

PART 5

WELDING

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WELDING

Section 5.1 - General

- 5.1.1 Welding of structures and fabrications will generally be for mild steel and of either manual metal arc (MMA) or metal inert gas MIG/CO₂ types.
- 5.1.2 Proposed alternative methods of welding should be submitted for the consideration and approval of the Surveyor.
- 5.1.3 Details of the welding of main structural members are to be included for approval on structural drawings and should indicate the type and dimensions of weld. Alternatively, the Builder's standard welding table may be submitted for approval. Details are to be provided of the proposed sequence of fabrication and welding.
- 5.1.4 Welding operators should be qualified or coded to an approved standard and proficient for the type of work undertaken. A declaration to verify these competences shall be requested from the Builder. In addition the Surveyor may require the Builder to provide sample weld test pieces, fabricated under similar conditions to the proposed construction.
- 5.1.5 If there is, or considered to be, restricted access within the crossdeck structures on catamarans, then a full construction and weld method plan is to be submitted for review prior to construction.
- 5.1.6 All welding is to be carried out in accordance with the best practice. Full consideration should be given to the access of welds and their locations.
- 5.1.7 Where welds are not suitably detailed on drawings, symbols will be required, as shown in Section 5.7.
- 5.1.8 Care is to be taken when removing welded temporary fittings in order to avoid damage to the hull material. Bridges and dogs should not be hammered off. Tack welds, where utilised, should be of a quality equal to the finished weld.

Section 5.2 - Preparation

- 5.2.1 Generally, plate edges and weld preparations may be produced by any of the established methods. Plate edges are to be properly prepared, and a back sealing run is to be applied after suitable back seam gouging to all seams where the main welding is carried out from one side only. Plates are to be properly aligned and excessive force should not be used in fairing and closing. Where excessive gaps exist, the correction is to be to the Surveyor's approval.
- 5.2.2 Special care should be taken to ensure cleanliness of edges and faces prior to welding. All edges are to be cleaned free of oil, rust, paint, zinc coatings and other contaminants.

- 5.2.3 When welding components with large cross-sectional areas, the sections are to be pre and post-heated, to provide good weld fusion and prevention of cold cracking in the heat affected zones (HAZ).

Section 5.3 - Dimensions

- 5.3.1 The dimensions of fillet welds for structural connections are to be in accordance with Section 5.6. The length of intermittent welds is to be measured over the length of the correctly proportioned fillet. Intermittent welds are to be doubled at the ends and continued around ends of brackets etc.
- 5.3.2 At the design stage, consideration is to be given to the stress capabilities of the different types of welds.
- 5.3.3 Care must be taken to ensure thorough penetration and fusion. Finished welds should be sound, uniform, and free from slag inclusions, porosity, undercutting or other defects.
- 5.3.4 Plug and slot welds are not to be used except where access to both sides of a joint is not possible. Such plug welds are to be 75mm maximum length and spacing is to be in accordance with the requirements for intermittent welding as given in the Standards. Width of slot is not to be less than twice plate thickness and the ends of the slot are to be radiused.
- 5.3.5 Stiffening members which pass over an uncompleted weld are to be scalloped in way of same. Scallops are to have a minimum radius of 25mm.

Section 5.4 - Materials

- 5.4.1 Electrodes and filler wires should be stored under approved conditions to Manufacturer's requirements to avoid deterioration. Special consideration is to be given to the storage of low hydrogen electrodes.
- 5.4.2 All welding consumables are to be compliant with current BS EN ISO Standards (or equivalent).
- 5.4.3 The testing of welds is to be at the discretion of the Surveyor and will generally be of the non-destructive type. Visual inspections may be augmented by a system of radiograph, ultrasonic, magnetic particle, or dye penetrant examination. Welds which are found to be defective are to be cut out and re-welded to the satisfaction of the Surveyor, and subject to re-testing.

Section 5.5 - Aluminium

- 5.5.1 Aluminium should be welded by either the gas tungsten arc (TIG) or gas metal arc (MIG) or other approved processes. Generally the welding of connections shall be as for steel. Where chain or intermittent welding is employed, the minimum length of the length 'W' is to be not less than that required for steel measured clear of end craters.
- 5.5.2 Plate edges and weld preparations may be by either of the following methods:-
- (i) Plasma arc cutting;
 - (ii) Tungsten arc;
 - (iii) Mechanical means (saw or shear).
- 5.5.3 All weld edges are to be prepared smooth and free from cutting tool scores and moisture. Fusion faces of weld joints should be cleaned free of all foreign matter, i.e. grease, dirt, oxide film and moisture.
- 5.5.4 Where cutting by mechanical means are used, care is to be taken to ensure that the tools used are not contaminated by other metals. Plates may be sheared provided this does not cause distortion of the plate edges.
- 5.5.5 Operatives, material, and structures, should be protected at all times to effectively prevent draughts destroying the gas shield. All welds are to be made on clean dry surfaces and carried out under cover.

Section 5.6 - Welding details

5.6.1 Connections of structural members

Type of weld connection		
Plating- bottom shell	Bar keel, stem bar Centre girder to bar keel and floors Side girders and machinery seatings Floors in machinery spaces Floors, and girders in fuel, fresh water and ballast tanks Tank tops and ends Watertight and oil-tight bulkheads	Full strength fillet (continuous)
	Frames and floors outside machinery spaces	Staggered intermittent or chain
Plating- side shell	Frames Longitudinals Stringers Non watertight bulkheads	Staggered intermittent or chain
	Frames and stringers in fuel, fresh water and ballast tanks	Full strength fillet (continuous)
Plating- deck	Deck to shell plating Pillars Hatch coamings Bulwarks and stays to deck plating Beams and girders under machinery, bollards, masts and gallows Beams, girders and webs in fuel, fresh water and ballast tanks	Full strength fillet (continuous)
	Beams Longitudinals Deck girders	Staggered intermittent or chain

Note: All seams and butts in shell, deck, and weathertight deckhouses and superstructures are to be square butt or single vee butt, continuous welded both sides.

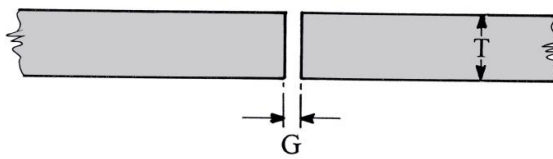
5.6.1 Connections of structural members (*continued*)

Type of weld connection - <i>continued</i>		
Bulkheads	Watertight and oil-tight bulkheads to shell plating Wash bulkheads to shell, bulkhead and deck plating Brackets on longitudinals Tank sides and ends, to bulkhead plating	Full strength fillet (continuous)
	Stiffeners	Staggered intermittent or chain
Side plating of engine room casings, deckhouses, wheelhouses and shelters	Side plating to deck Side plating to rail	Full strength fillet (continuous)
	Stiffeners	Staggered intermittent or chain
Steering compartments	All connecting bottom stiffening to rudder tables (including face flats), terminating at side girders or adjacent primary structure	Full strength fillet (continuous)

5.6.2 Details of weld connections

(i) *Square butt joint*

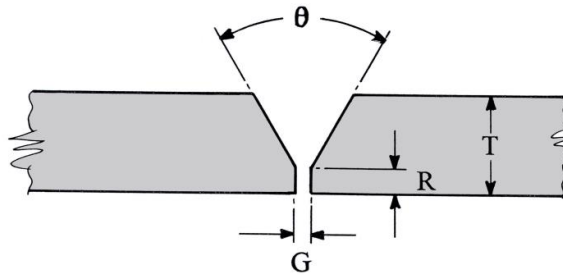
Recommended for use up to and including 6 mm plate - this method is economical in preparation and welding. A gap of more than that shown is not permitted



Up to 6 mm plate:

$$G = \frac{T}{2}$$

(ii) *Single V butt*



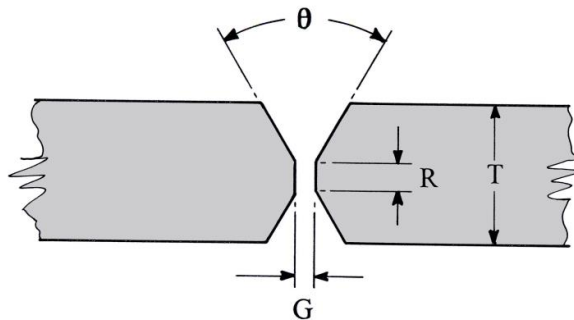
Over 6 mm up to 16 mm plate:

$$G = 0-3 \text{ mm}$$

$$R = 1.5 \text{ mm} - 3 \text{ mm}$$

$$\theta = 60^\circ - 70^\circ$$

(iii) *Double V butt*



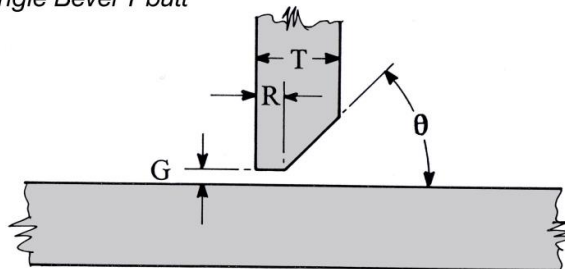
Over 16 mm plate:

$$G = 0-3 \text{ mm}$$

$$R = 1.5 \text{ mm} - 3 \text{ mm}$$

$$\theta = 60^\circ - 70^\circ$$

(iv) *Single Bevel T butt*



Over 6 mm up to 19 mm plate:

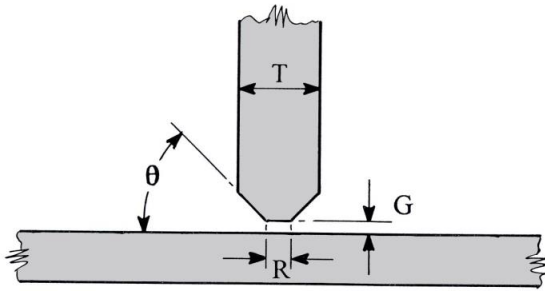
$$G = 0 - 1.5 \text{ mm}$$

$$R = 1.5 \text{ mm} - 3 \text{ mm}$$

$$\theta = 45^\circ \text{ minimum}$$

(v) *Double bevel T butt*

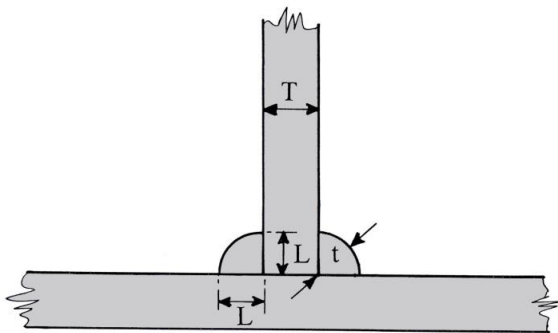
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Over 19 mm up to
38 mm plate:

$G = 0 - 1.5 \text{ mm}$
 $R = 0 - 5 \text{ mm}$
 $\theta = 45^\circ$

(vi) *Full strength (continuous) fillet weld*

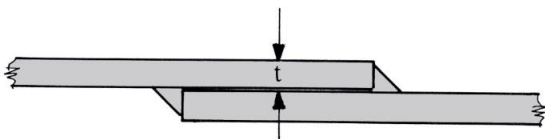


12.5 mm plate and above:

T = thickness of thinner part.
 L = leg length = $0.7T$ approx.
 t = throat thickness = $0.75L$ where plates are at right angles but is not to exceed $0.9L$.
For plates under 12.5 mm leg length is given in table 5.6.4.

(vii) *Fillet welded lap joint*
(Recommended only for work of minor structural importance)

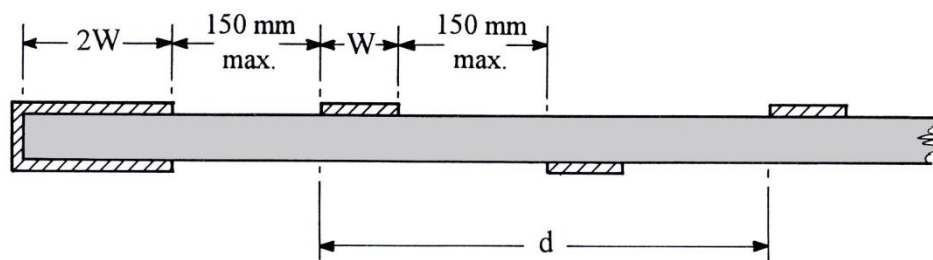
Length of overlap minimum $3t$
maximum $4t$



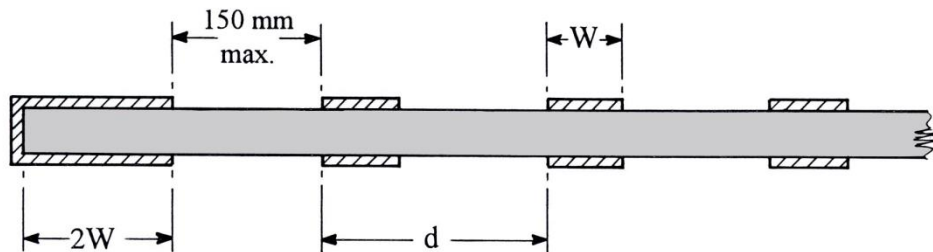
(viii) *Intermittent welds*

The minimum length of weld W is to be 10 x plate thickness or 75 mm whichever is the lesser. For values of 'd' in relation to W see Paragraph 5.6.3.

Staggered intermittent



Chain intermittent



Note:

Intermittent welds are to be doubled at the ends of all structural members and the welding to be carried round the ends.

5.6.3 Fillet welding

Maximum value of 'd' in relation to minimum 'W' values for staggered intermittent and chain intermittent welds.

Plate thickness in mm	Minimum 'W' length in mm	Maximum 'd' in mm	
		Staggered intermittent	Chain intermittent
3	30	360	180
4	40	380	190
5	50	400	200
6	60	420	210
7	70	440	220
8	75	450	225
↓	75	450	225
16	75	450	225

5.6.4 Dimensions of fillet welds for light plate

Plate thickness in mm	Weld type - double continuous leg length in mm
3	3.5
4	4
5	4.5
6	5
8	6
10	7

5.6.5 Throat thickness

(i) The minimum and maximum limits of throat thickness are to be as follows

(a) Intermittent (staggered or chain) fillets

Minimum throat thickness = 'T' x 0.25

Maximum throat thickness = 'T' x 0.45

(b) Double continuous fillets

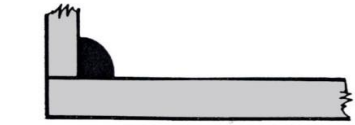

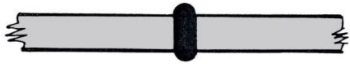



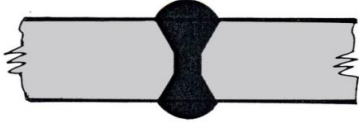

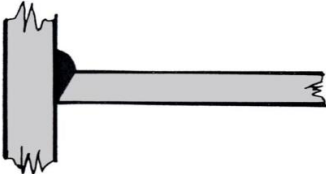

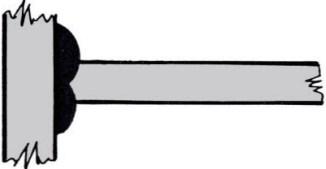

Minimum throat thickness = 'T' x 0.20

Maximum throat thickness = 'T' x 0.45

subject to a minimum throat thickness of 3mm for intermittent fillets, and a minimum of 2.5mm for continuous fillets;

(ii) 'T' = plate thickness of thinner member where this is less than 8mm. The minimum throat thickness of fillet welds for plates 8mm thickness and over is to be increased by 10% of the values shown above.

Section 5.7 - Symbols

FORM OF WELD	SECTION REPRESENTATION	SYMBOL
Fillet		
Square butt		
Single V butt		
Double V butt		
Single bevel butt		
Double bevel butt		
Sealing run	