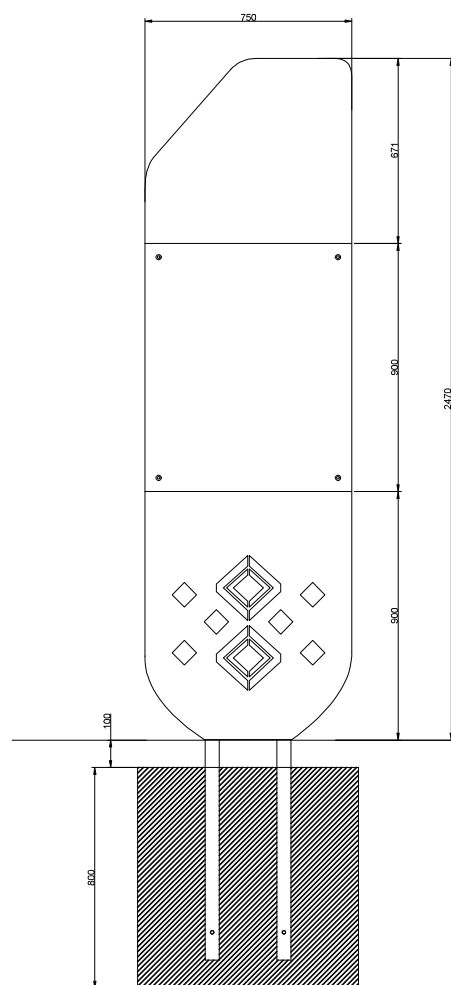
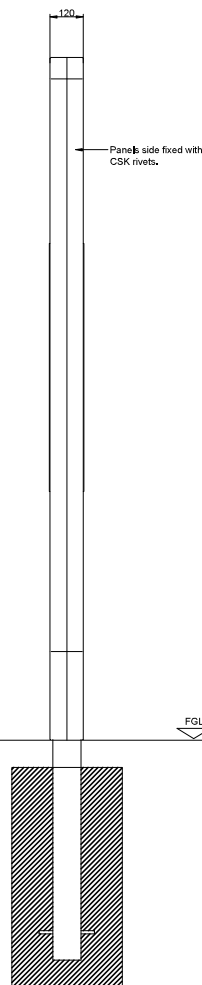


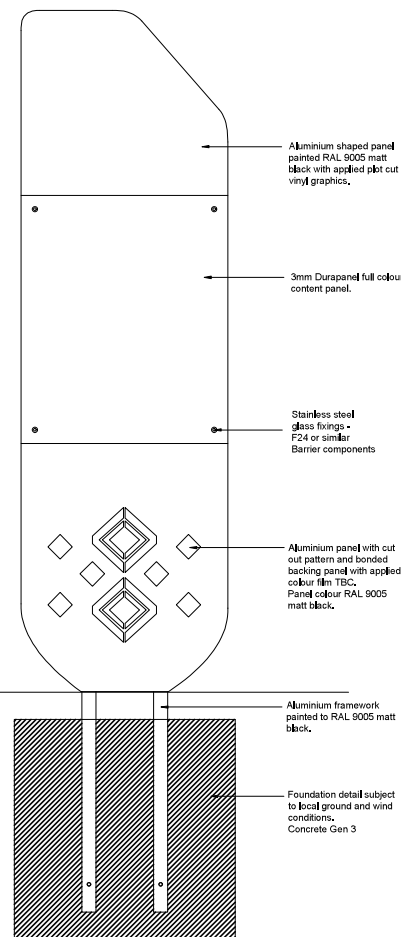
Plan elevation



Front elevation



Side elevation



Rear elevation

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 MULTITRIP	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 NDT PROCEDURE WELD DEFECT TO BE COMPLETELY REMOVED AND REWELDED TO THE ORIGINAL PROCEDURE.

GAS FLOW CHECK		
VISUAL INSPECTION	100%	PASS / FAIL

VISUAL INSPECTION	100%	PASS / FAIL
MPI	%	

DPI	%	
PRE GALV CHECK		

POST GALV CHECK	
-----------------	--

ON COMPLETION THIS DRAWING MUST BE SIGNED AND
GIVEN TO THE QA/RWC
SIGNATURE AND DATE:

WELDING PLAN-F014

- ALL WELDS 6mm 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 BE 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 OH 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



QTY	AS DETAILED
MATERIAL GRADE	AS DETAILED
SURFACE FINISH AND BS No.	

SITE	
TITLE	

DATE	09.07.2026
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DATE	06/07/2020		
DRAWN	RH	CHECKED	
SAFETY	1	20.1	20.1

SHEET No.	1	SO No.	5843
DRAWING No.	SO5843 - totem		

STRUCTURAL ENGINEERS JOB No. 000000 COLUMN TO BASEPLATE 00mm FILLET WELD

DRAWING ISSUE

INFORMATION

REVISION.

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