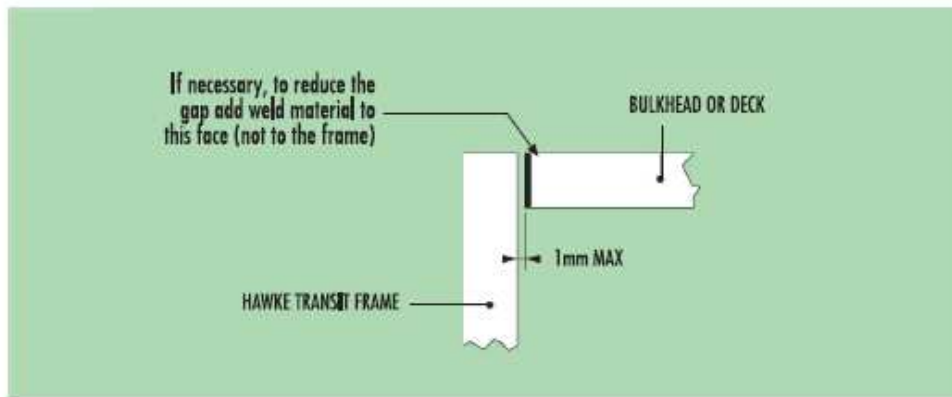
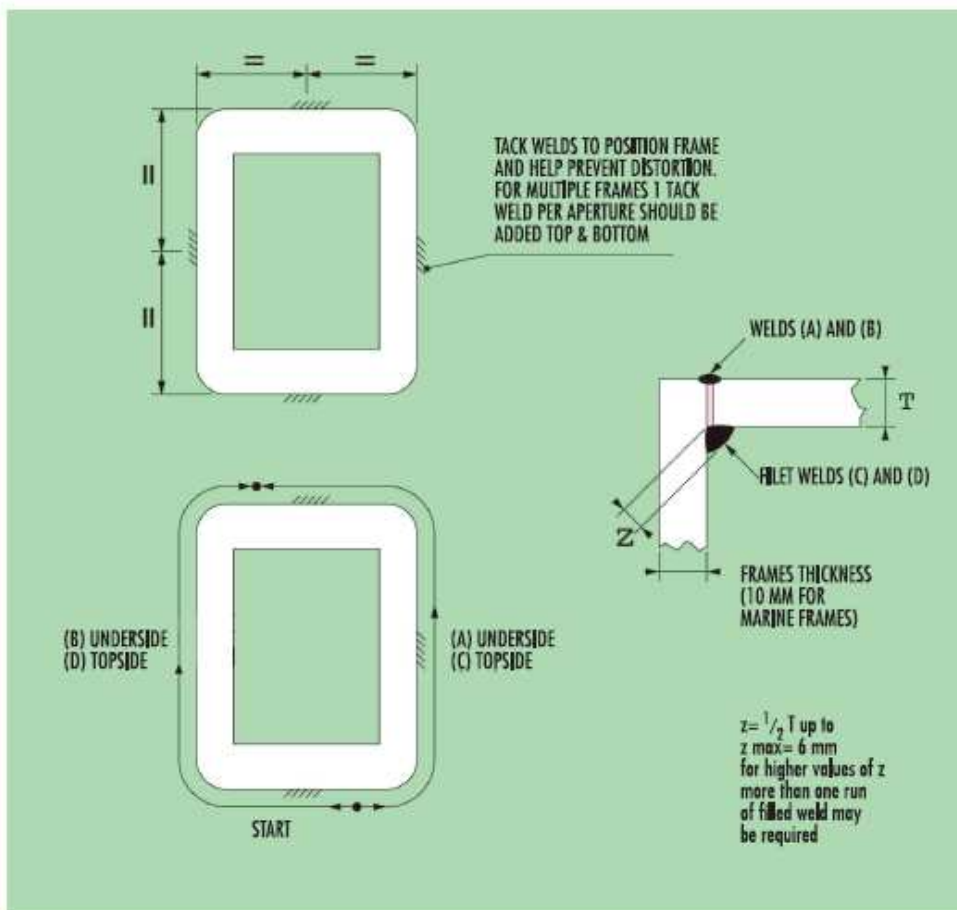


# FRAME WELDING INSTRUCTIONS



The aperture in the bulkhead/deck should be cut out such that the gap surrounding the frame 1mm.

If gap is in excess of 1mm weld material may be added to the bulkhead/deck cut face to reduce the gap. The bulkhead/deck should then be dressed and prepared as previously stated.



Prior to completing welds on either side of the bulkhead the frame should be tacked into position as in the sketch above. The tack welds reducing the amount of distortion in the parent metals.

The frame must be welded from both sides of the bulkhead.

## Welding Sequence

1st (A) underside, 2nd (B) underside, 3rd (C) topside, 4th (D) topside

**Note:** Allow adequate time for cooling to prescribed levels to prevent cracking between each weld run. Weld runs should not start or stop at a tack weld but should run over a tack.