

Welding procedure for locking cones (FR-1, FR-3)

1. Positioning of the cone:

Cones are to be positioned on deck.

Direction of the cone's centrelines must be in accordance with the planned stowage configuration.

2. Welding Seam preparation:

Weld seams on deck and straps must be cleaned. It has to be checked that they are free from paint, grease, oil,

3. Weather Protection, Preheating:

Weld seams are to be sufficiently protected against climatic influences (wind, damp, rain,...).

Unless base metal temperature is below 0°C, preheating is not required.

If temperature of material is below 0°C, material is to be preheated and kept constant at 20°C.

4. Welding:

Butt weld with depth 6mm, all around the cone. (see drawing)

Electrodes to be used: Any E.70X8 or equivalent.

