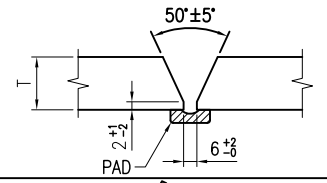
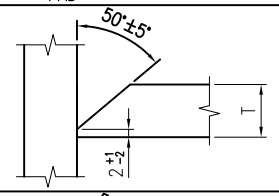
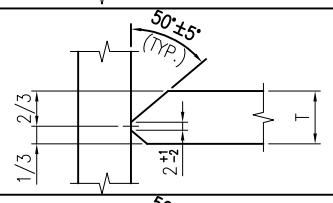
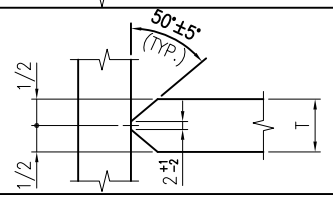
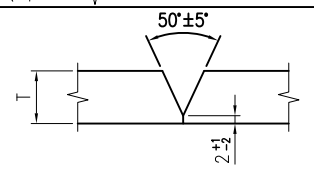
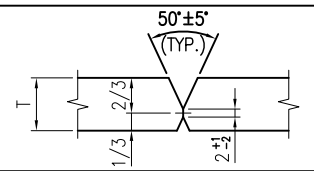
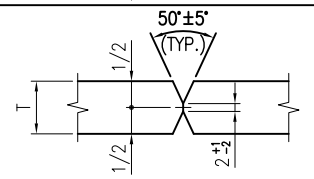
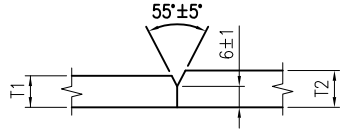
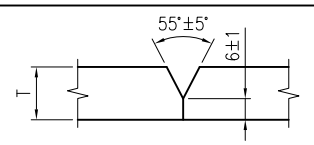
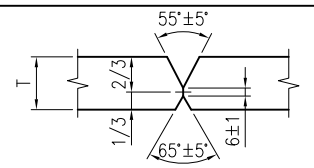
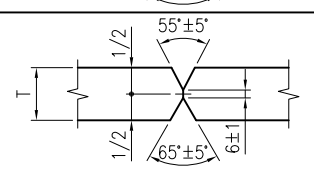
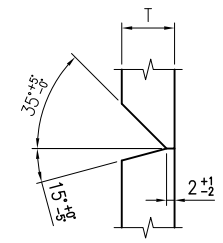
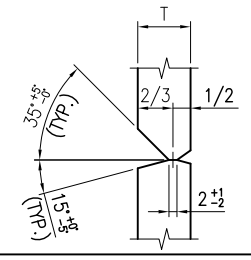
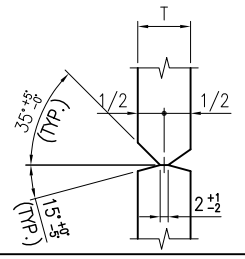
YTRS315-111-F12C

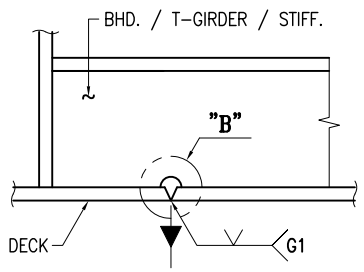
AUTOMATIC , SEMI AUTOMATIC & MANUAL WELDING DETAIL

TYPE	THICKNESS	DESCRIPTION
G1 FCAW-G	6 ≤ T ≤ 30 (T > 30 : APPLICATION TO G3)	
G2 FCAW-G or SMAW	6 ≤ T ≤ 16	
	16 < T ≤ 40	
	T > 40	
G3 FCAW-G or SMAW	6 ≤ T ≤ 16	
	16 < T ≤ 40	
	T > 40	
G4 SAW	T1 = 10 T2 = 12	
	11 ≤ T ≤ 20	
	20 < T ≤ 40	
	T > 40	

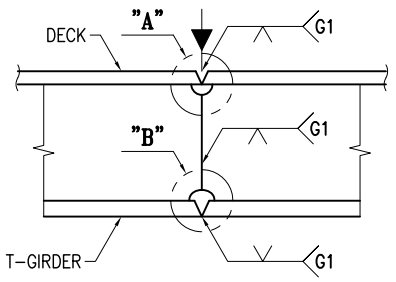
TYPE	THICKNESS	DESCRIPTION
G5 FCAW-G or SMAW (ONLY FOR THE VERTICAL POSITION OF BUTT WELD)	6 ≤ T ≤ 16	
	16 < T ≤ 40	
	T > 40	

BLOCK BUTT JOINT DETAIL

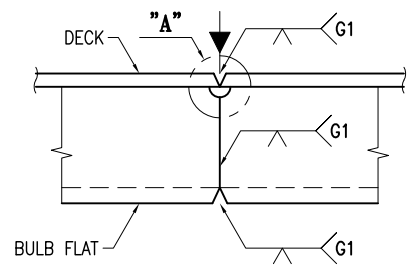
-CASE A



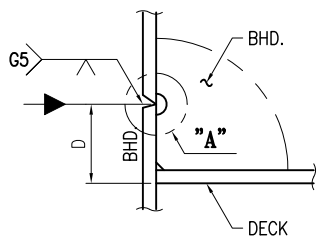
-CASE B



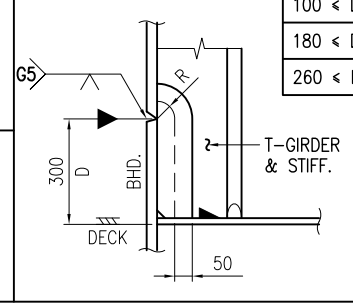
-CASE C



-CASE D

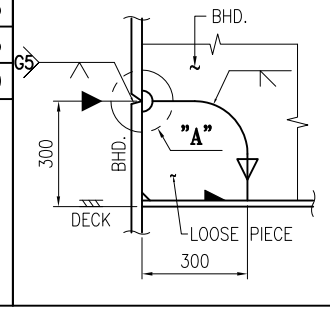


-CASE E



D	R
100 ≤ D < 180	R25
180 ≤ D < 260	R35
260 ≤ D	R50

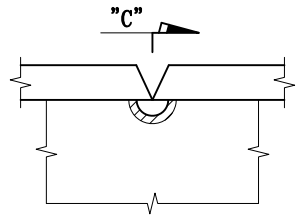
-CASE F



WELDING ACCESS DETAIL

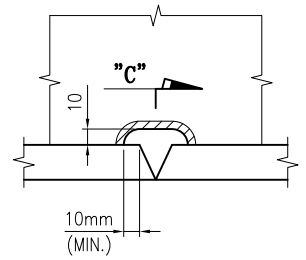
"A" DETAIL

-ASSEMBLE CLOSED HOLE BY WELDING

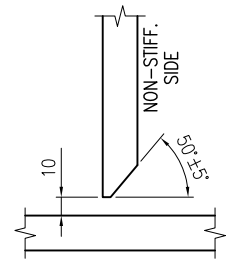


"B" DETAIL

-ASSEMBLE CLOSED HOLE BY WELDING

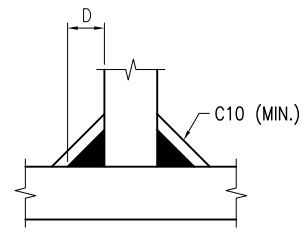


"C" SECTION



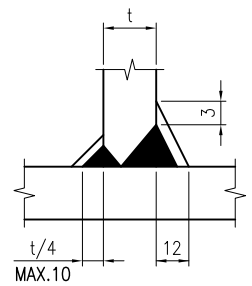
CHAMFER DETAIL

-FILLET

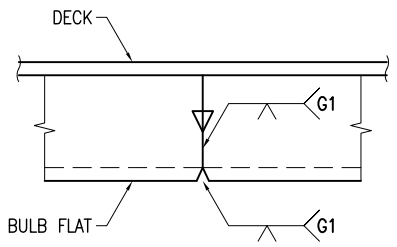


WELD SIZE	CHAMFERING
5 ~ 7	10
8 ~ 12	15
13 ~ 17	20
18 ~	S + 3

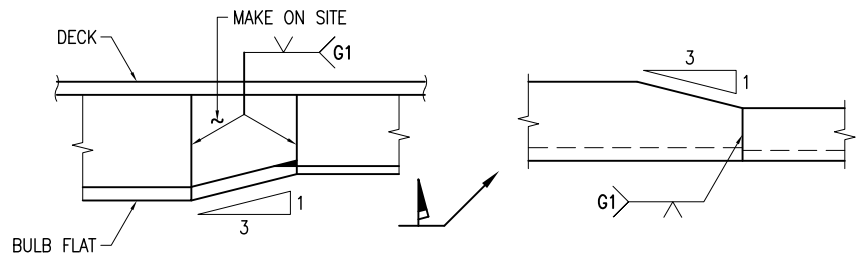
-FULL PENETRATION



BULB FLAT BUTT END GROOVE DETAIL



BULB FLAT SPLICE DETAIL



DRAWN			SCALE	DRAWING NO.	REV
CHECKED			1:90	YTRS315-111-F12C	0
MANAGER				SHEET 2 OF 51	A3
APPROVED					