

# INSTALLATION & WELDING RECOMMENDATIONS FOR D-RING LP-12 36T

## INSTALLATION INSTRUCTIONS

### **STEP 1: DECK LINES**

THE SHIPYARD HAS DETERMINE THE TO INTERSECTING LINES RELATIVE TO THE CENTER LINE OF THE D-RING STRAP FOR PROPER LASHING ARRANGEMENT. (SEE "TOP VIEW" DRAWING)

### **STEP 2: POSITIONING**

THE D-RING AND STRAP NEED TO BE POSITIONED OVER DECK LINES DESCRIBED IN STEP 1 ABOVE. (SEE "TOP VIEW" DRAWING)

### **STEP 3: SUPPORTS AND STIFFENERS**

THE SHIPYARD NEEDS TO SUPPLY SUPPORTS, STIFFENERS, AND REINFORCING PLATES TO SUIT SHIP STRUCTURE WITH ADEQUATE INSTALLATION AND CONSTRUCTION TO SATISFY APPROPRIATE CLASSIFICATION SOCIETY REQUIREMENTS.

## WELDING INSTRUCTIONS

### **STEP 4: PREPARATION**

D-RING STRAP, DECK PLATES, AND BASE PLATES NEED TO BE PROPERLY PREPARED AND CLEANED BEFORE WELDING.

### **STEP 5: WELDING**

WELD WITH 70,000 P.S.I. LOW HYDROGEN WELDING ROD EQUAL TO A.W.S. E7018. MOISTURE CONTENT TO BE CONTROLLED PER RECOMMENDED A.W.S. STORAGE AND RECONDITIONED PROCEDURES. WELDING SEQUENCE TO BE AS FOLLOWS:

- PLACE D-RIND AND STRAP IN POSITION PER INSTALLATION INSTRUCTIONS. ALWAYS PLACE D-RING AWAY FROM SIDE OF STRAP BEING WELDED.
- SHIM STRAP 2mm AND TACK WELD.
- WELD ALONG EDGES AND WRAP AROUND CORNERS.
- COMPLETE JOINT PENETRATION (CJP ) WELDS.
- MINIMUM WELD THROAT HEIGHT T= 5m

NOTE: D-RING TO SWING FREELY AFTER WELDING.

### **STEP 6: CLASSIFICATION SOCIETY APPROVAL**

SHIPYARD TO OBTAIN APPROPRIATE CLASSIFICATION SOCIETY APPROVAL OF APPLIED WELDING PROCEDURE.

