

NOTE :
1. THIS DRAWING IN NOT TO BE SCALED
2. ALL DIMENSIONS ARE IN MILLIMETRES UNLESS NOTED OTHERWISE

GENERAL NOTES

1. ALL NEW MATERIAL TO BE GRADE EN10025:S355 UOS. MATERIAL LIST PROVIDED FOR GUIDANCE ONLY. FABRICATOR TO CHECK ALL QUANTITIES AND SIZES BEFORE ORDERING AND CUTTING.

2. ALL FILLET WELDS TO BE THROAT 0.5 X MIN. THK. OF ATTACHED MEMBERS UNO ALL BUTT WELDS TO BE FULL PEN. UNO ALL WELDING TO BE IN ACCORDANCE WITH AWS D1.1 2000 ALL WELD SYMBOLS TO BS EN 22553

3. GENERAL FABRICATION TOLERANCES:- + LINEAR 2mm - + ANGULAR 0.5° - UOS.

4. SPECIAL CARE TO BE TAKEN TO ENSURE COMPLETE ALIGNMENT OF ALL STRUCTURAL MEMBERS, TO SURVEYORS SATISFACTION

5. EXISTING STRUCTURE TO BE VERIFIED AS FITTED, TO THE SURVEYORS SATISFACTION.

6. FABRICATOR TO PRODUCE WELDING PROCEDURES WITH APPROVAL BY CLASS AS NECESSARY.

7. ALL DIMENSIONS IN MM

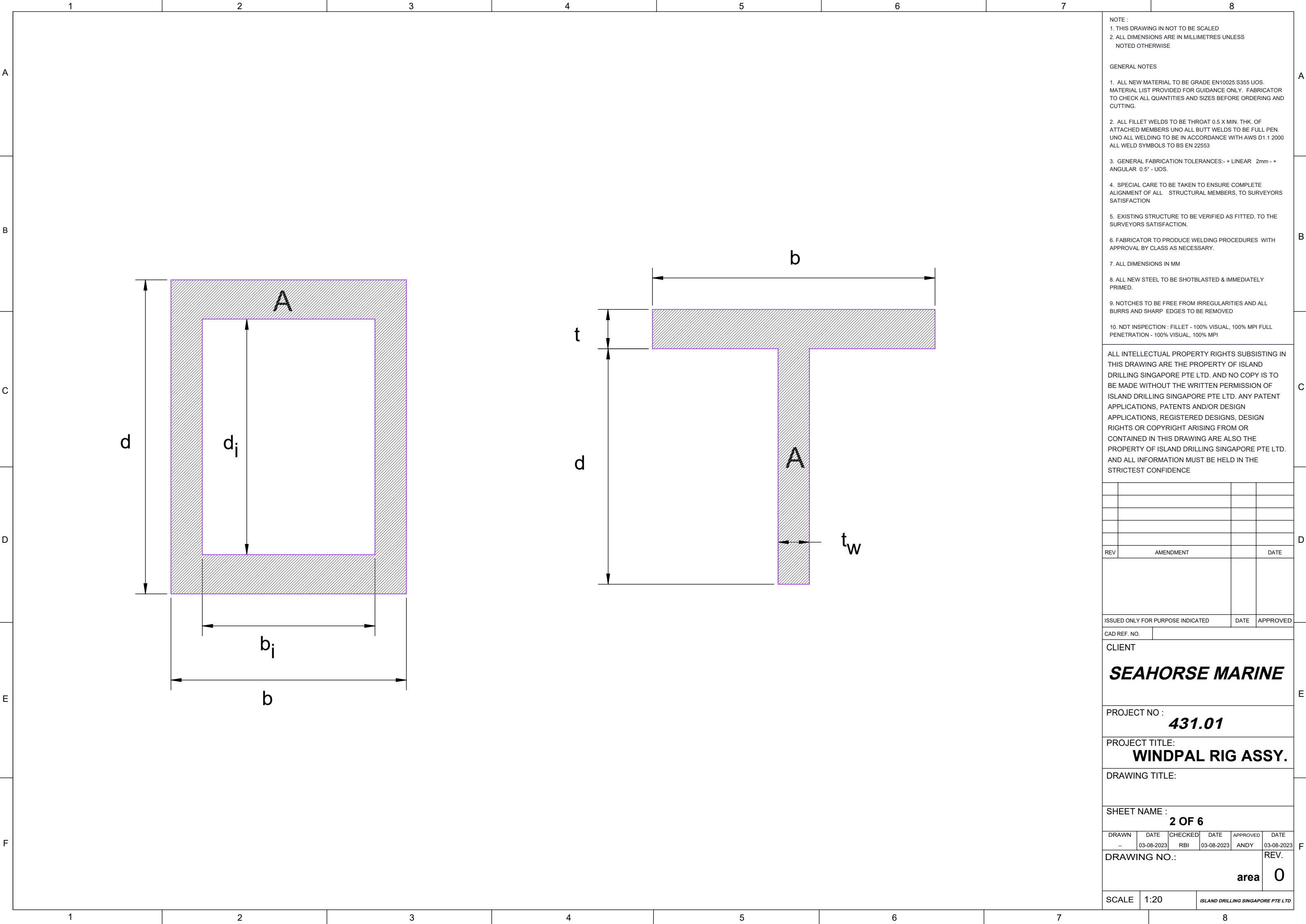
8. ALL NEW STEEL TO BE SHOTBLASTED & IMMEDIATELY PRIMED.

9. NOTCHES TO BE FREE FROM IRREGULARITIES AND ALL BURRS AND SHARP EDGES TO BE REMOVED

10. NDT INSPECTION : FILLET - 100% VISUAL, 100% MPI FULL PENETRATION - 100% VISUAL, 100% MPI

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REV	AMENDMENT		DATE
ISSUED ONLY FOR PURPOSE INDICATED		DATE	APPROVED
CAD REF. NO.			
CLIENT			
SEAHORSE MARINE			
PROJECT NO : 431.01			
PROJECT TITLE: WINDPAL RIG ASSY.			
DRAWING TITLE:			
SHEET NAME : 1 OF 6			
DRAWN	DATE	CHECKED	DATE
--	03-08-2023	RBI	03-08-2023
APPROVED		DATE	
ANDY		03-08-2023	
DRAWING NO.: area			REV. 0
SCALE	1:20		ISLAND DRILLING SINGAPORE PTE LTD



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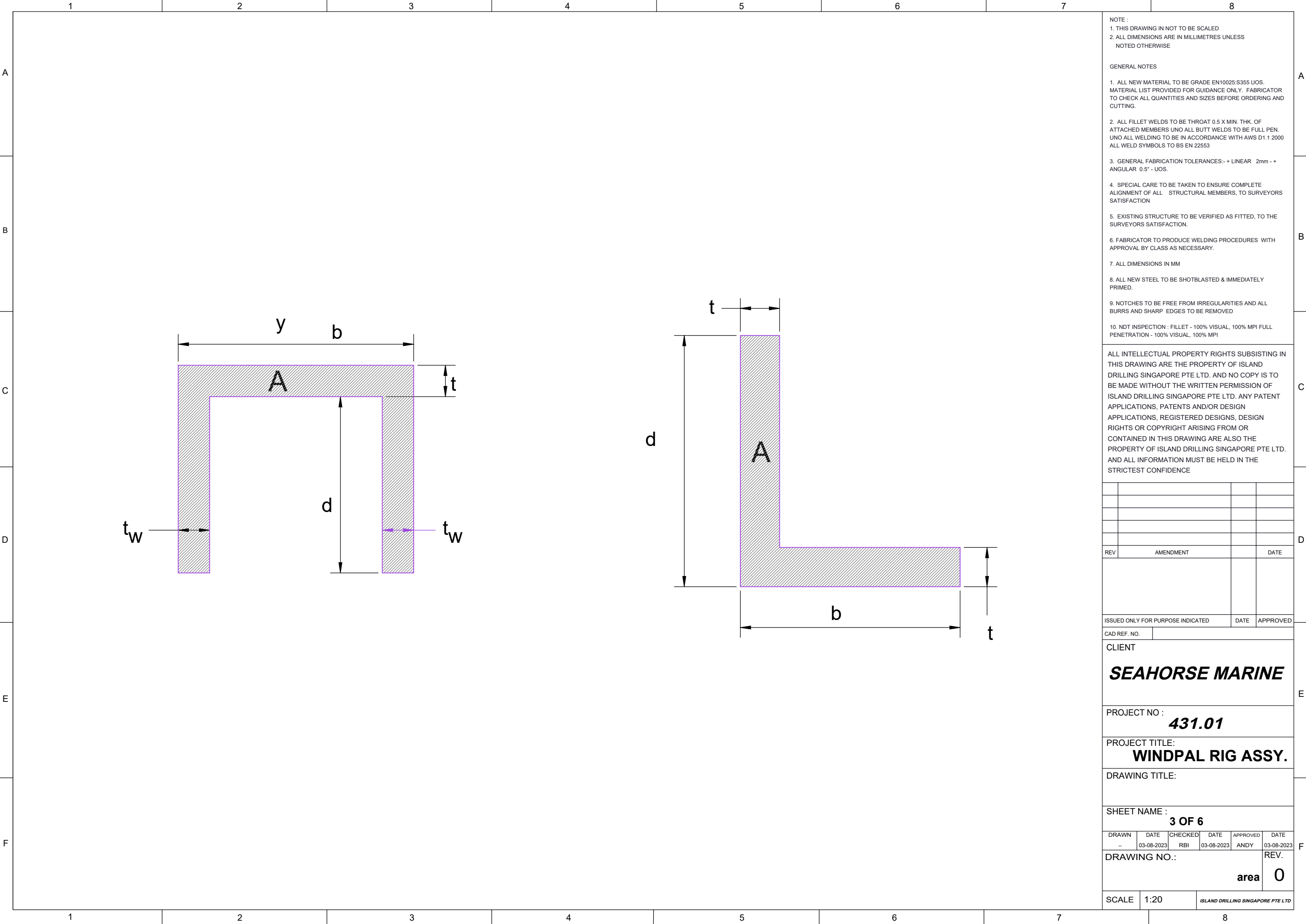
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REV	AMENDMENT		DATE
ISSUED ONLY FOR PURPOSE INDICATED		DATE	APPROVED
CAD REF. NO.			
CLIENT			
SEAHORSE MARINE			
PROJECT NO : 431.01			
PROJECT TITLE: WINDPAL RIG ASSY.			
DRAWING TITLE:			
SHEET NAME : 2 OF 6			
DRAWN	DATE	CHECKED	DATE
--	03-08-2023	RBI	03-08-2023
APPROVED		DATE	
ANDY		03-08-2023	
DRAWING NO.:			REV.
area			0
SCALE	1:20		ISLAND DRILLING SINGAPORE PTE LTD



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REV	AMENDMENT		DATE
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CAD REF. NO.			
CLIENT			
SEAHORSE MARINE			
PROJECT NO : 431.01			
PROJECT TITLE: WINDPAL RIG ASSY.			
DRAWING TITLE:			
SHEET NAME : 3 OF 6			
DRAWN	DATE	CHECKED	DATE
--	03-08-2023	RBI	03-08-2023
APPROVED		DATE	
ANDY		03-08-2023	
DRAWING NO.: area			REV. 0
SCALE	1:20		ISLAND DRILLING SINGAPORE PTE LTD

REFER SolidWorks CREATED PDF FOR SCALE SIZE ,
DIMENSIONS ETC. IN AutoCad (DWG) FILE FORMAT


REMOVE SHARP EDGES.WHENEVER IN DOUBT ASK !
DO NOT SCALE. ALL DIMENSIONS ARE IN mm
UNLESS NOTED OTHERWISE

ALL WELDS ARE FULLY PENETRATED
UNLESS NOTED OTHERWISE

FABRICATION TO BE IN ACCORDANCE WITH AWS D1.1
ALL WELDS TO BE INSPECTED 100% M.P.I. UNLESS SPECIFIED.

FINISH:
GRIT BLAST TO SA 2 1/2 NEAR WHITE FINISH
1 COAT ZINC PRIMER 50 MIC
1 COAT INTERMEDIATE BUFF 100 MIC
1 TOP COAT POLYURETHANE 50 MIC UV RESISTANT

	0	APPROVED FOR CONSTRUCTION	03-08-2023
ZONE	MARK	PARTICULARS	DATE
GENERAL TOLERANCE			
LINEAR TOLERANCE		ANGULAR TOLERANCE	
X ± 0.5 mm		X ± 1°	
X.X ± 0.1 mm		X.X ± 0.5°	
X.XX ± 0.05 mm			



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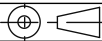
TITLE:

EQUIPMENT : --

DESIGNED : --

DRAWN : --

DRAWING NO.: area

PROJECTION : 

MATERIAL :

WEIGHT : Kg.

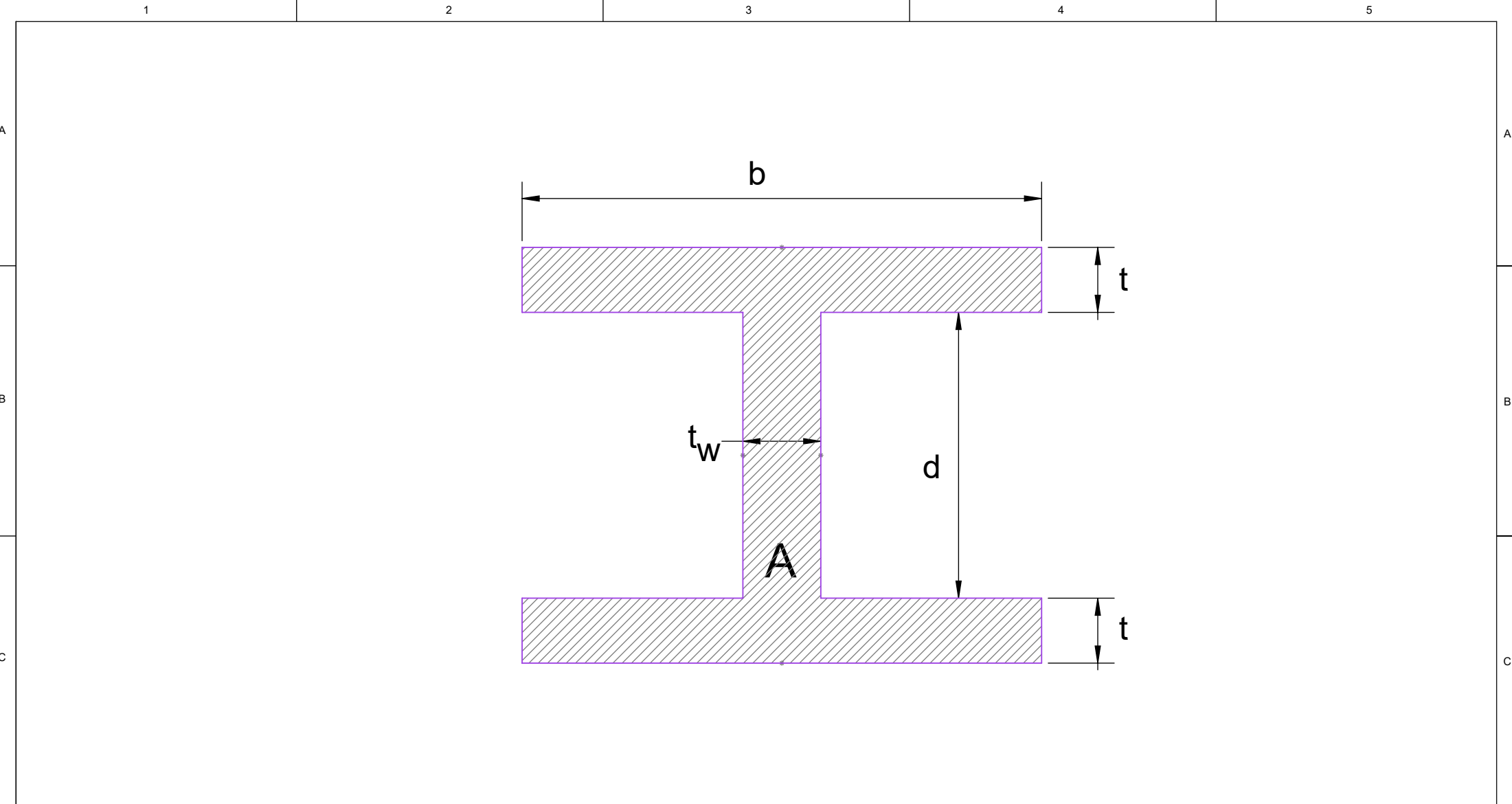
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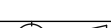
DATE: 03-08-2023

SHEET:4 OF 6

SCALE : 1:20

SHEET SIZE : A4



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		0	APPROVED FOR CONSTRUCTION	03-08-2023	
	ZONE	MARK	PARTICULARS	DATE	
	GENERAL TOLERANCE				
	LINEAR TOLERANCE		ANGULAR TOLERANCE		
	X ± 0.5 mm X.X ± 0.1 mm X.XX ± 0.05 mm		X ± 1° X.X ± 0.5°		

1

2

3

4

5

