

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

150 x 10 FLT. x 150 lg.
G.F.W. ALL ROUND

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 DRILL 2N°
18φ HLS.

OMIT WELD FROM END PLT TO 200 x 15 FLT FOR 30mm LOCAL TO HOLES THIS SIDE

115 85
75 40 40 45
30

88 32
40 75 45 40

200 x 12 FLT x 142 lg.
4N° 18φ HLS.
G.F.W. ALL ROUND.

FILL THRSR.
HOLS!

10 130 x 10 FLT. x 350 lg.
G.F.W. TO N/SIDE

150 x 10 FLT. x 100 lg.
G.F.W. ALL ROUND

142
22 88 32
130 6
127
88
206 NOTCH
12
-5

<L7> 1/6 457 x 191 x 82 UB. 191 x 229 x 410 B.T. x 1769 DEAD.
1793 % ALL
(1900)

(BUTT. WELDED 7 % 200 x 15 FLT.
1N° 210 lg. WITH 2N° 34φ HOLES.
1N° 83 lg. PREP FOR F.P.B.W.
WELD IN G.F.W. ALL ROUND AS SHOWN.

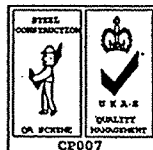
ONE N° REQ'D. THUS.

MKD 44/1

N.B. THIS SITEWORK TO BE DONE IN L. COOPERS WORKS. RE-BLAST AFTER ALTERATIONS & RE-PAINT

180 x 12 FLT. x 260 lg.
4N° 18φ HLS
G.F.W. ALL ROUND.

LEONARD COOPER LIMITED STRUCTURAL ENGINEERS



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REVISION A.

REVISION B.

REVISION C.

REVISION D

REVISION E.

ZONE 15

FABRICATION TOLERANCES
TO BS5950 PART 2 (U.N.O.)
(SHOWN ON L.C. PROCEDURE
M25-23)

CONTRACT: QUARMBY CONSTRUCTION
WAKEFIELD WATERFRONT. BLDG 20

TITLE SUPPORT TEE

SHOP BOLTS 4.6
FINISH 8.8

SHOP NOTES: (U.N.O.)
ALL WELDS 6mm CONT. FILLET WELDS
ALL STEEL TO BS EN 10025 GRADE S275JR

PAINT SHOT BLAST TO SA 2.5. 1 COAT
C400 V3 TO 80 mic D.F.T.

IDENTIFICATION MARKS MUST BE PLACED ON
1) TOP RIGHT HAND END OF BEAMS/MEMBERS OR
2) COLUMN WHERE INDICATED THUS: MARK

RELEASED FOR FABRICATION/ERECTION
SCALE:

DRAWN BY: MHS
CHK'D BY: ISM
DRG No: 07/18/SW14