INSTALLATION & WELDING RECOMMENDATIONS FOR D-RING LP-11 36 T

INSTALLATION INSTRUCTIONS

STEP 1: DECK LINES

THE SHIPYARD HAS DETERMINE THE TO INTERSECTING LINES RELATIVE TO THE CENTER LINE OF THE D-RING STRAP FOR PROPER LASHING ARRANGEMENT. (SEE "TOP VIEW" DRAWING)

STEP 2: POSITIONING

THE D-RING AND STRAP NEED TO BE POSITIONED OVER DECK LINES DESCRIBED IN STEP 1 ABOVE. (SEE "TOP VIEW" DRAWING)

STEP 3: SUPPORTS AND STIFFENERS

THE SHIPYARD NEEDS TO SUPPLY SUPPORTS, STIFFENERS, AND REINFORCING PLATES TO SUIT SHIP STRUCTURE WITH ADEQUATE INSTALLATION AND CONSTRUCTION TO SATISFY APPROPRIATE CLASSIFICATION SOCIETY REQUIREMENTS.

WELDING INSTRUCTIONS

STEP 4: PREPARATION

D-RING STRAP, DECK PLATES, AND BASE PLATES NEED TO BE PROPERLY PREPARED AND CLEANED BEFORE WELDING.

STEP 5: WELDING

WELD WITH 70,000 P.S.I. LOW HYDROGEN WELDING ROD EQUAL TO A.W.S. E7018. MOISTURE CONTENT TO BE CONTROLLED PER RECOMMENDED A.W.S. STORAGE AND RECONDITIONED PROCEDURES. WELDING SEQUENCE TO BE AS FOLLOWS:

- PLACE D-RIND AND STRAP IN POSITION PER INSTALLATION INSTRUCTIONS. ALWAYS PLACE D-RING AWAY FROM SIDE OF STRAP BEING WELDED.
- SHIM STRAP 2mm AND TACK WELD.
- WELD ALONG EDGES AND WRAP AROUND CORNERS.
- COMPLETE JOINT PENETRATION (CJP) WELDS.
- MINIMUM WELD THROAT HEIGHT T= 5mm

NOTE: D-RING TO SWING FREELY AFTER WELDING.

STEP 6: CLASSIFICATION SOCIETY APPROVAL

SHIPYARD TO OBTAIN APPROPRIATE CLASSIFICATION SOCIETY APPROVAL OF APPLIED WELDING PROCEDURE.

TOP VIEW (SEE STEPS 1-2)

SIDE VIEW (SEE STEPS 3-6)