



INSTRUCTIONS :

- 1.TACK WELDS CAN BE MADE IN ANY POSITION WITH ANY PROCESS IN THE MOST LOGICAL SEQUENCE FOR STRUCTURAL SQUARENESS AND JOINT ACCESS.
- 2.ALL TACK WELDS ARE TO BE MADE SHORTER THAN 15 mm AND PLACED ON THE OUTSIDE OF THE VESSEL ONLY.
- 3.ALL WELDS ARE TO BE MADE AS INDICATED ON DRAWING.
- 4.ALL FILLET WELDS EXCEPT SPECIAL NOTES ARE TO BE 10 mm (+2mm/-0mm) IN LEG LENGTH.
- 5.COMPLETE ALL WELDING WITH BASE "A" IN THE FLAT POSITION.
- 6.GRINDING WILL BE LIMITED TO : TACK WELDS , STARTS , STOPS , ROOT PASS , FACE AND TOES.
- 7.POST CLEANING : WIRE BRUSH ONLY AFTER SLAG REMOVAL , NO GRINDING.