

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)

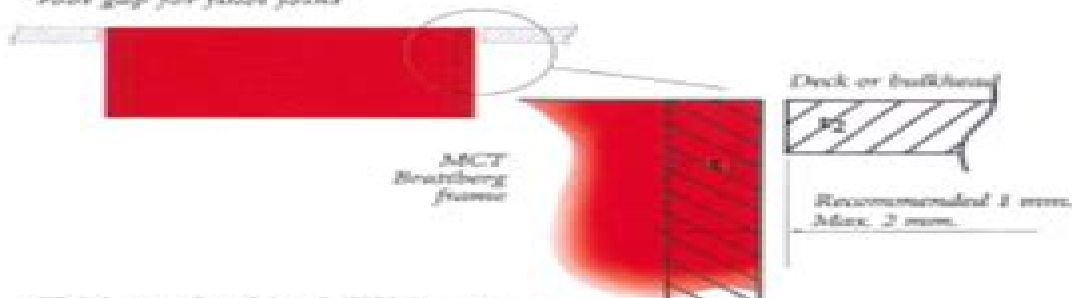
Consumable to be handled and treated according to manufacturer's recommendation.

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.

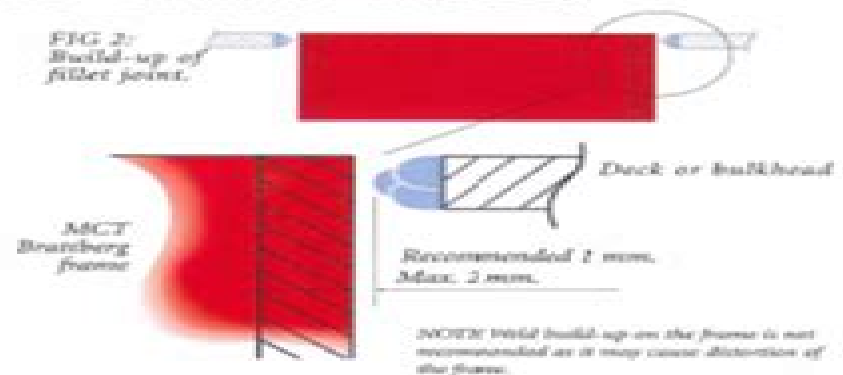
Maximum allowed root gap for fillet welds is recommended 1 mm, max 2 mm (see fig. 1).

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.



Recommended 1 mm.
Max. 2 mm.

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/mm².

IMPORTANT!

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

Putting safety first

Welding Instructions Guide

J Dewey



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
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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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Table of Contents Welding Instructions Guide

1. Understanding the eBook Welding Instructions Guide
 - The Rise of Digital Reading Welding Instructions Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Welding Instructions Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Welding Instructions Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Welding Instructions Guide
 - Personalized Recommendations
 - Welding Instructions Guide User Reviews and Ratings

- Welding Instructions Guide and Bestseller Lists
- 5. Accessing Welding Instructions Guide Free and Paid eBooks
 - Welding Instructions Guide Public Domain eBooks
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 - Welding Instructions Guide Budget-Friendly Options
- 6. Navigating Welding Instructions Guide eBook Formats
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 - Welding Instructions Guide Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Welding Instructions Guide
 - Highlighting and Note-Taking Welding Instructions Guide
 - Interactive Elements Welding Instructions Guide
- 8. Staying Engaged with Welding Instructions Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Welding Instructions Guide
- 9. Balancing eBooks and Physical Books Welding Instructions Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Welding Instructions Guide
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Welding Instructions Guide
 - Setting Reading Goals Welding Instructions Guide
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Welding Instructions Guide
 - Fact-Checking eBook Content of Welding Instructions Guide
 - Distinguishing Credible Sources

13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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