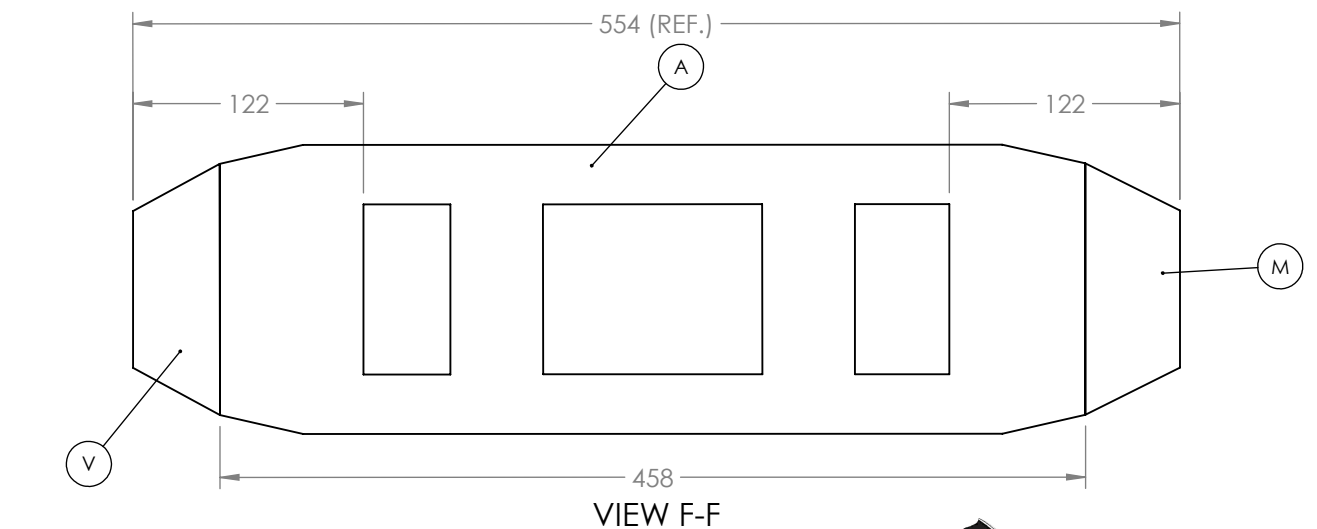
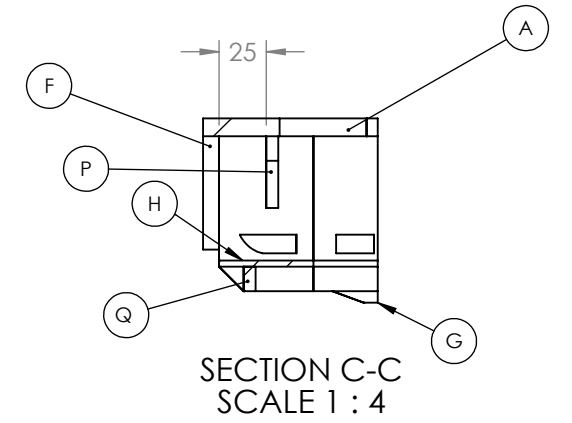
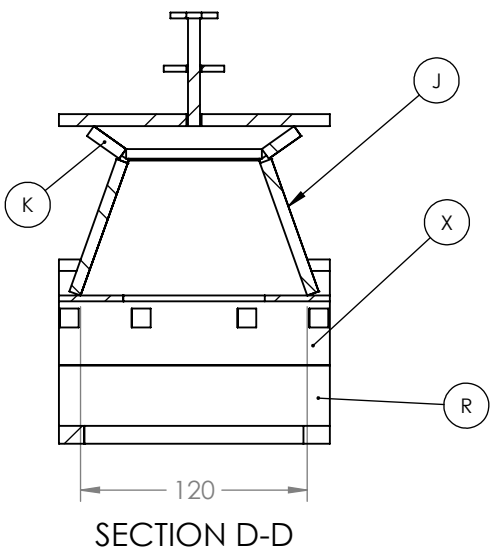
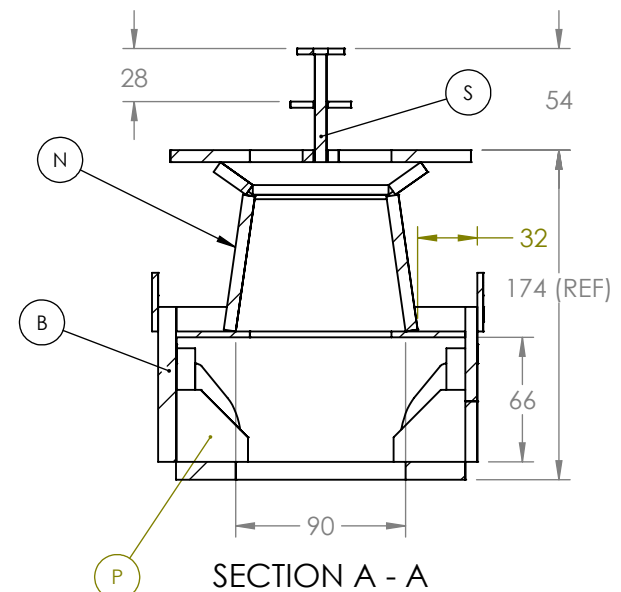
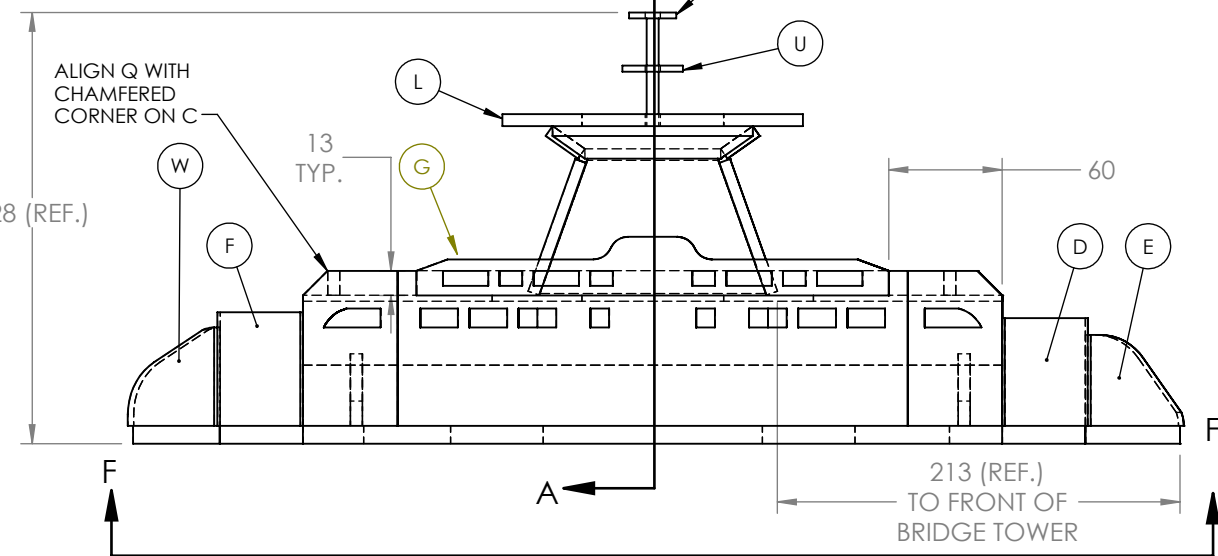
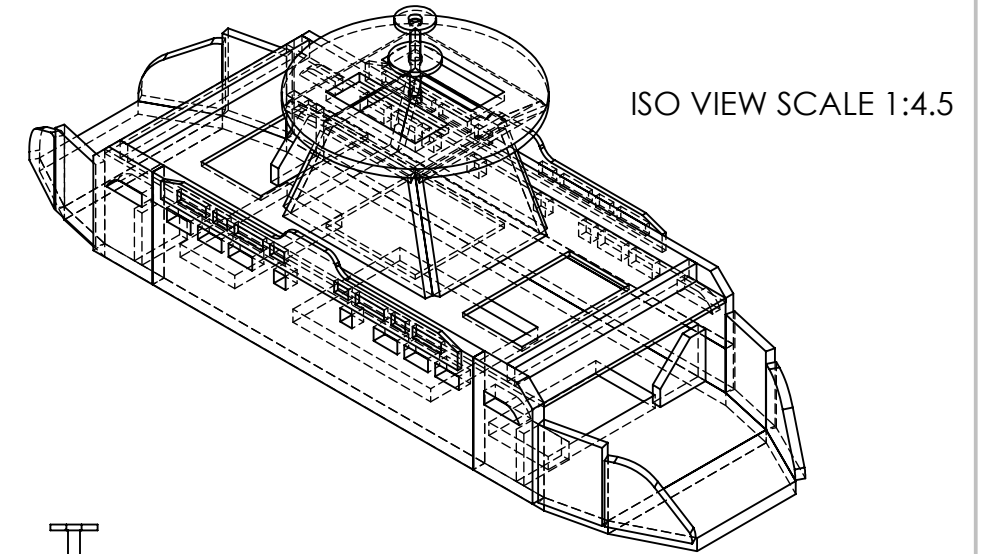
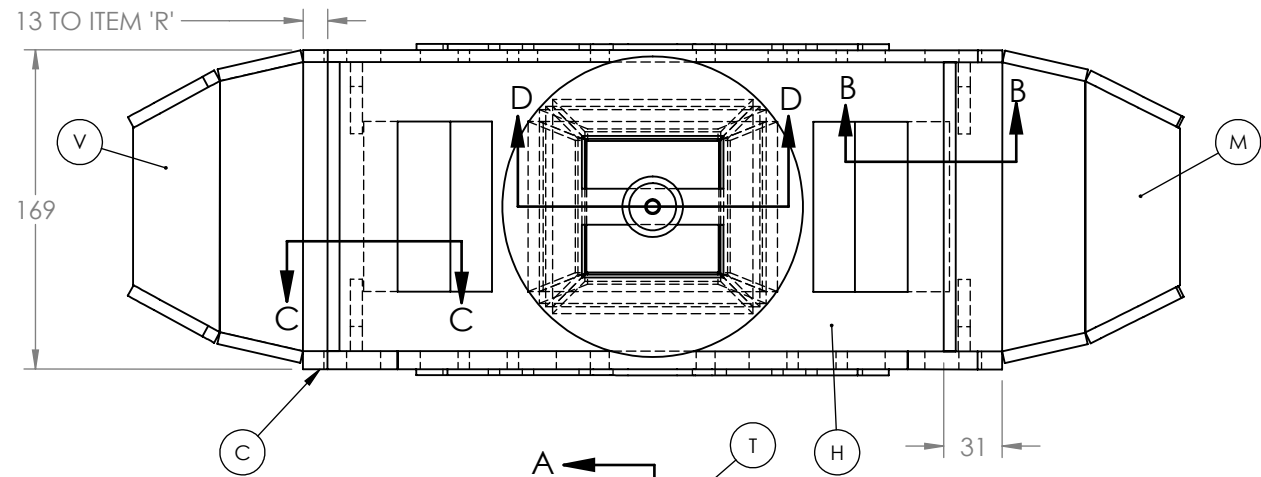


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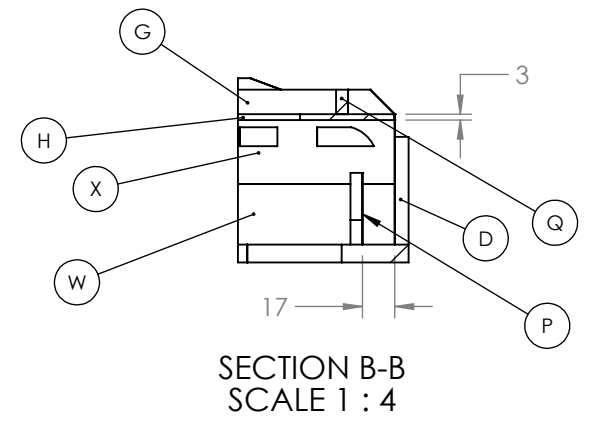
3

2

1



NOTE:  
 ALL DIMENSIONS IN MILLIMETERS / KILOGRAMS  
 ALL MATERIAL MILD STEEL  
 SEE OTHER SHEETS FOR DETAIL SKETCHES, WELDING SYMBOLS AND DIMENSIONS  
 TIME: 6 HOURS



<b>TITLE:</b> 2022 SCAVC - SECONDARY SALISH RAVEN - GENERAL ARRANGEMENT				<b>SHEET #:</b> 1 OF 4	<b>SIZE:</b> B
<b>DWG. NO.:</b> SC2020-SP-1	<b>REV.:</b> 3	<b>SCALE:</b> 1:5	<b>DRAWN BY:</b> J. HYDE	<b>DATE:</b> 2020-02-10	

4

3

2

1

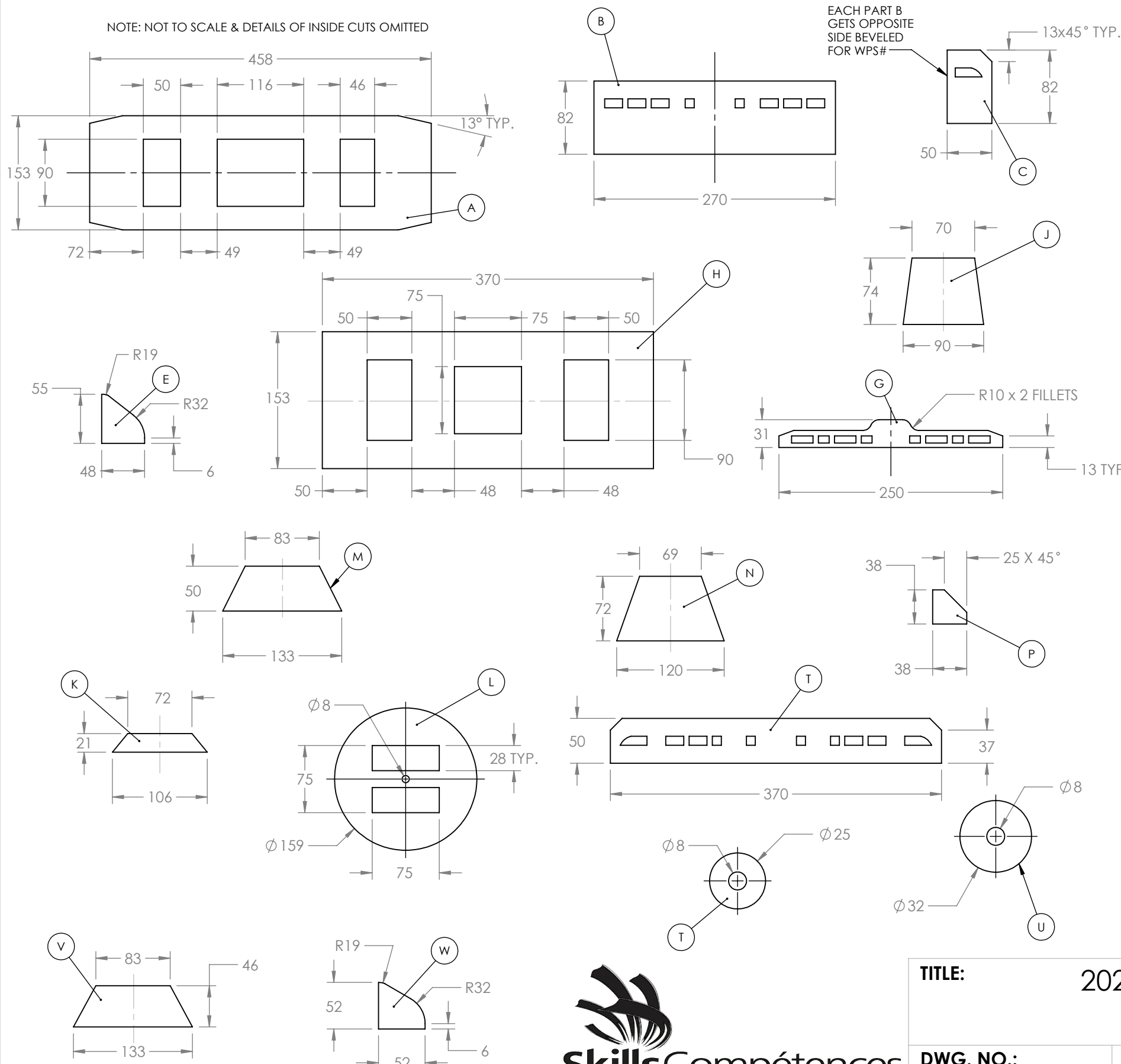
4

3

2

1

NOTE: NOT TO SCALE & DETAILS OF INSIDE CUTS OMITTED



EACH PART B GETS OPPOSITE SIDE BEVELED FOR WPS#

### BILL OF MATERIALS

ITEM	DESCRIPTION & SIZES (mm)				QTY	WEIGHT (kg)	NOTE
	Shape	T	W	L			
A	PL	9.5	153	458	1	5.24	SHAPE/BEVEL
B	PL	9.5	82	270	1	1.66	BEVEL
C	PL	9.5	50	82	2	0.61	SHAPE/BEVEL
D	PL	6.4	45	57	2	0.26	BEVEL
E	PL	6.4	48	55	2	0.26	SHAPE
F	PL	6.4	45	60	2	0.27	BEVEL
G	PL	3.2	31	250	2	0.39	SHAPE
H	PL	3.2	153	370	1	1.41	SHAPE
J	PL	6.4	74	90	2	0.66	SHAPE
K	PL	6.4	21	106	4	0.44	SHAPE
L	PL	6.4	ø159		1	1.26	SHAPE
M	PL	9.5	50	133	1	0.50	SHAPE/BEVEL
N	PL	6.4	72	120	2	0.86	SHAPE
P	PL	6.4	38	38	4	0.29	SHAPE
Q	PL	6.4	13	153	2	0.20	
R	PL	6.4	32	370	1	0.59	
S	BAR	ø3.2 -ROUND		57	1	0.01	@0.22 kg/m
T	PL	3.2	ø25		1	0.02	SHAPE
U	PL	3.2	ø32		1	0.03	SHAPE
V	PL	9.5	46	133	1	0.46	SHAPE/BEVEL
W	PL	6.4	52	52	2	0.27	SHAPE/BEVEL
X	PL	6.4	50	370	1	0.92	SHAPE/BEVEL
Y							
<b>TOTAL WEIGHT</b>						<b>16.6</b>	<b>kg</b>

ALL DIMENSIONS IN MILLIMETERS



<b>TITLE:</b> 2022 SCAVC - SECONDARY SALISH RAVEN - PARTS				<b>SHEET #:</b> 2 OF 4	<b>SIZE:</b> B
<b>DWG. NO.:</b> SC2020-SP-1	<b>REV.:</b> 3	<b>SCALE:</b> NTS	<b>DRAWN BY:</b> J. HYDE	<b>DATE:</b> 2020-02-10	
				PARTS SKETCH PROFILE VIEWS	

4

3

2

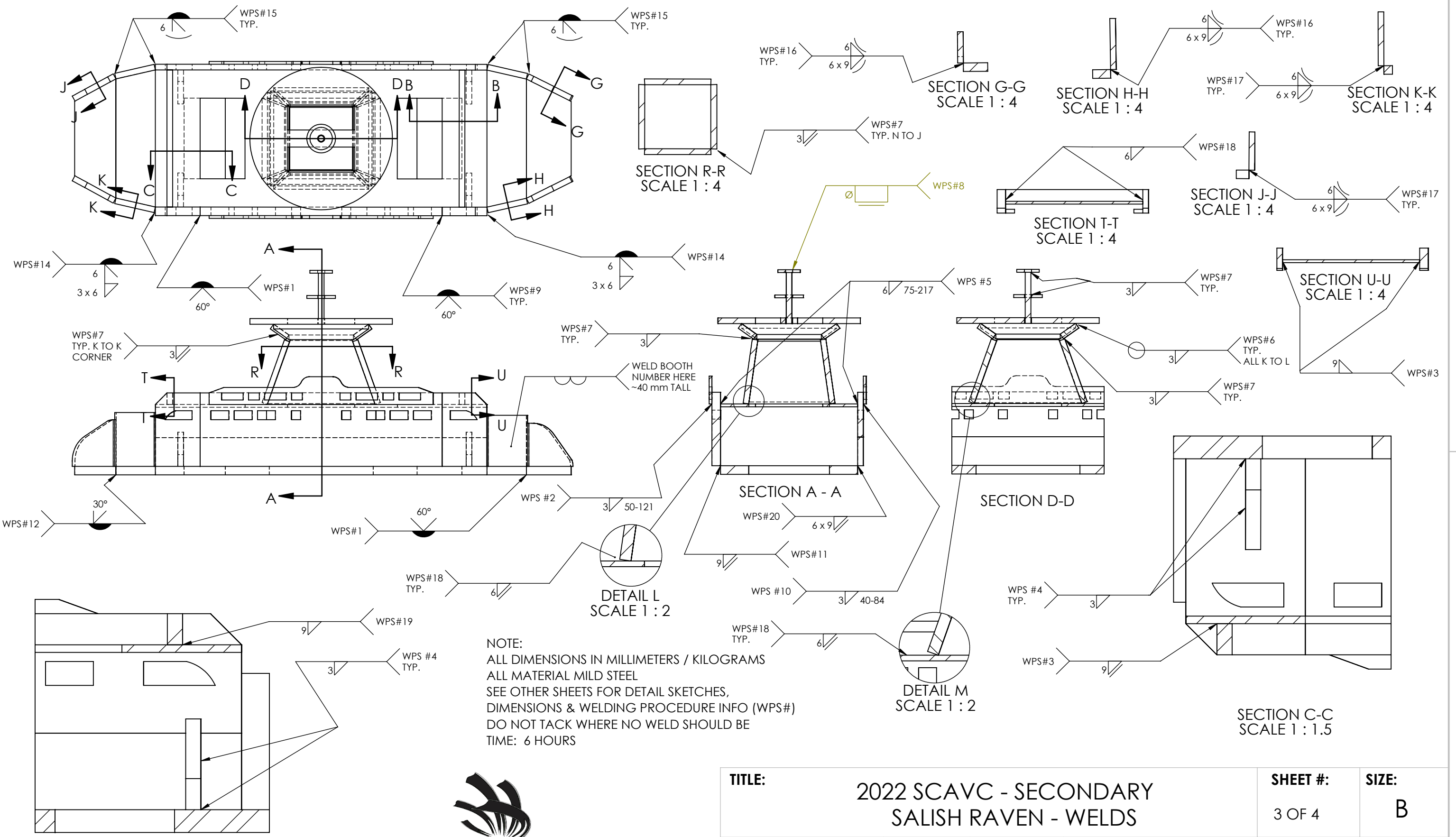
1

4

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2

1



NOTE:  
 ALL DIMENSIONS IN MILLIMETERS / KILOGRAMS  
 ALL MATERIAL MILD STEEL  
 SEE OTHER SHEETS FOR DETAIL SKETCHES,  
 DIMENSIONS & WELDING PROCEDURE INFO (WPS#)  
 DO NOT TACK WHERE NO WELD SHOULD BE  
 TIME: 6 HOURS



<b>TITLE:</b> 2022 SCAVC - SECONDARY SALISH RAVEN - WELDS				<b>SHEET #:</b> 3 OF 4	<b>SIZE:</b> B
<b>DWG. NO.:</b> SC2020-SP-1	<b>REV.:</b> 3	<b>SCALE:</b> 1:5	<b>DRAWN BY:</b> J. HYDE	<b>DATE:</b> 2020-02-10	

4

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2

1

# WELDING PROCEDURE SPECIFICATIONS

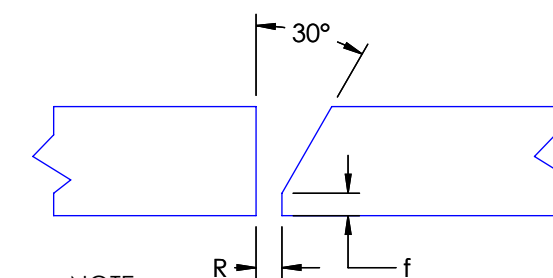
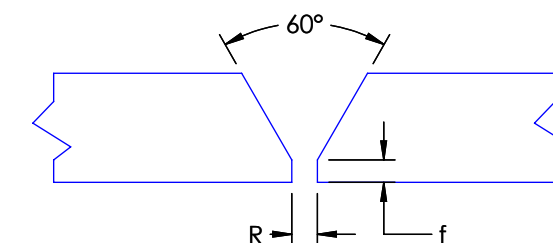
WPS#	TYPE(S)	SIZE(S)	PROCESS(ES)	ELECTRODE / FILLER	POSITION(S)	NOTE
1	VEE*	9	SMAW	E4310 ROOT / E4918 FILL	1G / 3G	MELT-THROUGH
2	FILLET	3	GMAW	ER49S-6	4F	INTERMITTENT
3	FILLET	9	SMAW	E4918	2F	FLAT
4	FILLET	3	SMAW	E4918	2F	
5	FILLET	6	SMAW	E4918	2F	INTERMITTENT
6	FILLET	3	GMAW	ER49S-6	4F	
7	FILLET	3	GMAW	ER49S-6	3F	
8	PLUG	N/S	GMAW	ER49S-6	FLAT	
9	VEE GROOVE*	9	GMAW	ER49S-6	3G	MELT-THROUGH
10	FILLET	3	GMAW	ER49S-6	2F	INTERMITTENT
11	FILLET	9	SMAW	E4918	4F	FLAT PROFILE
12	BEVEL GROOVE*	9	GMAW	ER49S-6	1G	MELT-THROUGH
13	BEVEL GROOVE*	6	GMAW	ER49S-6	3G	MELT-THROUGH
14	BEVEL/FILLET	3 / 6	SMAW	E4918	3G/3F	NO PREP / MELT-THROUGH
15	BEVEL GROOVE*	6	SMAW	E4918	3G	MELT-THROUGH, CONVEX
16	FILLET	6 / 6X9	SMAW	E4918	2F / 4F	FILLETS BOTH SIDES, UNEQUAL LEGS TO THICKNESS OF PLATE
17	FILLET	6 / 6X9	GMAW	ER49S-6	2F / 4F	FILLETS BOTH SIDES, UNEQUAL LEGS TO THICKNESS OF PLATE
18	FILLET	6	GMAW	ER49S-6	2F	FLAT
19	FILLET	9	GMAW	ER49S-6	2F	
20	FILLET	6 X 9	GMAW	ER49S-6	4F	FLAT

**NOTE:**

- ALL WELDING MUST BE DONE WITH BASE PLATE "A" SITTING FLAT ON TABLE
- TACK ENTIRE PROJECT PRIOR TO STARTING WELDS, YOU MUST OBTAIN A SIGN-OFF FROM THE TECHNICAL COMMITTEE AFTER FITTING AND BEFORE WELDING
- GAP AND LAND FOR PREPARED VEE AND BEVEL GROOVE WELDS --> YOUR CHOICE
- ALL VERTICAL WELDING TO BE DONE IN UPHILL PROGRESSION, UNLESS OTHERWISE NOTED

**PREPARED GROOVE DIMENSIONS**

\* = UNLESS OTHERWISE NOTED, ALL BEVEL AND VEE PREPARATIONS AS FOLLOWS:



NOTE: **R** and **f** are prepared to the preference of the competitor. The dimension for the plates shown in (Sheet 1 and 2) is to a feathered edge and any root gap must be accommodated in overall fitting dimensions.



<b>TITLE:</b> 2022 SCAVC - SECONDARY SALISH RAVEN - WELDING PROCEDURES (WPS)			<b>SHEET #:</b> 4 OF 4	<b>SIZE:</b> B
<b>DWG. NO.:</b> SC2020-SP-1	<b>REV.:</b> 3	<b>SCALE:</b> NTS	<b>DRAWN BY:</b> J. HYDE	<b>DATE:</b> 2020-02-10

