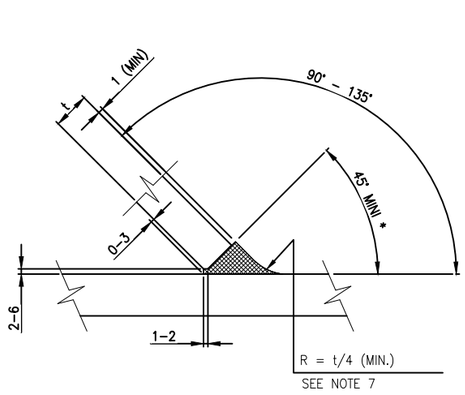
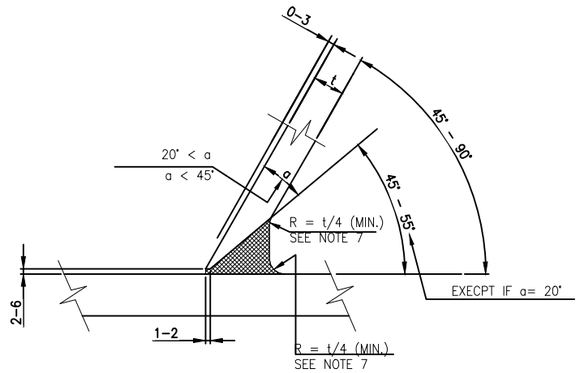
DRAWING NO. 123A90-DDL-ST-DD-90033

REV. 02

DETAIL 1 – T BUTT–PLATE



"T" BUTT (OBTUSE)



"T" BUTT (ACUTE)

* ANGLE VALUE MANDATORY

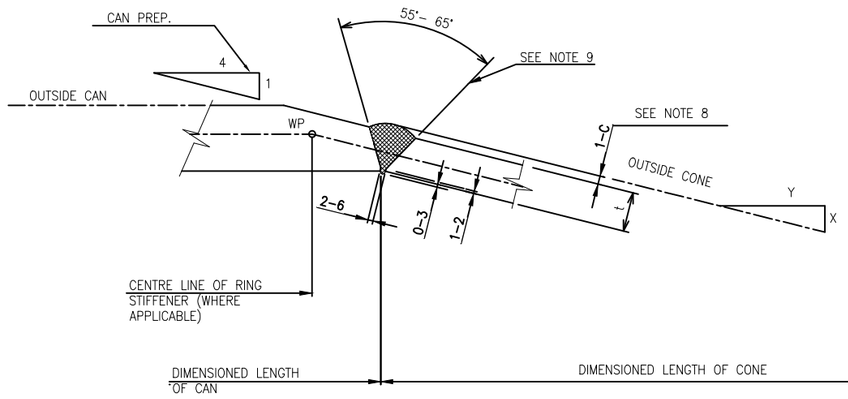
NOTES:

1 – WHERE ACCESS IS UNPRACTICAL OR AS SHOWN ON DESIGN DRAWING, AND AGREED IN WRITING BY COMPANY, SINGLE SIDED WELDS MAY BE USED AS SHOWN ABOVE.
2 – UNLESS NOTED OTHERWISE, ALL STEEL SHALL BE JOINED BY COMPLETE PENETRATION GROOVE WELDS.
3 – WELD DETAILS DESCRIBED ON THESE WELDING DETAIL DRAWINGS ARE APPLICABLE UNLESS EXPLICITLY NOTED OTHERWISE ON THE DESIGN DRAWINGS.
4 – DETAILS SHOWN ARE APPROPRIATE FOR SMAW OR S.A.W. PROCESSES ONLY.
IF OTHER WELDING PROCESSES ARE ALLOWED BY COMPANY DIMENSIONS, ANGLES AND TOLERANCES MAY BE REVISED SUBJECT TO AGREEMENT BY THE COMPANY.
5 – DIMENSIONS AND ANGLES OF WELDING PREPARATIONS MAY BE SUBJECT TO VARIATION DEPENDING ON WELDING PROCEDURES AGREED WITH THE COMPANY.
6 – ALL WELD PROFILES SHALL CONFORM TO THE REQUIREMENTS OF THE APPROPRIATE FABRICATION SPECIFICATION.
7 – WELD PROFILE RADII INDICATE THE REQUIRED AVERAGE AS WELDED SHAPE ONLY AND DO NOT CALL FOR SURFACE GRINDING UNLESS SPECIFIED ELSEWHERE.
8 – THE MAXIMUM BUTT WELD REINFORCEMENT "C" SHALL NOT EXCEED THE FOLLOWING VALUES :

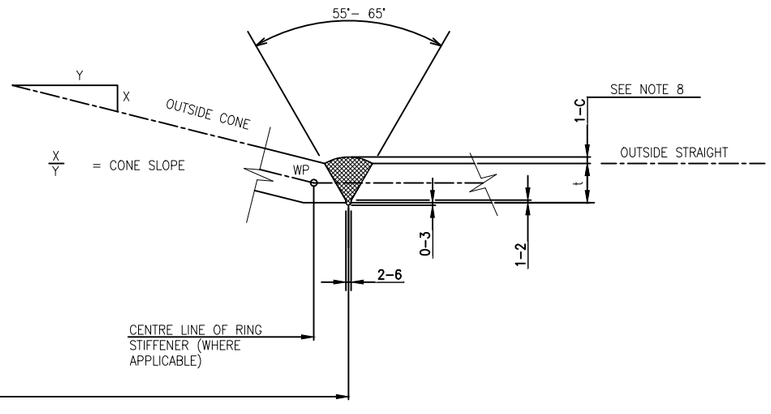
PLATE THICKNESS t (mm)	C (mm)
6 < t < 25	3
25 < t < 50	4
50 < t	5

9 – ALL BEVELS SHALL BE INDIVIDUALLY 20°, 30°, 45° WITH REGARD TO THE UT INSPECTION SURFACE.

DETAIL 4 – CONE TO TUBE



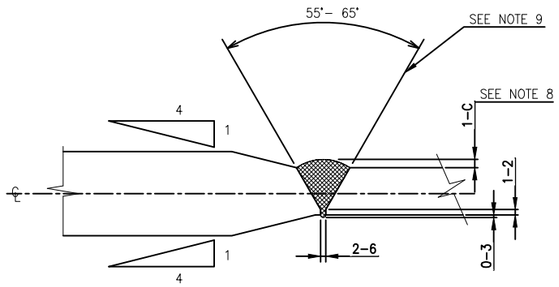
CAN TO CONE



CONE TO STRAIGHT

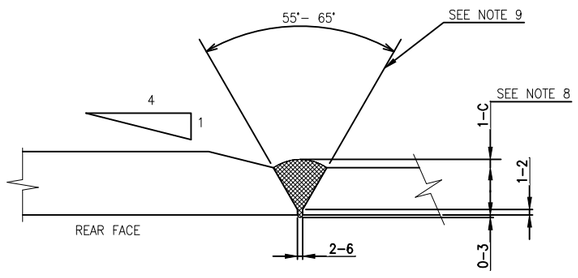
DETAIL 2 – UNEQUAL THICKNESS BUTT– MATCHING CENTER LINES

PLATE OR TUBE BUTT

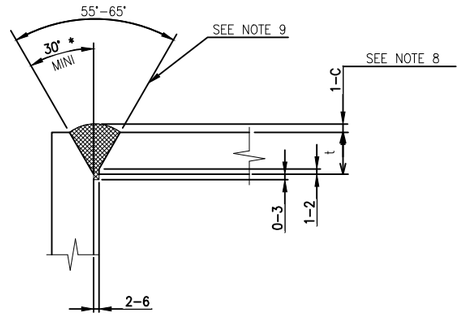


DETAIL 3 – UNEQUAL THICKNESS BUTT– MATCHING REAR SURFACE

PLATE OR TUBE



DETAIL 5 – CORNER



* ANGLE VALUE MANDATORY

TECON

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)

CROSSWIND

ROSETTI MARINO

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

CONTRACT NO./TITLE CW–I–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–90033	SHEET 001	REV. 02

File Name : 123A90-DDL-ST-DD-90033 REV.02.dwg