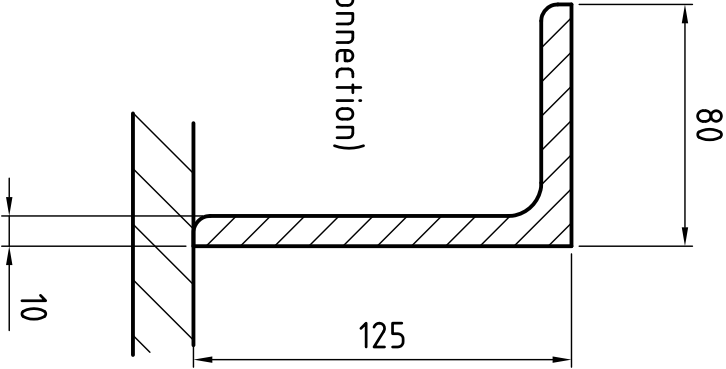



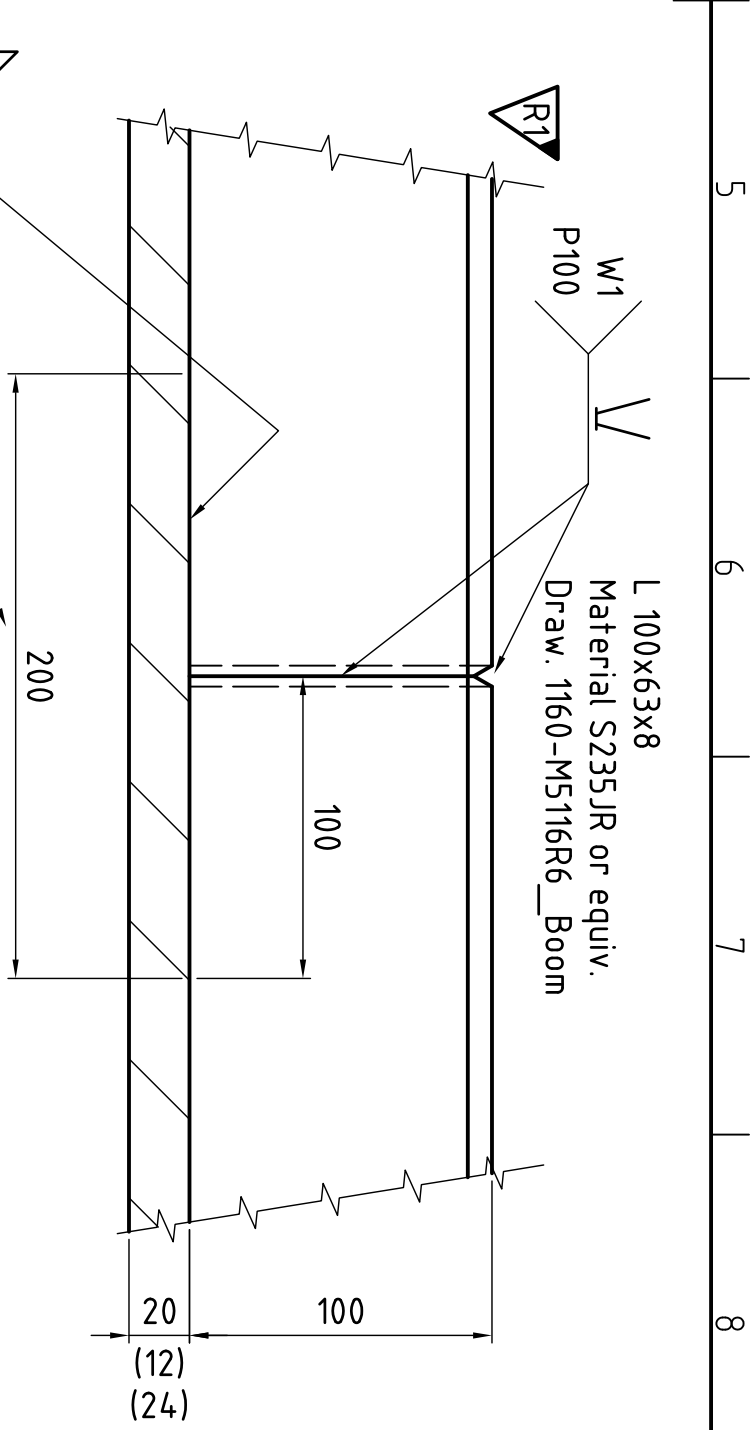
Repair steps

1. Remove existing weld in this area
2. Remove paint in the repair area
3. Prepare the welding flanks.
4. Perform welding from the outside Full penetration) with ceramic backing plate on inside.
5. Grind and weld from the outside (welding flanks). (Full connection)
6. Weld fillet weld between buckle stiffness and flange
7. After at least 16 hours NDT test (P100)
8. Acceptance
9. Painting

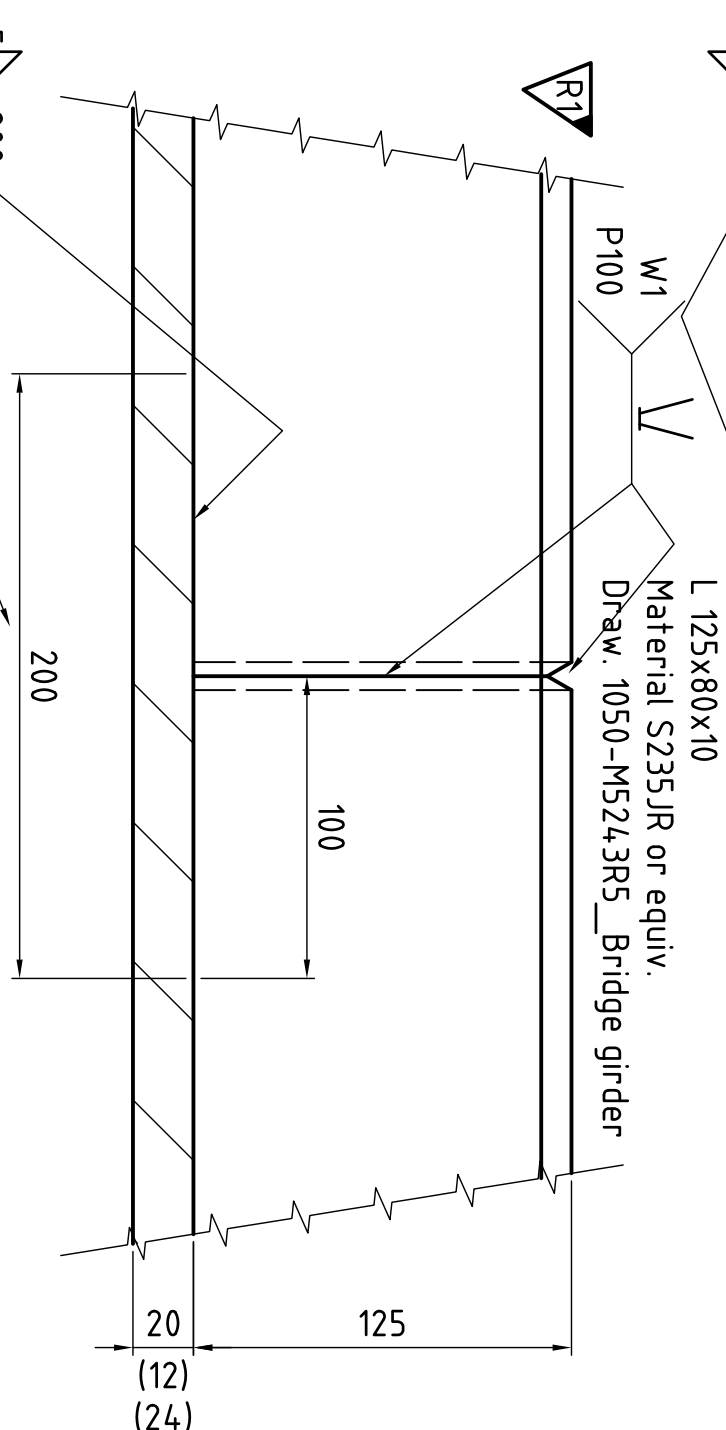


NOTES:

- PRINCIPLES OF CONSTRUCTION AND WELDING ACC. TO FEM 1001, booklet 3, notch case 3
- Execution of welds according to EN ISO 5817 quality level B
- PLATES AND SHAPES WITH $t \geq 25\text{mm}$ - PRE-HEATED BEFORE WELDING (100-150°)
-  US = AREAS TO BE CHECKED FOR LAMINATION BY ULTRASONIC TEST
- \sphericalangle = WELD INTERFACE NOTCH-FREE



L 125x80x10
Material S235JR or equiv.
Draw. 1050-M5243R5_Bridge girder



					Surface		Scale 1:2.5		Draw size A3	Weight -
							Description Welding detail for stiffener re P.P.A Container Terminal_Piraeus			
				Date	Name					
				Prepar	18.12.2017	Tibitanzl				
				Check.						
				Seen						
						Drawing number P.P.A. 1000.0001				
Rev. 1	Change weld type	23.12.2017	Tib.							
Index	Revision	Date	Name	File name						