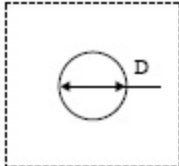
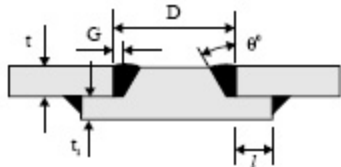
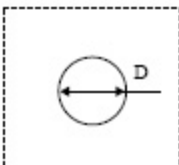
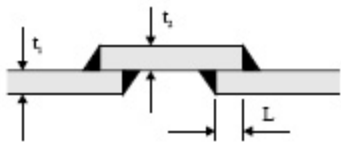


TABLE 9.11 - ERRONEOUS HOLE REPAIR

Detail	Repair standard	Remarks
<p>Holes made erroneously $D < 200$ mm</p> 	<p>Strength members open hole to minimum 75 mm dia., fit and weld spigot piece</p>  <p> $\theta = 30^\circ - 40^\circ$ $G = 4 - 6$ mm $1/2 t \leq t_1 \leq t$ $l = 50$ mm </p> <p>OR open hole to over 300 mm and fit insert plate</p>	<p>Fillet weld to be made after butt weld</p> <p>The fitting of spigot pieces in areas of high stress concentration or fatigue is to be approved by the Classification Society</p>
<p>Holes made erroneously $D > 200$ mm</p> 	<p>Strength members open hole to over 300 mm and fit insert plate</p> <p>Other members open hole to over 300 mm and fit insert plate OR fit lap plate</p>  <p> $t_1 = t$ $L = 50$ mm, min </p>	