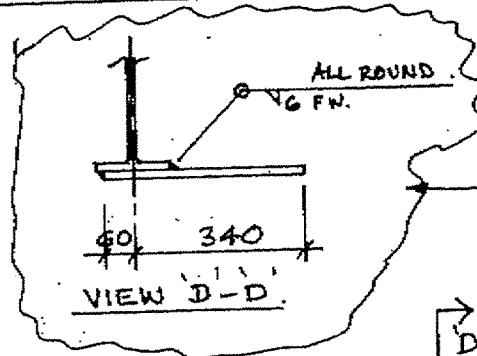
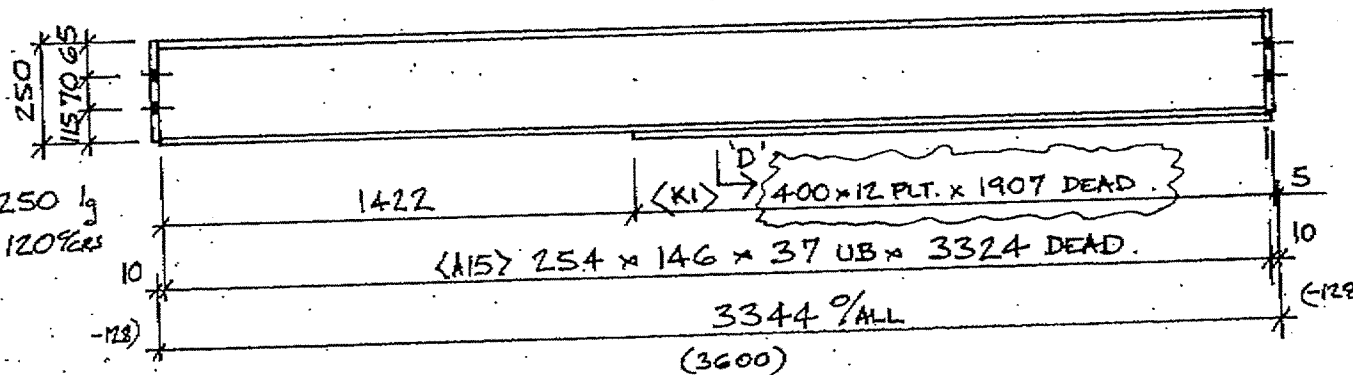


ALL SHS, RHS & CHS SECTIONS ARE GRADE S355JR UNLESS NOTED OTHERWISE.

ANY/ALL SITE WELDING TO L COOPER STEEL STRUCTURE MUST BE DONE USING LOW HYDROGEN WELDING RODS (SUITABLY DRIED IN AN OVEN) OR SIMILAR



SITE WELD NEW PLATE 400x12 THK. G.F.W. ALL ROUND TO 2ND BEAMS



2 N° REQ'D. THUS.

MKD 28/1

NEW PLATES EXTRA TO CONTRACT.

LEONARD COOPER LIMITED

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REGISTERED OFFICE
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REVISION A.	
REVISION B.	
REVISION C.	
REVISION D.	
REVISION E.	

SHOP BOLTS	4.6
FINISH	S.S.
NO	
OFF	
TYPE	
DIA	
TH	
NO	
TH	

ZONE 6
FABRICATION TOLERANCES
TO BS5586 PART 2 (U.N.O.)
1500MM ON A.C. PROCEDURE
NOTES: (U.N.O.)
ALL WELDS ARE FULL PENETRATION
ALL STEEL TO BEEN 100% GRADE S275JR
PAINT SHOT BLAST TO SA 2.5 COAT
H.B.L.P. PRIMER TO 60MM D.M.T.
IDENTIFICATION MARKS MUST BE PLACED ON
1) TOP RIGHT END OF BEAM/ANGLES OR
2) OTHER SIDE IDENTIFIED FROM MARK

CONTRACT	QUARMBY CONSTRUCTION
WAKEFIELD WATERFRONT, BLDG 20	
TITLE	BEAMS
RELEASED FOR	SIGNED:
FABRICATION/ERECTION	DATE:
SCALE:	
DATE: 07/18/SWS	
CHECKED BY: JSM	