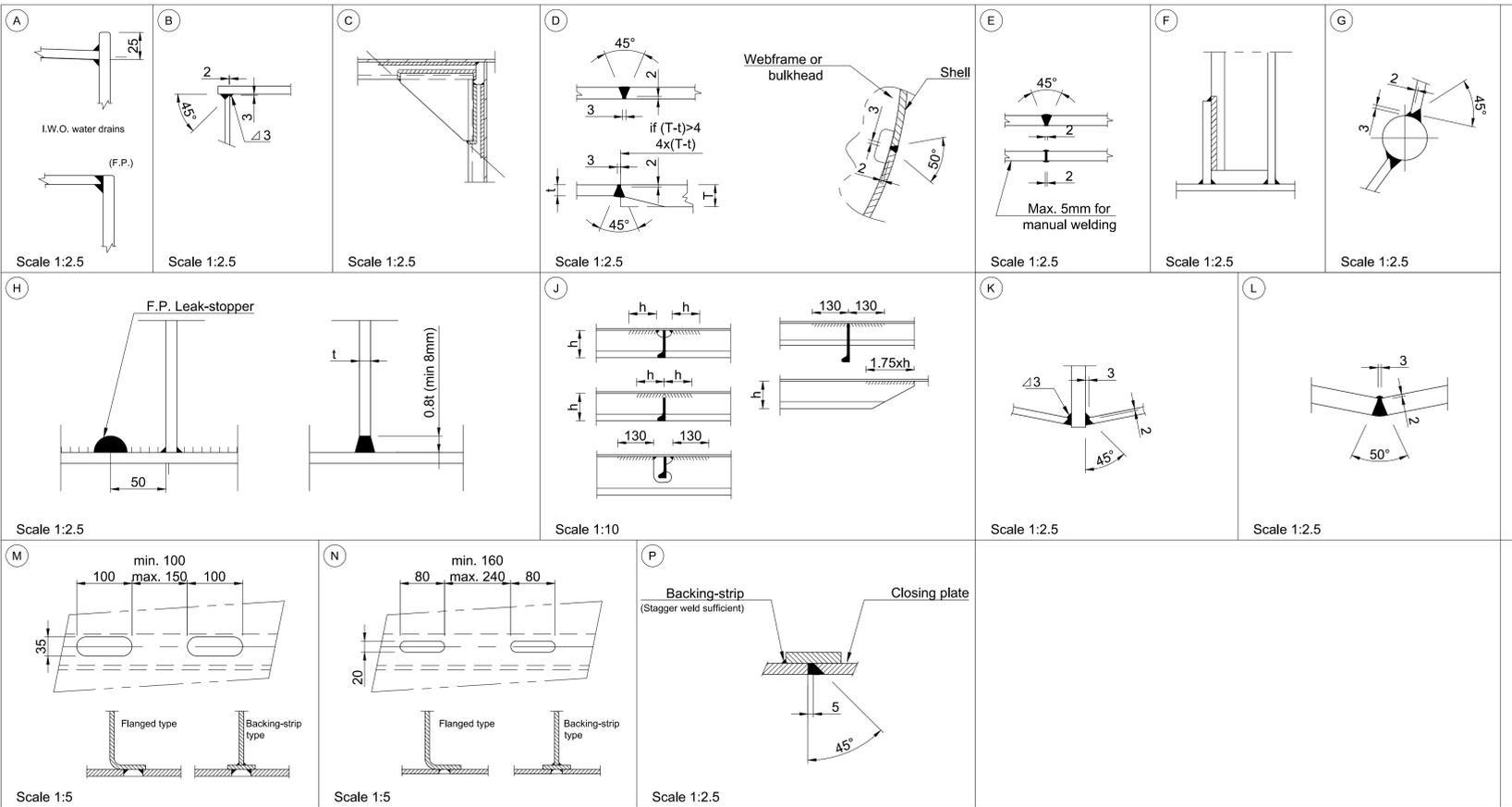
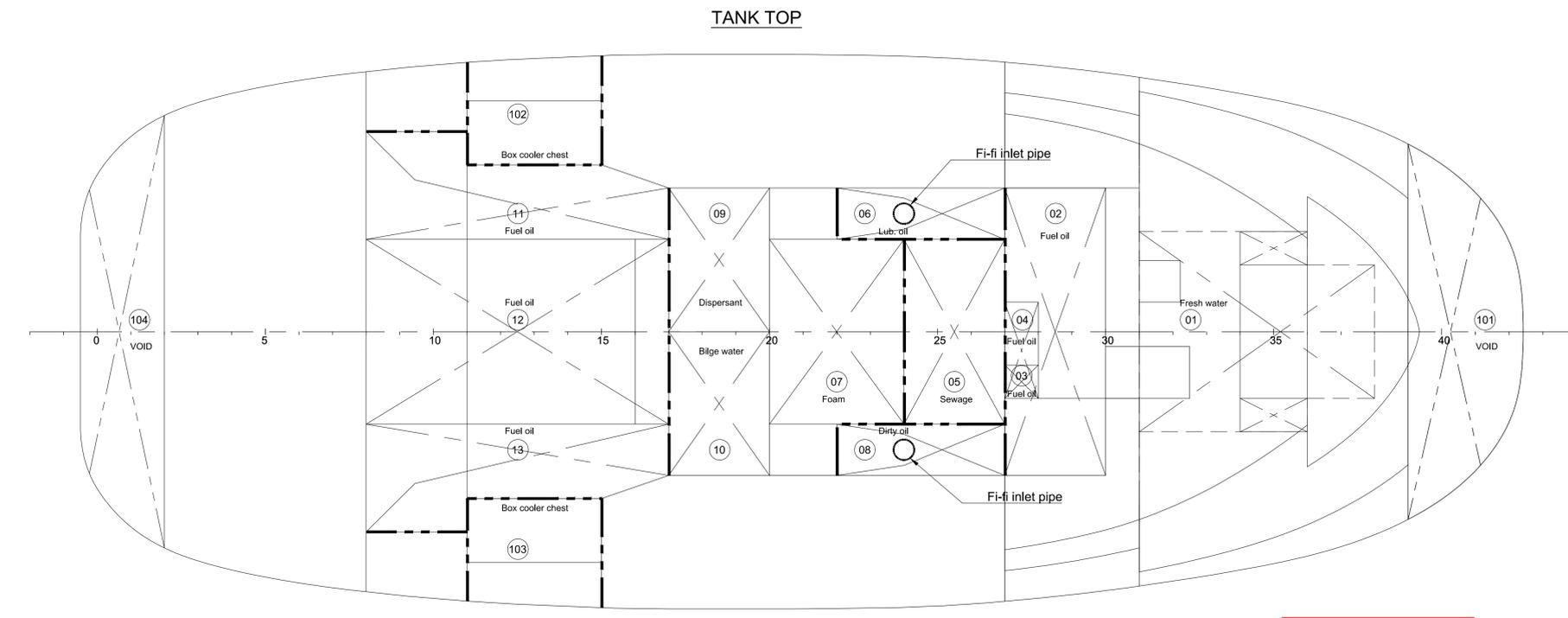
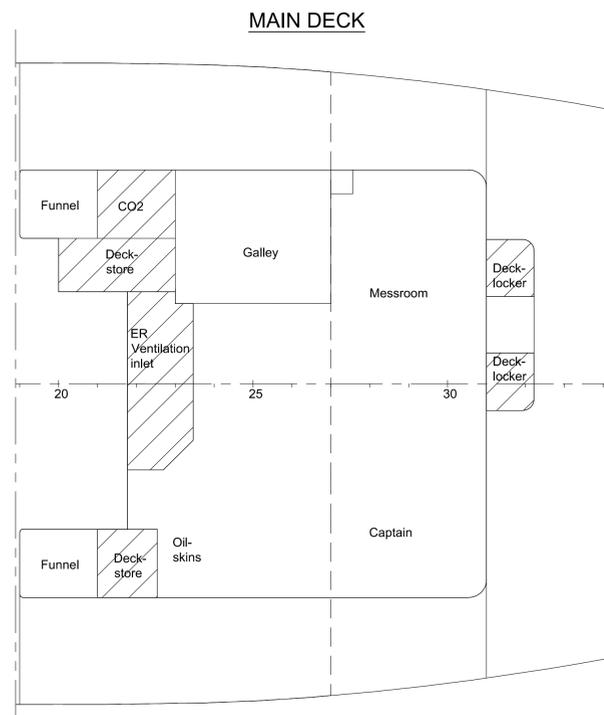


CONNECTIONS	WELDING CODE	DETAIL	Throat thickness	S/D
1	Bottom - and side plating	V	D	
2	Vertical jump up hullplating	V	D	
3	Buttwelding remainder	V	E	
4	Deck / side connection	I	A	4
5	Bottom / stembar-barkeel / center girder connection	V	K, L	
6	Tank- and W.T. bulkheads against deck and hull	I	H	3.5
7	Floors on hull- and bulkhead plating	I		3.5
8	Long girders on hull or barkeel	I		4.5
9	Flatbar on floors in E.R., steer.gear.r. and watertanks	I		3.5
10	Remaining flatbar on floors	III	J	4 75/225
11	Stiffeners on floors	I		3.5
12	Except: stiffeners in oiltanks	III	C, J	4 75/225
13	Long.girder engine foundation on bottomplating	I		4.5
14	Topplate on long.girder engine foundation	V	B	
15	Webframes on hull and deck	I		4.5
16	Longitudinal girders on deck	I		4
17	Flatbar on webframes and long.girders	III	J	4 75/225
18	Except: flatbar in E.R. and watertanks	I		3.5
19	Frames on hull (bottom and side)	III	C, J	3.5 75/225
20	Except: frames in E.R., steer.gear. r. and watertanks	I		3.5
21	Stiffeners on bulkheads	III	C, J	3.5 75/225
22	Except :stiffeners in E.R., steer.gear. r. and watertanks	I		3.5
23	Deck beams / longitudinals on deck	III	C, J	4 75/225
24	Except : deck long. in watertanks and i.w.o. winches	I		3.5
25	Bracket connections t < 8 mm	I	C	3.5
26	Bracket connections t = 8 - <10 mm	I		4
27	Bracket connections t =/< 10 mm	I		5
28	Buttwelding superstructure	V	E	
29	Deck - superstructure connection	I		3.5
30	Deck- walls (superstructure)	IV		3 75/225
31	Stiffeners and deckbeams (superstructure)	III	C, J	3.5 75/300
32	Stiffeners between windows in wheelhouse	I		3
33	Bulwark on deck / bulwark stiffeners	I		3.5
34	Floorstrips in deckhouse / accommodation	I	F	3.5
35	Exposed welding and wet spaces	I		3.5
36	Skeg plating	M		5
37	Bulwark plating	N		3,5
38	Pillars (tank top and deck connection)	I		6,0
39	Closing plates	I	P	
40	Knuckled frames ship types/ anchor pocket	I	G	



WELDING CODE	
I	2 Sides continuous welding
Chain welding - See also detail C and J	
II	Staggered welding - Continuous in way of brackets, crossings and where required for top fittings (see also detail C and J)
III	1 Side continuous, other side chainwelding
IV	Full penetration welding (FP)

WELDING SIZE TABLE	
t	a
t ≤ 5	3
5 ≤ t ≤ 8	3,5
8 < t ≤ 10	4,5
10 < t ≤ 12	5
12 < t ≤ 14	6
14 < t ≤ 15	6,5
15 < t ≤ 18	7
18 < t ≤ 20	8

t = Smallest plate thickness
a = Weld throat size

Bureau Veritas Marine & Offshore
Section 47158L.....
REVIEWED
only for parts concerning Classification,
and as per contract.
Rotterdam, 13-May-2024
(Electronic document)
The plan approval office

NOTE

- Sharp edges to be removed
- Connections table is shown minimum weld based on:
NR600 (Bureau VERITAS) -Ch6, Sec. 2
- Check with WELDING SIZE TABLE and the greater to be used
- If detail is not shown WELDING SIZE TABLE to be used

Full penetration welding for:

- Box cooler chests and fi-fi inlet
- Bulkheads between tanks marked by

Double continuous welding for:

- Wet spaces (except spaces covered with floating floor and wooden panels)
- Chain lockers
- All flat bars in all hatches, doors, inside funnels, casing and fire-flaps
- All outside welding
- All remaining tanks

= Wet spaces

REFERENCE DOCUMENTS			
Function	Func.seq.	Class	Title
110	010	DRAW-2D	Tank arrangement

Project No.	513233	Function	100	Drawn	FVDV	Checked	FVDV	Date	23-02-2017
Yard No.		Section/Compartment		Document number		Sheet	1	Revision	A01
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Doc class DRAW-2D Function sequence 005 Derived from

Project No. 513233 Function 100 Drawn FVDV Checked FVDV Date 23-02-2017

Yard No. Section/Compartment Document number Sheet Revision

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