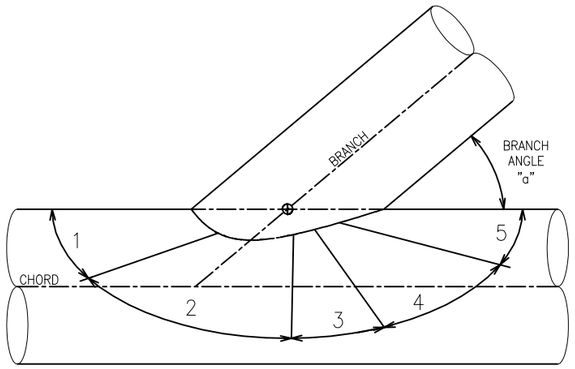
DRAWING NO. 123A90-DDL-ST-DD-90031 REV. 02

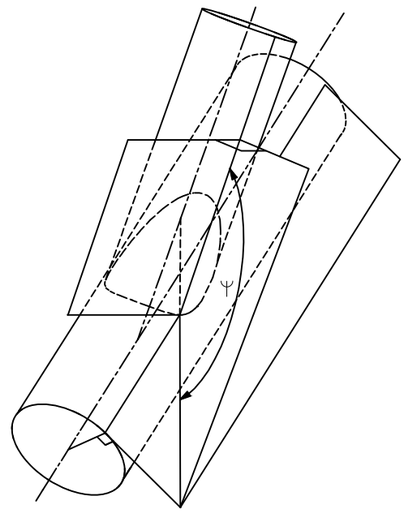
TYPICAL LOCATION OF WELD TYPES



NOTES:

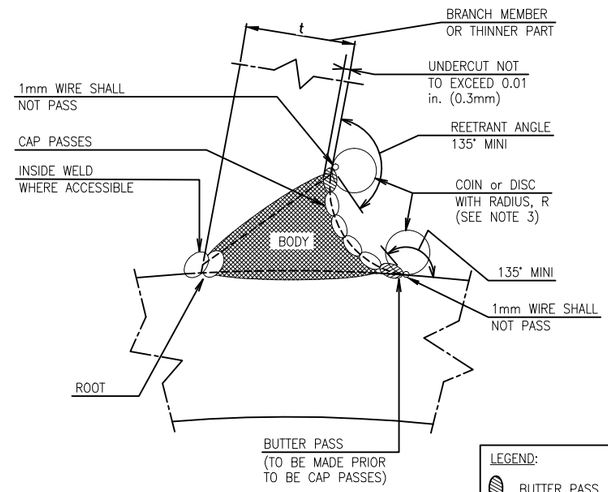
EXAMPLE SHOWING TYPICAL LOCATIONS WHERE THE NUMBERED WELD DETAIL TYPES (1 TO 5) SHALL BE USED ALONG THE LINE OF THE WELD. (TRANSITIONS BETWEEN TYPES SHALL BE GRADUAL)

LOCAL DIHEDRAL



ANGLE " Ψ " IS THE ANGLE FORMED BY THE EXTERIOR SURFACES OF THE BRACE AND CHORD AT ANY POINT ON THEIR JOINT LINE (LOCAL DIHEDRAL ANGLE)

DISC TEST FOR IMPROVED WELD PROFILE CONTROL



SEE NOTES 1 AND 2

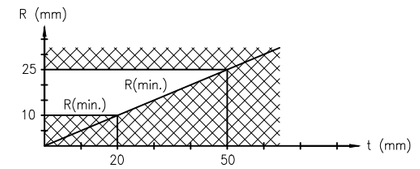
LEGEND:
- BUTTER PASS
- CAP PASS

NOTES:
1 – MPI INDICATION,EXCESSIVE CONVEXITY,OR UNDERCUT IN WELD TOE PASSES OR BETWEEN ADJACENT PASSES SHALL BE CORRECTED BY LIGHT GRINDING.
2 – FINAL GRINDING MARKS SHALL BE TRANSVERSE TO THE LONGITUDINAL WELD AXIS.
3 – THEORETICAL RADIUS R= t/2 ,EXCEPT THAT 10mm ≤ R ≤ 25mm.
4 – THE WHOLE WELD THICKNESS INCLUDING TO SO–CALLED "BACK–UP WELD" IN AWS D1.1 SHALL BE SUBJECT TO INSPECTION CLASS X.
5 – FOR Ψ BETWEEN 30° TO 40° CONTRACTOR TO SELECT WELD TYPE 4, 4 ALTERNATE OR TYPE 5 DEPENDING ON WELDING ACCESSIBILITY.

LEGEND:
a = BRANCH ANGLE WITH CHORD.
b = ANGLE BETWEEN TANGENT LINE TO CHORD AND BEVELLED EDGE OF BRANCH.
T = WELD LENGTH ON CHORD SIDE "T" TO BE AS PER FOLLOWING TABLE UNLESS OTHERWISE NOTED.

Ψ	WELD TYPE	MIN. "T"
155° TO 180°	1	1.75 t
90° TO 155°	2	1.50 t
65° TO 90°	3	1.25 t
30° TO 65°	4	1.50 t
25° TO 40°	5	2.00 t

R = RADIUS AT WELD TOE

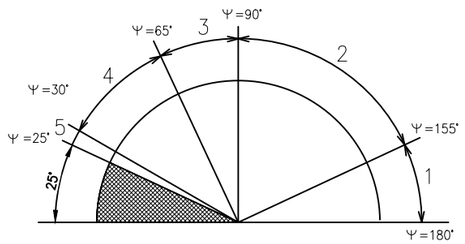


POSSIBLE VALUES OF R VERSUS t
R ≥ t/2 AND 10mm ≤ R ≤ 25mm

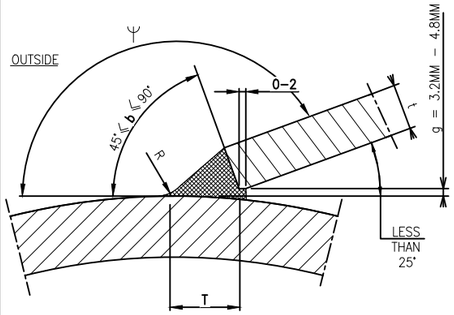
PROHIBITED ZONE FOR R

t = BRANCH THICKNESS
g = ROOT PASS OPENING

WELD TYPE VERSUS Ψ

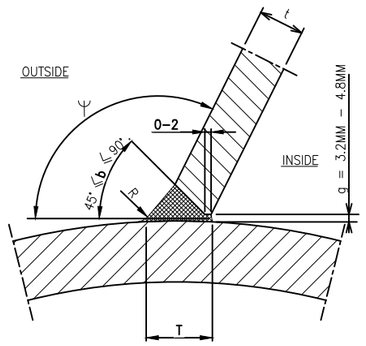


TYPE 1



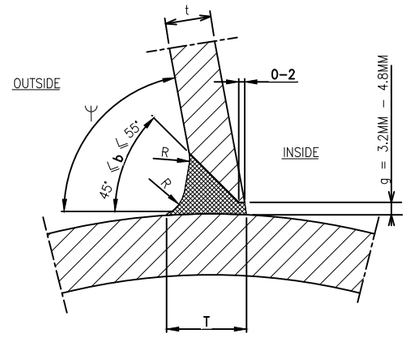
LOCAL DIHEDRAL ∠ 155° ≤ Ψ < 180°

TYPE 2



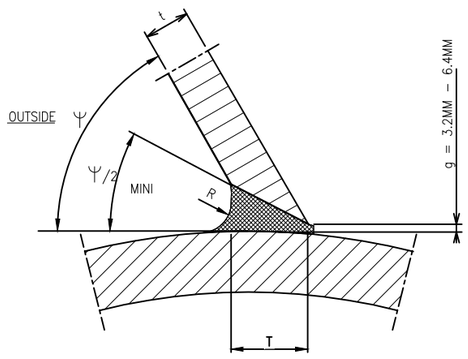
LOCAL DIHEDRAL ∠ 90° ≤ Ψ < 155°

TYPE 3



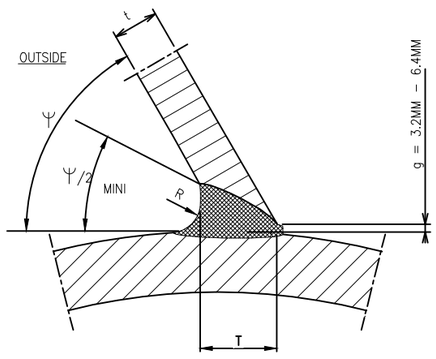
LOCAL DIHEDRAL ∠ 65° ≤ Ψ < 90°

TYPE 4



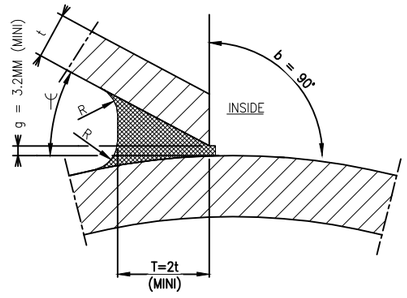
LOCAL DIHEDRAL ∠ 30° ≤ Ψ < 65° NO ROOT FACE

TYPE 4 (ALTERNATE)



LOCAL DIHEDRAL ∠ 30° ≤ Ψ < 65° GROOVE OPENED BY ARC GOUGING

TYPE 5



LOCAL DIHEDRAL ∠ 25° ≤ Ψ < 30°

REV.	DATE	DRN	CHKD	APPD	DESCRIPTION
02	22/09/25	SPS	AB	CGI	AS–BUILT (ASB)
01	31/01/24	SGR	AB	DLS	ACCEPTED FOR CONSTRUCTION (AFC)
00	13/10/23	SGR	AB	DLS	ISSUE FOR REVIEW (IFR)

TECON

CROSSWIND

ROSETTI MARINO

TITLE :
BASE LOAD POWER HUB (BLPH)
STANDARD DRAWINGS
TUBULAR JOINTS – SINGLE SIDED WELDS

CONTRACT NO./TITLE CW-1-WP4-2023-05/HOLLANDSE KUST NOORD WIND PARK | SCALE NTS
DRAWN SPS | CHECKED A.BALZAROTTI | APPROVED CGI | DATE 22/09/25
A1 | DRAWING NO. 123A90-DDL-ST-DD-90031 | SHEET 001 | REV. 02

File Name : 123A90-DDL-ST-DD-90031 REV.02.dwg