

# Welding Instructions Mild Steel

## WELDING METHOD

Shielded metal arc welding (SMAW)  
Flux cord arc welding (FCAW)

## WELDERS' QUALIFICATION

Welders to be qualified according to AWS D1.1 latest edition

## CONSUMABLE

SMAW (AWS 7018)

FCAW (AWS E-71-T5)

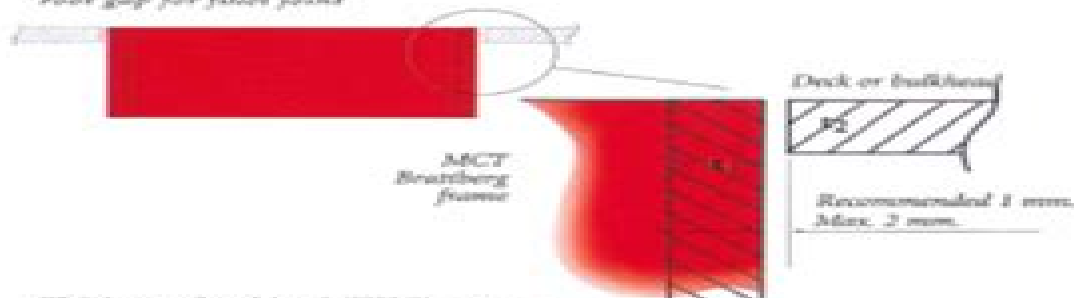
Consumable to be handled and treated according to manufacturer's recommendation.

## PREPARATION AND FIT UP

The prepared joint and surrounding areas shall be clean and free from moisture, oil, grease, loose or thick scale, oxides etc., or any protective coating except weldable primers.

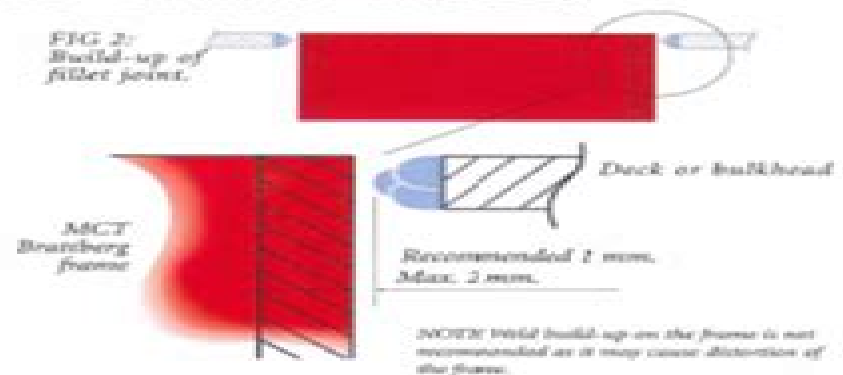
Maximum allowed root gap for fillet welds is recommended 1 mm, max 2 mm (see fig. 1).

FIG 1:  
maximum allowable  
root gap for fillet joint



Thickness Combined (THC) =  $t_1 + t_2$   
If root gap is too wide the deck plate or bulkhead may be built-up with weld to achieve a proper gap.  
(see fig. 2)

FIG 2:  
Build-up of  
fillet joint.



NOTE: Weld build-up on the frame is not recommended as it may cause distortion of the frame.

## PREHEAT AND INTERPASS TEMPERATURE

To avoid hydrogen cracking when welding MCT Brattberg frames made of carbon, manganese or micro alloy steel  
ReL. ° 390N/mm<sup>2</sup>.

## IMPORTANT!

To avoid deformation of the frame it is recommended to follow this welding instructions

Putting safety first

# Welding Instructions Guide

**Klas Weman**

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the 'Klas Weman' text.

## **Welding Instructions Guide:**

**Technical Manual** United States. War Department,1949      **Arc-welding Manual** General Electric Company,1928  
**Underwater Cutting and Welding Manual** United States. Navy Department. Bureau of Ships,1954      *Arc-welding Manual for the Design and Control of Welded Construction* United States. Bureau of Reclamation,1950      *Ordnance Inspection Administrative Manual: General inspection administrative instructions* United States. Army. Ordnance Corps,1960  
A Quick Guide to Welding and Weld Inspection S E Hughes,2009-10-20 A concise and accessible guide to the knowledge required to fulfil the role of a welding inspector In covering both European and US based codes the book gives those wishing to gain certification in welding inspection a basic all round understanding of the main subject matter A concise and accessible guide to the knowledge required to fulfil the role of a welding inspector Covers both European and US based codes Gives those wishing to gain certification in welding inspection a basic all round understanding of the main subject matter      *Marine safety manual* United States. Coast Guard,1985      **Vocational Education : State Instruction Materials for ...** Curriculum and Instructional Materials Center (Okla.),Texas Education Agency. Department of Occupational Education and Technology,1973      Marine Safety Manual: Technical United States. Coast Guard,1985      The Oxxwelder's Manual Oxxweld acetylene Company,1925      *Bibliography of Scientific and Industrial Reports* ,1946  
**Vocational Education : State Instruction Materials for ...** Oklahoma. State Department of Vocational and Technical Education. Curriculum and Instructional Materials Center,1974      *Welding Processes Handbook* Klas Weman,2003 Welding processes handbook is an introductory guide to all of the main welding processes It is specifically designed for students on EWF courses and newcomers to welding and is suitable as a textbook for European welding courses in accordance with guidelines from the European Welding Federation Welding processes and equipment necessary for each process are described so that they can be applied to all instruction levels required by the EWF and the important areas of welded joint design quality assurance and costing are also covered in detail      *Manual of Engineering Drawing* Colin H. Simmons,Dennis E. Maguire,2009-03-24 The Manual of Engineering Drawing has long been the recognised as a guide for practicing and student engineers to producing engineering drawings and annotated 3D models that comply with the latest British and ISO Standards of Technical Product Specifications and Documentation This new edition has been updated to include the requirements of BS8888 2008 and the relevant ISO Standards and is ideal for International readership it includes a guide to the fundamental differences between the ISO and ASME Standards relating to Technical Product Specification and Documentation Equally applicable to CAD and manual drawing it includes the latest development in 3D annotation and the specification of surface texture The Duality Principle is introduced as this important concept is still very relevant in the new world of 3D Technical Product Specification Written by members of BSI and ISO committees and a former college lecturer the Manual of Engineering Drawing combines up to the minute technical information with clear readable explanations and

numerous diagrams and traditional geometrical construction techniques rarely taught in schools and colleges This approach makes this manual an ideal companion for students studying vocational courses in Technical Product Specification undergraduates studying engineering or product design and any budding engineer beginning a career in design The comprehensive scope of this new edition encompasses topics such as orthographic and pictorial projections dimensional geometrical and surface tolerancing 3D annotation and the duality principle along with numerous examples of electrical and hydraulic diagrams with symbols and applications of cams bearings welding and adhesives The definitive guide to draughting to the latest ISO and ASME standards An essential reference for engineers and students involved in design engineering and product design Written by two ISO committee members and practising engineers      **Manual Training Magazine** ,1921

**Steel Designers' Manual** Steel Construction Institute (Great Britain),2012-02-20 In 2010 the then current European national standards for building and construction were replaced by the EN Eurocodes a set of pan European model building codes developed by the European Committee for Standardization The Eurocodes are a series of 10 European Standards EN 1990 EN 1999 that provide a common approach for the design of buildings other civil engineering works and construction products The design standards embodied in these Eurocodes will be used for all European public works and are set to become the de facto standard for the private sector in Europe with probable adoption in many other countries This classic manual on structural steelwork design was first published in 1955 since when it has sold many tens of thousands of copies worldwide For the seventh edition of the Steel Designers Manual all chapters have been comprehensively reviewed revised to ensure they reflect current approaches and best practice and brought in to compliance with EN 1993 Design of Steel Structures the so called Eurocode 3      **Occupational Outlook Handbook** ,2000 Describes 250 occupations which cover approximately 107 million jobs      Resources in Education ,1989      Manual Training Magazine Charles Alpheus Bennett,1918      **Welding Theory and Application** United States. War Department,1943

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