 3 1/2"x3 1/2"x.35", 4"x4"x.50" B.S. 6"x6"x.35" UNDER ENGINES & THRUST BLOCK, 6"x6"x.35" UNDER BOILER BEARERS.

CEMENT CHOCKS TO BE FITTED AT UPPER EDGE OF BILGE CEILING IN ALL HOLDS EXCEPT NO. 1

KEEL 52"x.78" FOR 3/5 L TO .68" AT ENDS

7/8" RIVETS IN SEAMS AND FRAMES.

- EQUIPMENT
- 2 - BOWER ANCHORS - 68 CWTs.
 - 1 - STUD CABLE CHAIN - 225 FATHOMS 2 3/4"
 - 1 - STREAM ANCHOR (STOCKLESS) - 23 3/4 CWTs.
 - 1 - STREAM WIRE 90 FATHOMS 5" - 6x12 F.S.W.
 - 1 - TOWLINE 120 " 4 3/4" - 6x24 SPECIAL F.S.W.
 - 2 - HAWSERS 90 " 2 3/4" - 6x12 F.S.W.
 - 2 - WARPS 90 " 2 1/2" - 6x12 "

REVISIONS	
JULY 21/41	RE DRAIN HOLES
AUG 21/41	A DETAIL SHOWING W.T. FLOORS AT C.V. KEEL HAS BEEN ADDED (SEE BELOW AT LEFT) UPPER & SECOND DK. PLATING NOW JOGGLED INSTEAD OF TAPERED LINERS
JAN 15/42	1" E DRAIN HOLES - SEE NOTE
FEB 3/42	NOTE ADDED - RE-CEMENT CHOCKS

MIDSHIP HULL SECTION 67-55 Fort McLeod

YARROWS LTD. ESQUIMALT, B. C.

DATE 1/21/41

CHECKED

DRAWING NO. HB-7R

REGISTERED

Foundation

CLASS: 100 A.I. LLOYDS, WITH FREE BOARD CORRESPONDING TO A DRAFT 18" MORE THAN THAT OF A C.S.S. VESSEL

EQUIPMENT NUMERALS	
L (B + D)	39,189
MIDSHIP DECKHOUSE	30.25 x 7.5 x .50
CASINGS	20.5 x 7.5 x .50
"	59.75 x 10.5 x .50
AFTER DECKHOUSE	26 x 7.5 x .50
	39,798

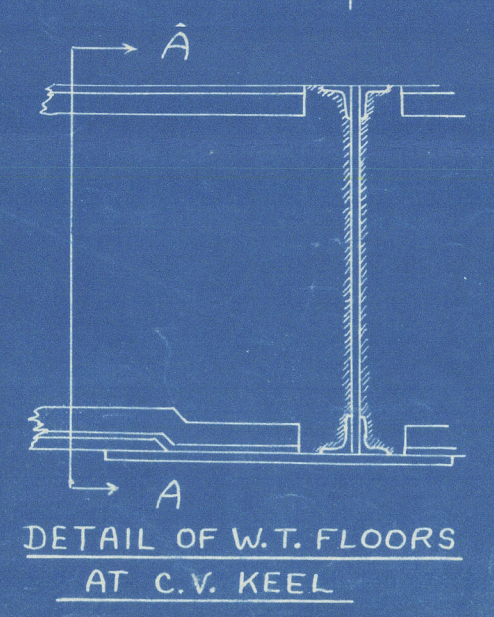
ISSUED

MAR 7 1942

BURGARD & CO. LTD.

WALL DEPOT

MODERN WAREHOUSE



DETAIL OF W.T. FLOORS AT C.V. KEEL

9 RIVETS 3/4" TO FLOORS

8 " 7/8" - CENTRE GDR. FOR 1/2 L

9 " 3/4" " " AT ENDS

13 " 7/8" " " 6 FLOORS IN 6'x6" ANGLES

REVISIONS

APR 21/42

W.T. FLOORS

ELIMINATED

SECTION A-A

WELDING FOR FLOORS WITH SINGLE TOP & BOT. BARS.

WELDING FOR FLOORS WITH DOUBLE TOP & BOT. BARS.

W1188-0159

S.S. "FORT McLEOD"

VARROWS LTD - HULL N° 67

MIDSHIP SECTION

VANCOUVER REPORT N° 5776.



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Lloyd's Register
Foundation

W1188-D159

Heel 67
Fort McLead
Midship Section

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VELDS
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TWO E
WELL

K. STR
R ANG

14" CAMBER
6" x 3 1/2" x 1/2" ANGLE
S 6" x 6"
8 1/2" KNEE
4 "

7/8 DIAM.
AND

TWEE
6" x 3 1/2"
8" x 3 1/2"
{ 6" x 3 1/2"
8" x 3 1/2"
K. STR

6" CAMBER
KNEES
(27" TO
KNEES

DIAM. AIR
D BHD S



© 2020
Lloyd's Register
MAIN F
" W.T. FLOOR
" IN DOUBLE