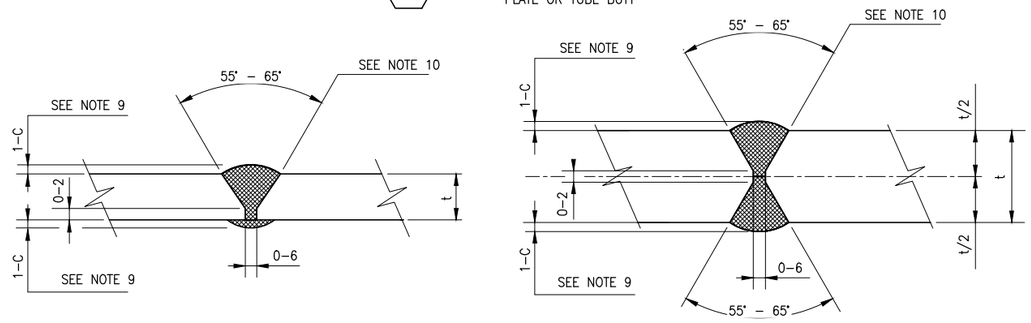
DRAWING NO. 123A90-DDL-ST-DD-90032

REV. 01

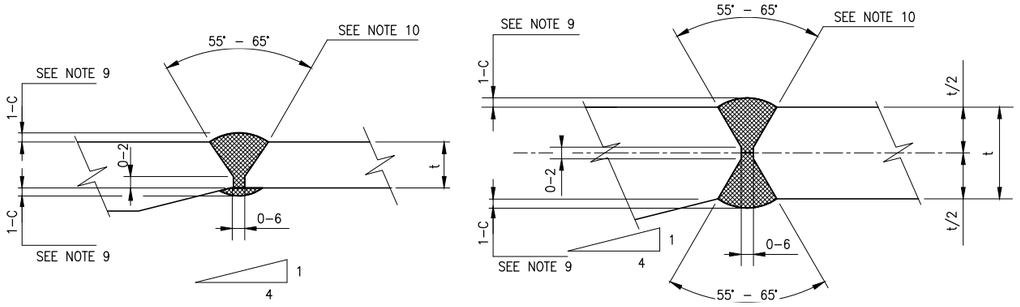
DETAIL 1 – EQUAL THICKNESS BUTT

PLATE OR TUBE BUTT



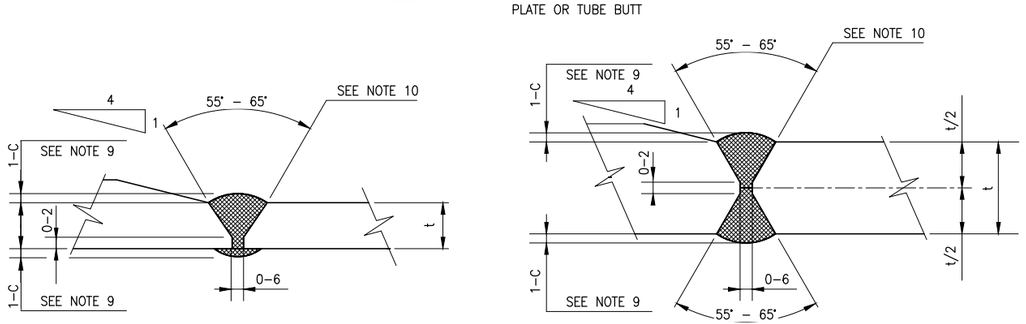
DETAIL 2 – UNEQUAL THICKNESS BUTT– MATCHING FRONT SURFACE

PLATE OR TUBE BUTT



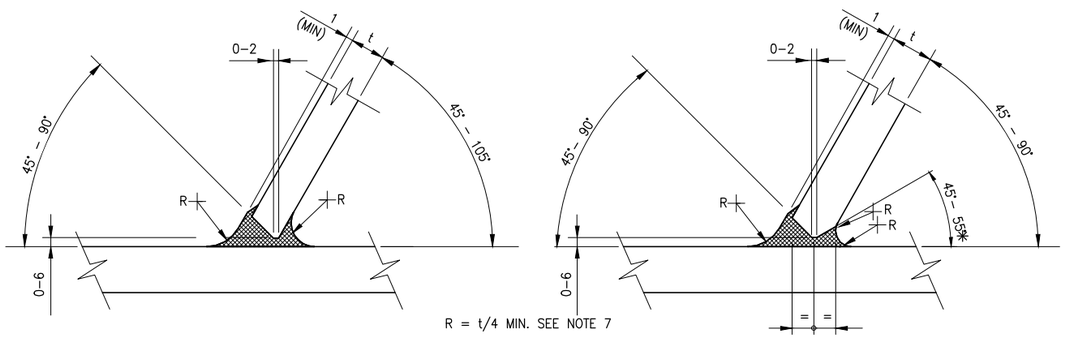
DETAIL 3 – UNEQUAL THICKNESS BUTT– MATCHING REAR SURFACE

PLATE OR TUBE BUTT



DETAIL 4 – T BUTT–PLATE

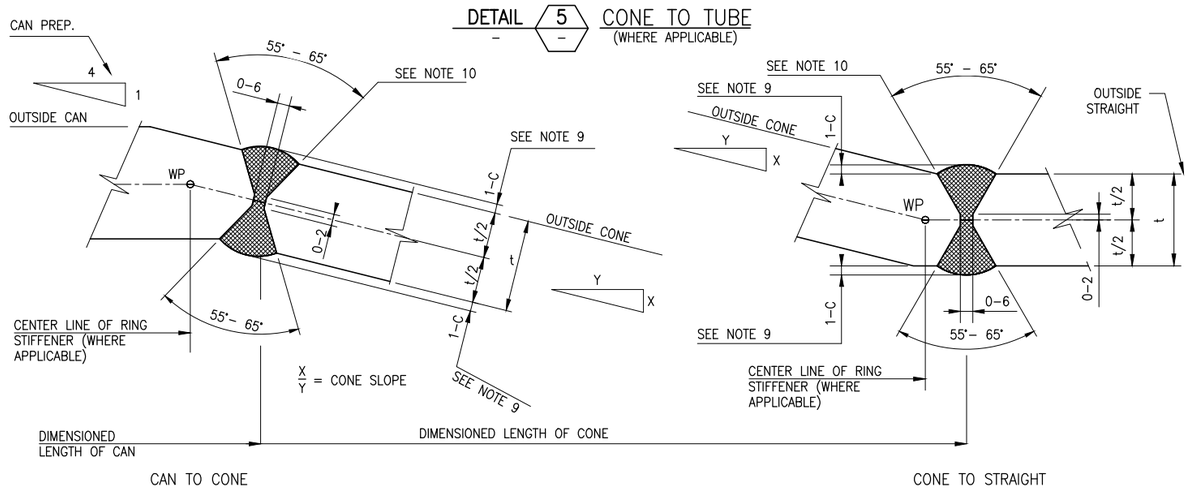
* ANGLE VALUE MANDATORY



R = t/4 MIN. SEE NOTE 7

DETAIL 5 – CONE TO TUBE

(WHERE APPLICABLE)



CAN TO CONE

CONE TO STRAIGHT

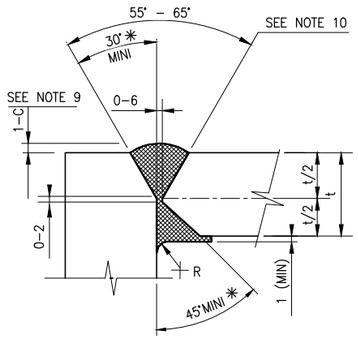
GENERAL NOTES:

1 – ALL GROOVE WELDS SHALL BE WELDED FROM BOTH SIDES UNLESS AGREED IN WRITING BY COMPANY TO BE IMPRACTICAL OR UNLESS SHOWN AS WELDED FROM ONE SIDE ONLY ON THE DESIGN DRAWINGS.
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 – BALANCED WELD PREPARATIONS ARE RECOMMENDED FOR T > 20 mm.
9 – 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

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

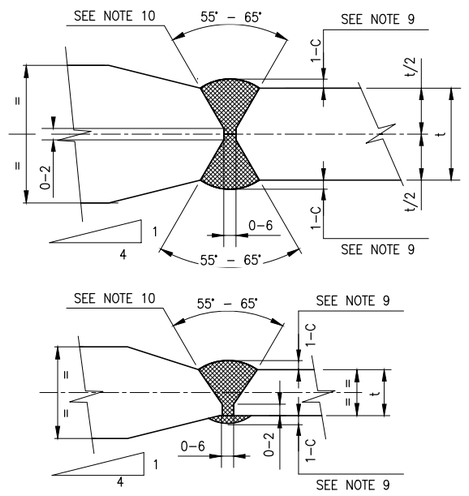
DETAIL 6 – CORNER



* ANGLE VALUE MANDATORY R = t/4 MIN. SEE NOTE 7

DETAIL 7 – UNEQUAL THICKNESS BUTT– MATCHING CENTER LINE

PLATE OR TUBE BUTT



REV.	DATE	DRN	CHKD	APPD	DESCRIPTION
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
PLATES – DOUBLE SIDED WELDS

CONTRACT NO./TITLE CW-I-WP4-2023-05/HOLLANDSE KUST NOORD WIND PARK			SCALE NTS
DRAWN S.GRIFFINI	CHECKED A.BALZAROTTI	APPROVED D.LO STERZO	DATE 31/01/24
A1	DRAWING NO. 123A90-DDL-ST-DD-90032	SHEET 001	REV. 01

File Name : 123A90-DDL-ST-DD-90032_01.dwg