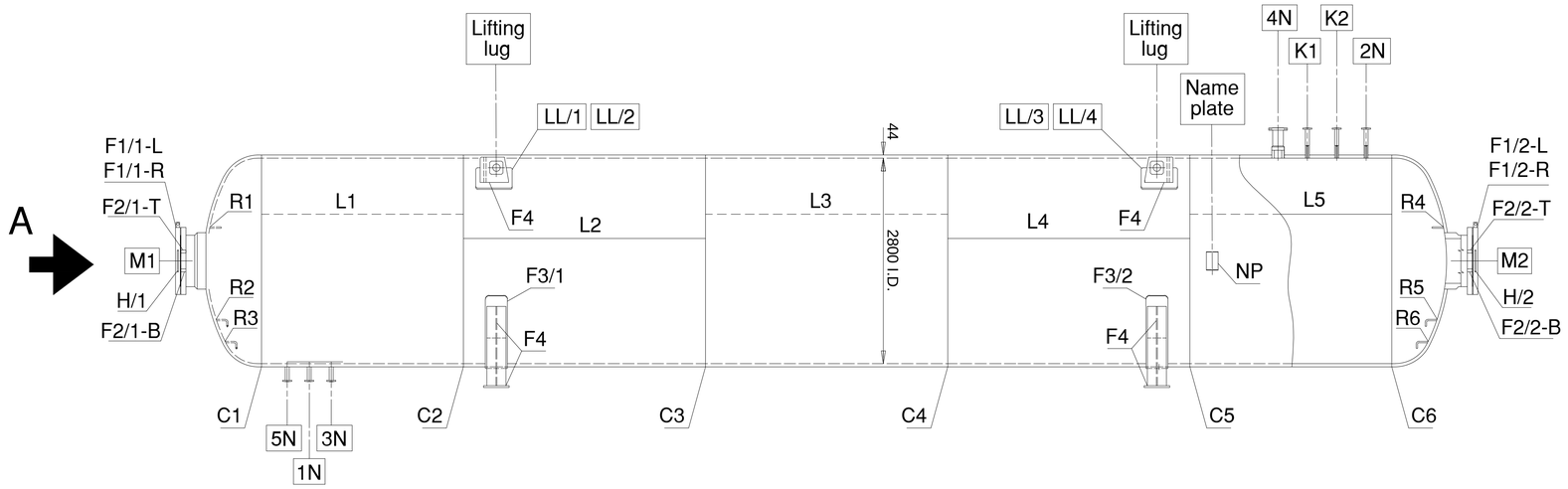
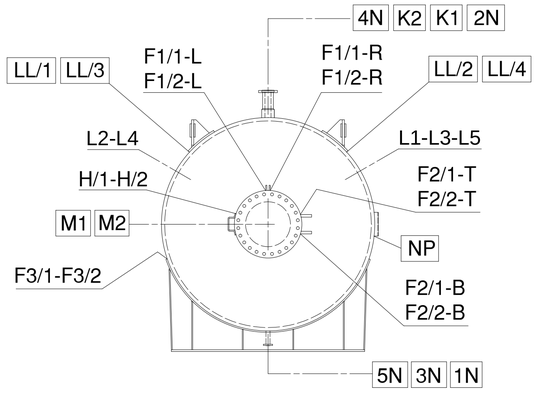
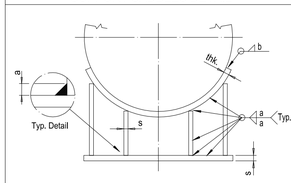




VIEW FROM -A-

SUPPORT SADDLES DETAIL



Ref. to Note 2	"a"= LEG (mm)
s(mm) =< 6	3
6 < s(mm) <= 12	5
12 < s(mm) <= 20	6
s(mm) > 20	8

	"b"= LEG (mm)
thk.(mm)	b=thk./2

NOTES :

1) THIS STANDARD IS APPLICABLE FOR SUPPORT SUBJECT TO COMPRESSIVE LOAD.
2) "s" IS THE THICKER PLATE TO BE JOINTED.

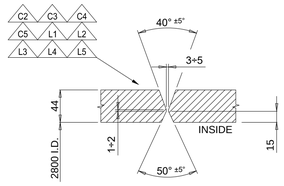
REFERENCE :

1) AWS D1.1/D1.1M : 2015 - Table 5.7
2) Uhde PS-UN V416-01 Part 2 : 2003-02 - ITEM U 8.7

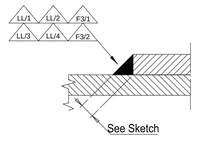
Internal standard for fillet weld

NOTE

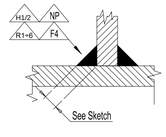
1) FOR EQUIPMENT ASSEMBLY, AND BILL OF MATERIAL WITH GENERAL NOTES SEE DRAWINGS: DWG. 23096-01-EGA1 & DWG. 23096-01-EBM1 .



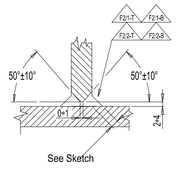
LONGIT. & CIRCUMF. WELDING DETAIL



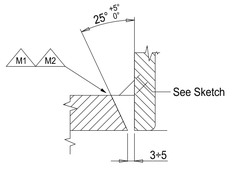
FILLET WELD



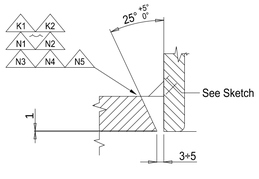
FILLET WELD



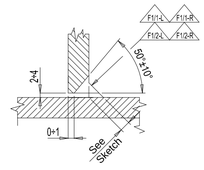
FULL PENETRATION WELDING DETAIL



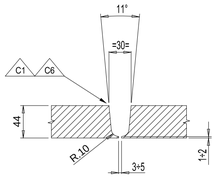
MANHOLE WELDING DETAIL



NOZZLE - SHELL WELDING DETAIL

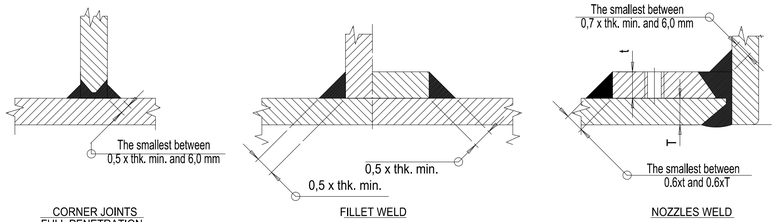


FULL PENETRATION WELDING DETAIL



HEAD CIRCUMF. WELDING DETAIL

SKETCH



Typical weld throat dimensions (if not otherwise quoted on construction drawing)
ASME VIII DIV.2

Date : 30-06-2021
REV.0

FIT-UP MISALIGNMENT TOLERANCES

Table 6.4 (ASME VIII Div.2-2021) 3

Section Thickness, mm	Joint Category A	Joint Category B,C and D
13 (1/2 in.) =< t	t/4	t/4
13 (1/2 in.) < t =< 19 (3/4 in.)	3 mm (1/8 in.)	t/4
19 (3/4 in.) < t =< 38 (1 1/2 in.)	3 mm (1/8 in.)	5 mm (3/16 in.)
38 (1 1/2 in.) < t =< 50 (2 in.)	3 mm (1/8 in.)	t/8
t > 50 (2 in.)	min [t/16, 10mm (3/8 in.)]	min [t/8, 19mm (3/4 in.)]

GENERAL NOTE : t is the nominal thickness of the thinner section at the weld joint.

BREMBANA&ROLLE — VILLA & BONALDI

CLIENT : Rosetti Marino S.p.A.
PROJECT: CROSSWIND HOLLANDE KUST NOORD WIND PARK
PURCHASE ORDER No.: 1723001756 123A90A
LOCATION : NETHERLANDS, 18.5KM OFF THE COAST , NEAR THE TOWN OF EGMOND AAN ZEE.

B&R CAD FILE No: 23096-01-EBM1.dwg
MFR'S S.N. 23096-01-SNA/F
B&R DRAWING No. 23096-01-EWM1

REV.	DATE	DRN	CHKD	APPD	DESCRIPTION
3	14/06/2024	AFG	MT	DG	ACCEPTED FOR CONSTRUCTION (AFC)
2	13/03/2024	AFG	MT	DG	ACCEPTED FOR CONSTRUCTION (AFC)
1	07/03/2024	AFG	MT	DG	ACCEPTED FOR CONSTRUCTION (AFC)
0	05/12/2023	AFG	MT	DG	ISSUE FOR REVIEW (IFR)

CROSSWIND — ROSETTI MARINO

WELDING DETAIL DRAWING
HYDROGEN STORAGE VESSEL ITEM : V-25001A/F

CONTRACT NO. CW-I-WP4-2023-05 / H2 STORAGE — SCALE 1:35

DRAWN A.FRANCO | CHECKED M.TONIOLO | APPROVED D.PASSERINI | DATE 14/06/24

A1 — DRAWING NO. 1723001756-WEL-DD-00014 — SHEET 1 — REV. 3

File Name : 1723001756-WEL-DD-00014.DWG