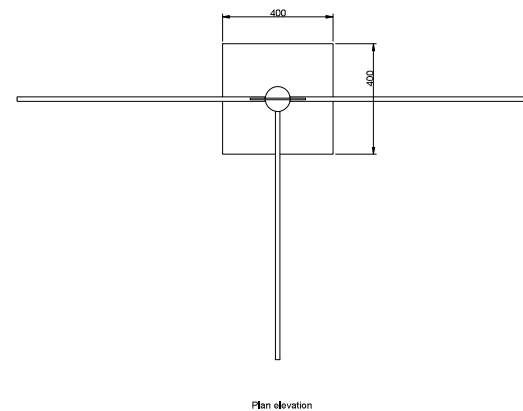
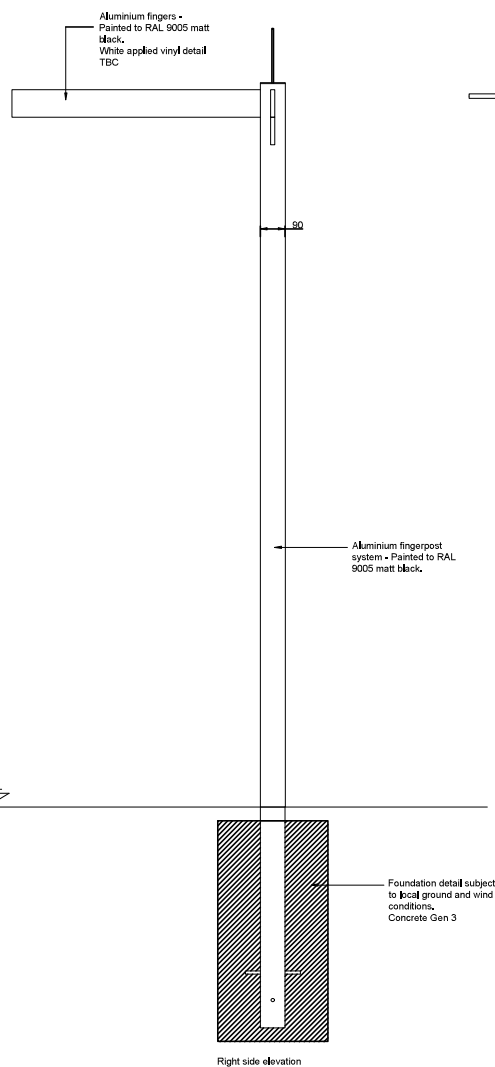
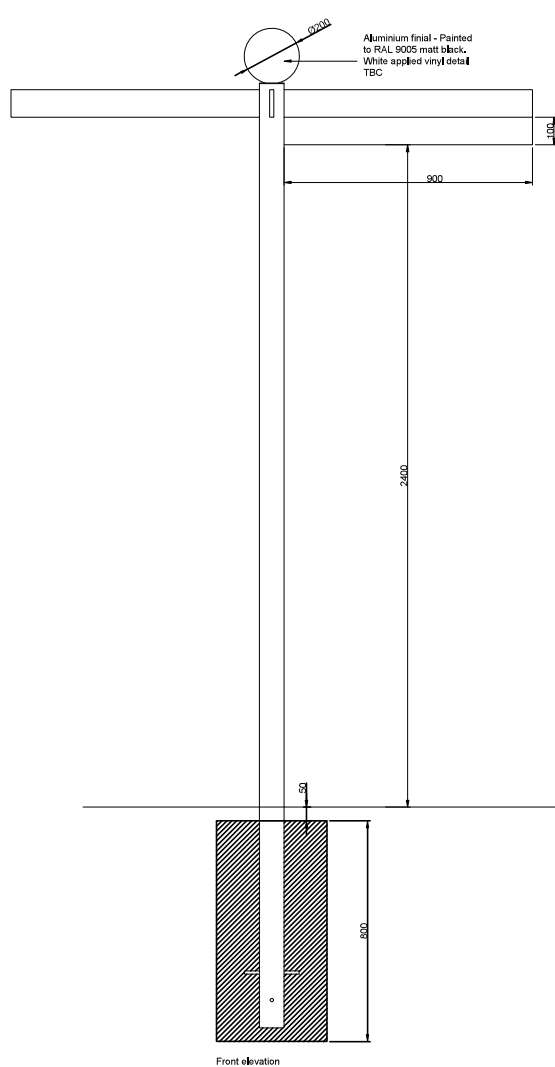


Generic layout of fingers - refer to graphical files for content and directions TBC



JOB CARD-F006			
WELD SET No.			
WELDING WIRE LOT/BATCH			
WELDING GAS LOT/BATCH			
ISSUE TO FAB	INITIALS:		
CUT BY	INITIALS:		
BENT BY	INITIALS:		
DIMENSIONAL CHECKS	INITIALS:		
FABRICATED BY	INITIALS:		
WELDED BY	INITIALS:		
WELD INSPECTION DURING MULTIRUN	INITIALS:		
COMPLETION OF MANUFACTURE	DATE:		
CHECKED BY RWC YES NO	DATE:		
REWORK YES NO	DATE:		
	NCR No.		
ANY REWORK MUST RELATE TO NCR AND FOLLOW NID PROCEDURE WELD DEFECT TO BE COMPLETELY REMOVED AND REWELDED TO THE ORIGINAL PROCEDURE.			
GAS FLOW CHECK			
VISUAL INSPECTION	100%	PASS / FAIL	
MPI	%		
DPI	%		
PRE GALV CHECK			
POST GALV CHECK			
ON COMPLETION THIS DRAWING MUST BE SIGNED AND GIVEN TO THE QARWC SIGNATURE AND DATE:			
WELDING PLAN-F014			
-ALL WELDS 9mm LEG LENGTH FILLET UNO -ALL STEELWORK TO EXC2 -ALL TOLERANCES TO MEET BS 1090-2 -MAKE SURE SURFACE IS FREE FROM GREASE & MILL SCALE -ACCEPTABLE CRITERIA TO BS EN 5817 (QUALITY LEVEL C) -LAMELLA TEARING TO BE AVOIDED BY GOOD JOINT DESIGN -CORRECT MATERIALS, WELDING SEQUENCE AND TECHNIQUE -RESTRAINTS APPLIED, CLAMPS AND BRACES (IF REQUIRED) -TURNING OF COMPONENTS BY O/H CRANE AND 'a' FRAMES -MEASURES TO AVOID DISTORTION PRE-HEAT POST-HEAT			
WPS 01 SL FW(135) z <8.5mm WPS 02 ML FW(135) Z >8.5mm WPS 06 SL FW(141) ALU WPS 09 BW(135) WPS 03 SL FW(135) PIPE TO PLATE WPS 05 SL FW(141) STAINLESS WPS 08 SL FW(141) SS PIPE-PLATE			
 CUTTING EDGE SIGNAGE Enterprise House, Unit 1 Aber Park Industrial Estate Farnshire, CH6 5EX t: 01352 792000 e: info@is-group.co.uk w: www.is-group.co.uk			
QTY	AS DETAILLED		
MATERIAL GRADE	AS DETAILLED		
SURFACE FINISH	AND BS No.		
SITE			
TITLE			
DATE	09.07.2026		
DRAWN	RH	CHECKED	
SHEET No.	1	SO No.	5843
DRAWING No. SO5843 - fingerpost			