

# 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)

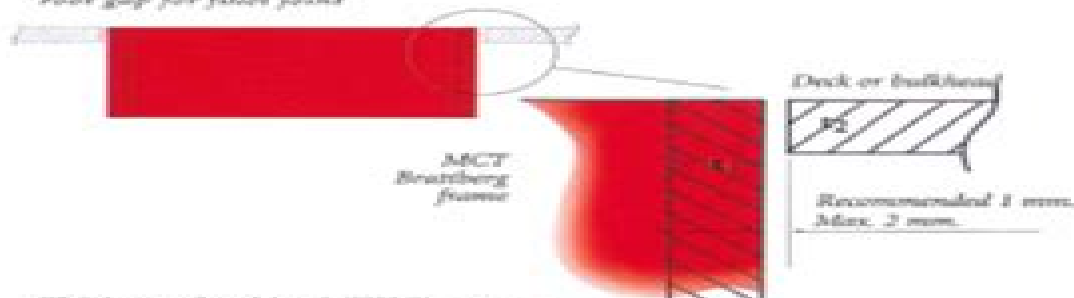
Consumable to be handled and treated according to manufacturer's recommendation.

## 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.

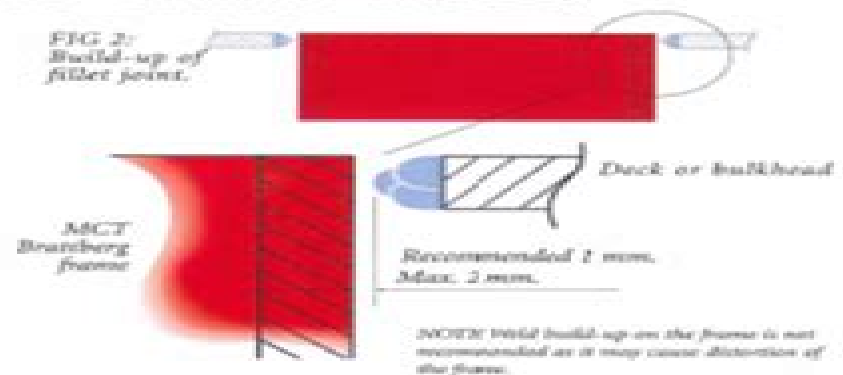
Maximum allowed root gap for fillet welds is recommended 1 mm, max 2 mm (see fig. 1).

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.



## 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

**United States. Navy Department.  
Bureau of Ships**



## **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,1929

**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

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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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