

REVISION HISTORY		
DATE	DESCRIPTION	REV
26/02/2024	ORIGINAL RELEASE	A
06/03/2024	Standard Approved Drawing Format	B

Laminated Copy in circulation - rev B
Customer: See Process Card
File saved in the folder named below



PC NO	PART NAME	QTY
7	50020-3027-001_DWG	4
6	50020-3018-001-16_DWG	4
5	50020-3014-005_DWG	1
4	50020-3004-001_DWG	1
3	50020-3001-009 W ASM_DWG	6
2	50020-3001-008 W ASM_DWG	1
1	50020-3001-007 W ASM_DWG	1

Washer Rack Accessories welding Requirements (with tubing) - SF1:

- Only parts with full QC pass to be used in this assembly.
- All laser cut edges to be polished down smooth to look seamless - Ra max. = 0.6 micro meter Ra.
- All joints on tubing to be Orbital welded where possible.
- Only "hard to reach" joints on tubing to be manually TIG welded so it fully penetrates the joint.
- All joints on framework to be manually TIG welded so it fully penetrates the joint.
- All external welds to be ground down smooth to look seamless - Ra max. = 0.6 micro meter Ra.
- All internal welds - Ra max. = 1.6 micro meter Ra.
- Internal Ra max. = 0.51 micro meter RA (SF1). See Table SF-2.4-1 in ASME BPE 2019 (page 249) for full details. (except for internal welds - Ra max. = 1.6 micro meter Ra)
- Any blemishes such as porosity, pinholes, undercutting, cracks, un-flush welds are not permitted on any surface of the part.
- See Table SF-2.2-1 in ASME BPE 2019 (page 248) for full details.
- Maximum size of scratches permitted - cumulative length to be less than 305mm (1ft) per 6.1m (20ft) of length or prorated and if depth less than 0.08mm (0.003 in).
- See Table SF-2.2-1 in ASME BPE 2019 (page 248) for full details.
- All edges to be fully deburred - both internally and externally.
- No contact permitted with internal surface during welding/jigging.
- No contact permitted with internal surface with files or other deburring/cleaning tools.
- All fabricated folds and bends to be within +/- 1.0 mm unless noted otherwise.
- All fabricated folds and bends to be within +/- 0.5 degrees unless noted otherwise.
- Weld Map drawings to be initialled and signed by welder as each weld is completed.
- All mounting holes to frame section to be checked on checking jig.
- External surfaces of Tubing - passivated & Electro polished. See Table SF-2.2-2 in ASME BPE 2019 (page 249) for full details.
- Internal surfaces of Tubing - passivated only. See Table SF-2.2-2 in ASME BPE 2019 (page 249) for full details. (Note: internal welds - Ra max. = 1.6 micro meter Ra)
- Part to be packaged before and after welding/polishing to prevent damage
- Internal and external surfaces to be visually inspected with Borescope & under Magnifying Lamp to ensure they conform to latest ASME BPE Standards.
- Ensure IPT form is completed correctly.

Preferred Material Blank Size	See Parts
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Fabrication to use:
TE50011-094 - Belimed Base Frame Jig

Design Stamp		Released: O.Fitzgerald				Date: 06/03/2024		
		Name	Date					
	Drawn	M.Looram	06/03/2024					
	Checked	C.Gilsenan	06/03/2024					
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				Outer Ring - Weld ASM				
				Size	Drawing No.		Rev	
				A3	50020-3014-008 W ASM_dwg		B	
				Scale	NTS	Standard Washer Racks		Sheet 1 of 1