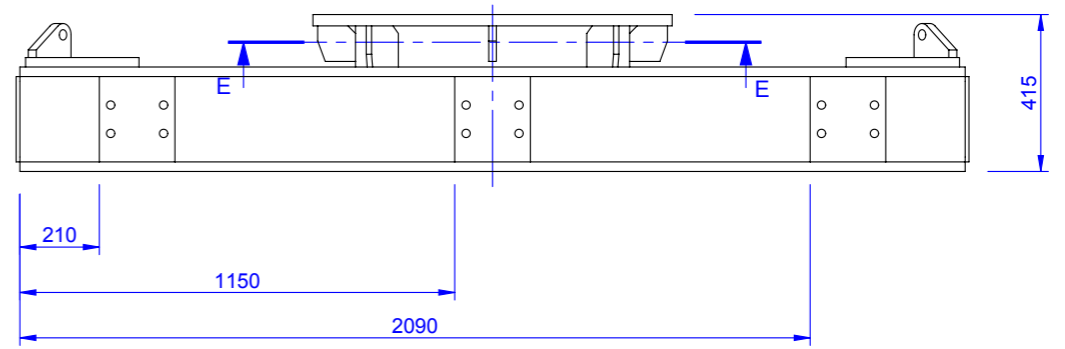
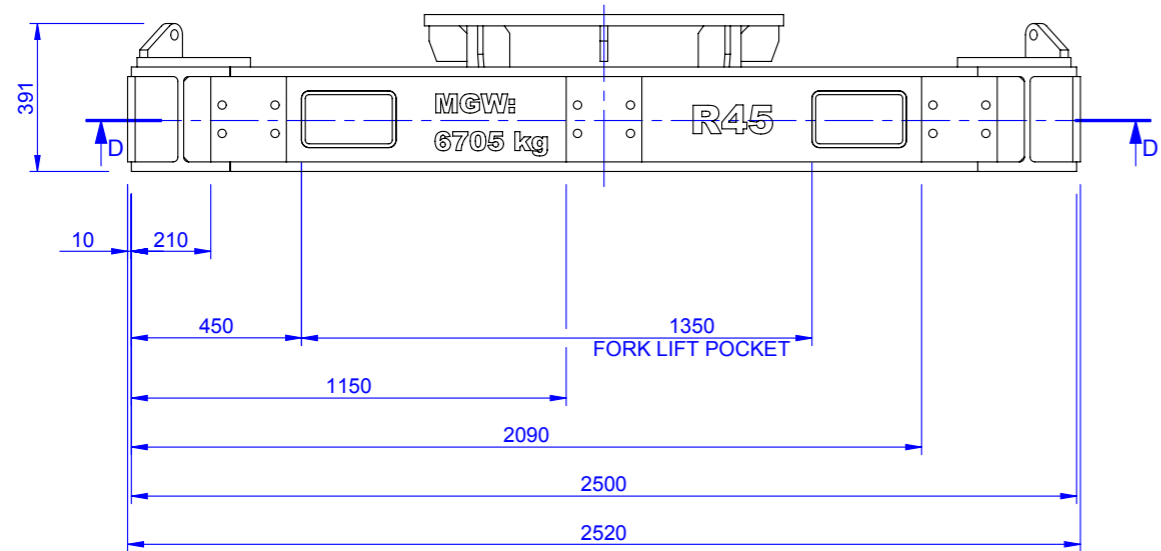
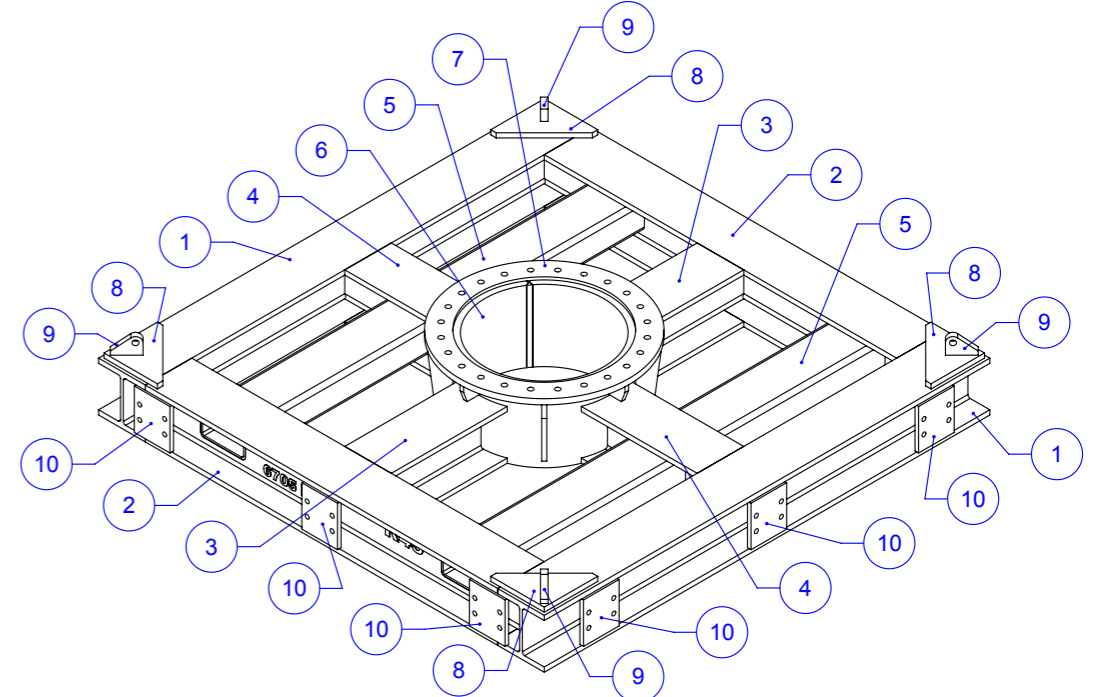
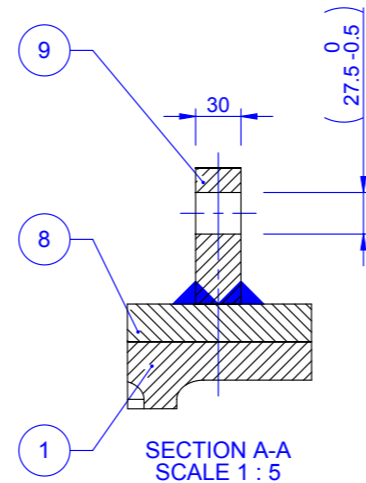
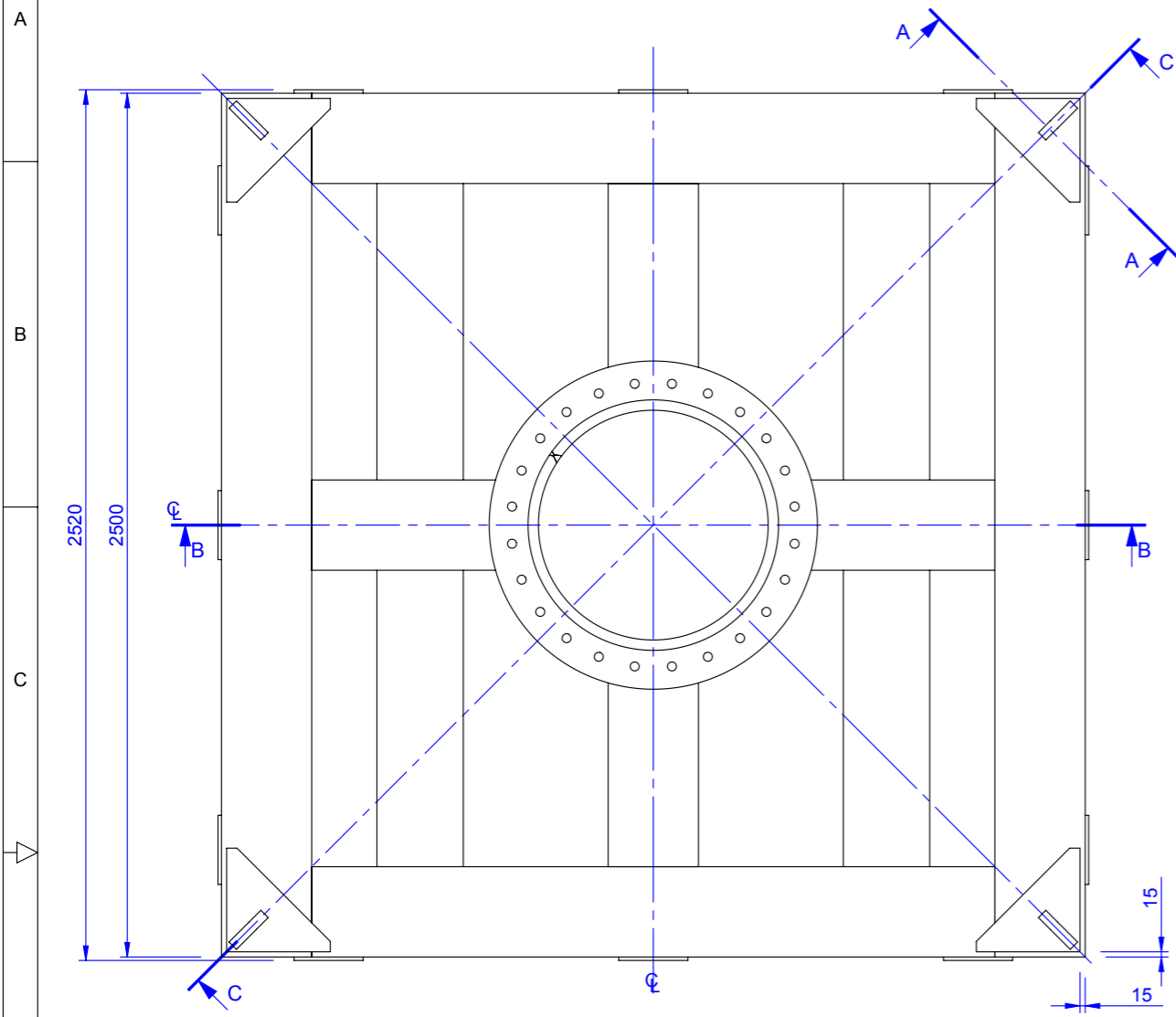


WELDMENT ITEM	PROFILE/SECTION	TOTAL APPROX LENGTH PER ITEM (mm)	QTY.	MATERIAL
1	U.C. 254 x 254 x 132 Kg/M	2500	2	Structural Steel, BS EN 10225 S355G12+M+Z35
2	U.C. 254 x 254 x 132 Kg/M	2223.4	2	Structural Steel, BS EN 10225 S355G12+M+Z35
3	U.C. 254 x 254 x 132 Kg/M	773.6	2	Structural Steel, BS EN 10225 S355G12+M+Z35
4	U.C. 254 x 254 x 132 Kg/M	773.6	2	Structural Steel, BS EN 10225 S355G12+M+Z35
5	TUBE, RECTANGULAR 250 X 150 X 10	2254	2	Structural Steel, BS EN 10210 S355J2H
6	Rolled Can, Dia 723mm X 410mm Long x 30mm Thick		1	Structural Steel, BS EN 10025 S355J2+N
7	30mm Plate		1	Structural Steel, BS EN 10025 S355K2+N
8	25mm Plate		4	Structural Steel, BS EN 10025 S355K2+N
9	30mm Plate		4	Structural Steel, BS EN 10025 S355K2+N
10	20mm Plate		12	Structural Steel, BS EN 10025 S355K2+N
11	20mm Plate		4	Structural Steel, BS EN 10225 S355G12+M+Z35
12	20mm Plate		4	Structural Steel, BS EN 10225 S355G12+M+Z35



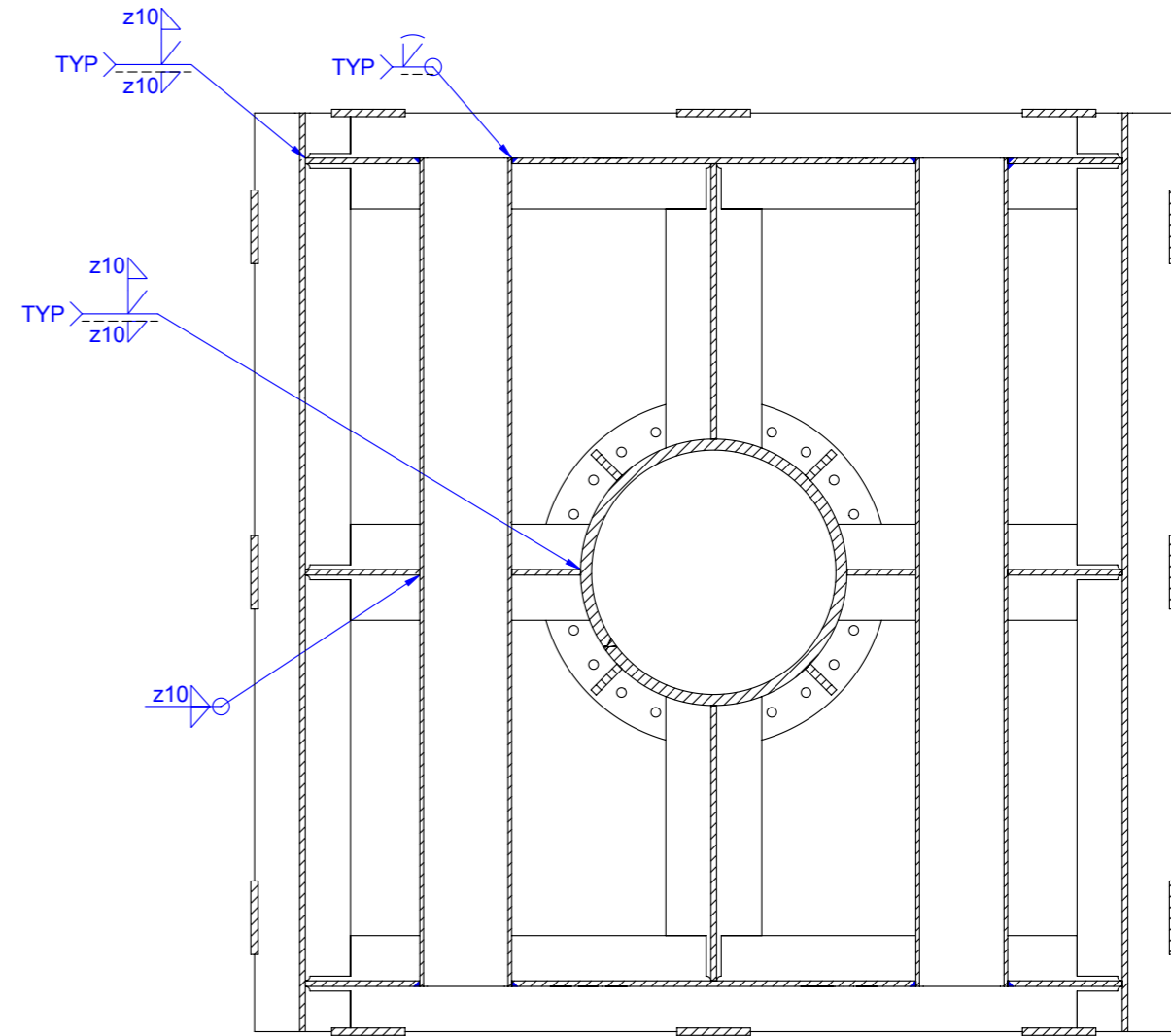
ISSUED FOR MANUFACTURE					01	JK	LGK	JC	09/07/2015	MATERIAL SEE CUT LIST	TOLERANCES U.O.S. 0-199mm ±1 200-999mm ±2 1m-3m ±3 >3m ±5 ANGULAR ±0.5°	ALL DIMENSIONS ARE IN MILLIMETRES (INCHES) AND PRIOR TO ANY COATING (U.O.S)	TITLE CRANE WELDMENT FRAME	THISTLE GROUP	Thistle Marine (Peterhead) Ltd 5 Baltic Place Peterhead AB42 1TF Tel :- 01779 477210		
DESCRIPTION	REV	DRAWN	REVIEWED	APPROVED	DATE	FINISH REMOVE ALL BURRS & SHARP EDGES, DRESS ALL WELDS, SURFACE FINISH TO BE 3.2µmRa OR BETTER EXCEPT WELDS		THIRD ANGLE PROJECTION		WEIGHT IN AIR: 2300 kg	WEIGHT IN WATER: N/A	000-M400-01	REV. 01	DO NOT SCALE DRAWING	SCALE 1:20	SHEET 1 OF 4	A3

NOTES:

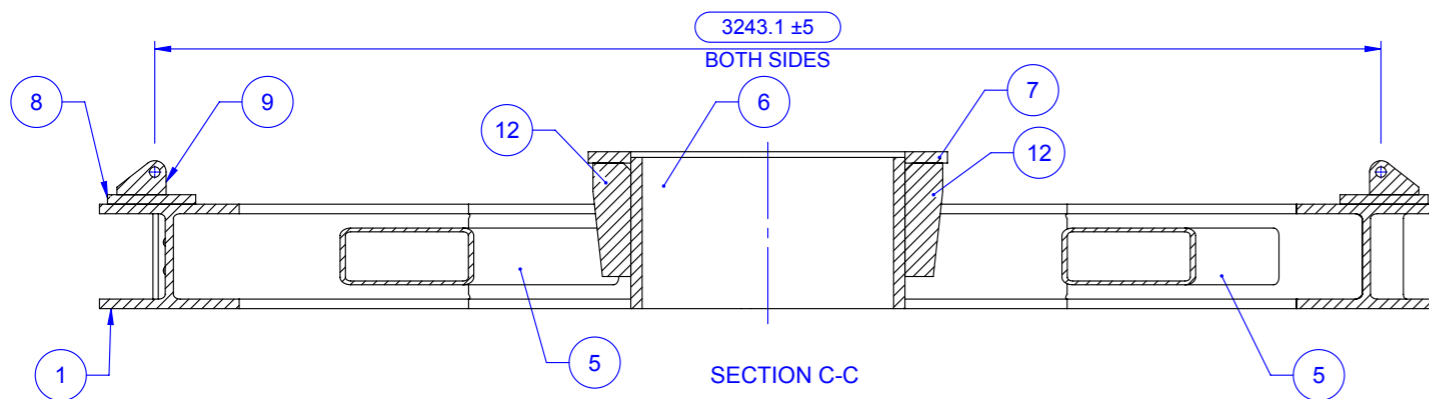
1. ALL DIMENSIONS AND GEOMETRIC TOLERANCES ARE TYPICAL U.O.S. AND PRIOR TO COATING IF APPLICABLE
2. WELD SYMBOLS TO BS EN 22553, WELD DETAILS ARE TYPICAL U.O.S.
3. OPERATOR AND WELD PROCEDURES, QUALIFICATIONS, & WELDING TO ASME IX OR BS EN 287 & BS EN ISO 15614-1:2004+A1:2008
4. NDE OPERATOR QUALIFICATION TO PCN/ASNT LEVEL 2 MINIMUM (BS EN ISO 9712)
5. ALL WELDS TO BE 100% MAGNETIC PARTICLE INSPECTED (MPI) IN ACCORDANCE WITH THE FOLLOWING STANDARDS: BS EN ISO 17638:2009 - MPI PROCEDURES BS EN ISO 23278:2009 - MPI ACCEPTANCE LEVELS
6. WELD IN ACCORDANCE WITH BS EN 1011-2, DEFECT ACCEPTANCE LEVEL QUALITY CATEGORY 'A'
7. ALL WELDS TO BE CONTINUOUS 10mm FILLET OR FULL PENETRATION BUTT WELDS AS APPROPRIATE U.O.S. (WELDS ARE TYPICAL)
8. PRIMARY STRUCTURE STEEL TO BE TESTED BY THE CHARPY IMPACT METHOD:  

THICKNESS	TEMP
UP TO 25 THK	-20°C
OVER 25 THK	-40°C
IMPACT ENERGY FOR GRADE 355 > 35 JOULES	

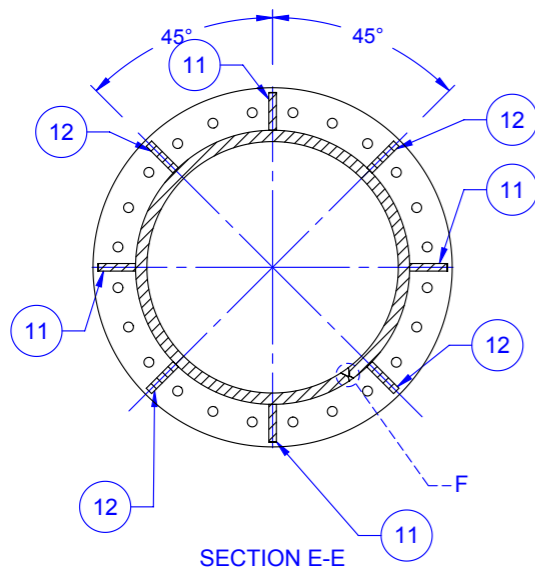
NOTES CONTINUED ON PAGE 4



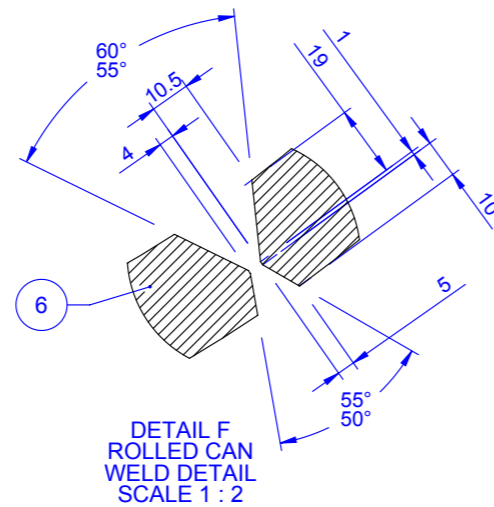
SECTION D-D



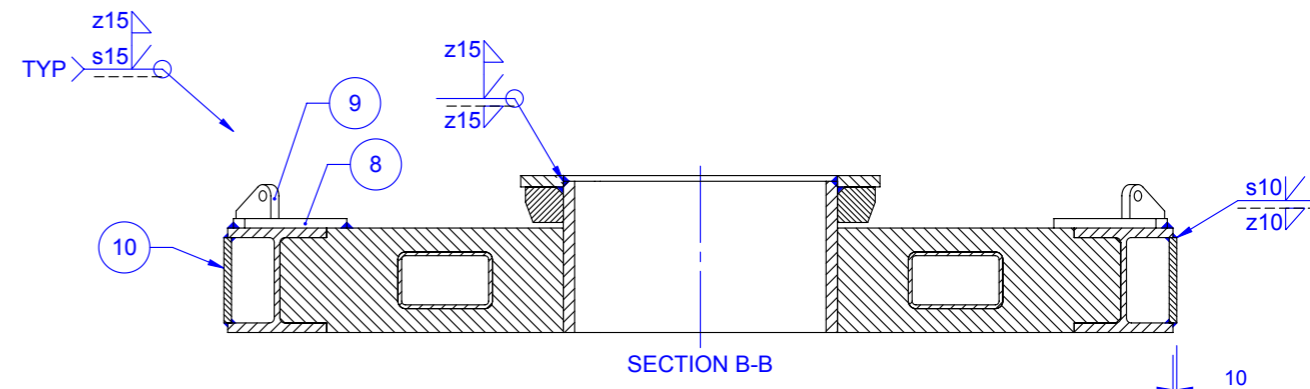
SECTION C-C



SECTION E-E

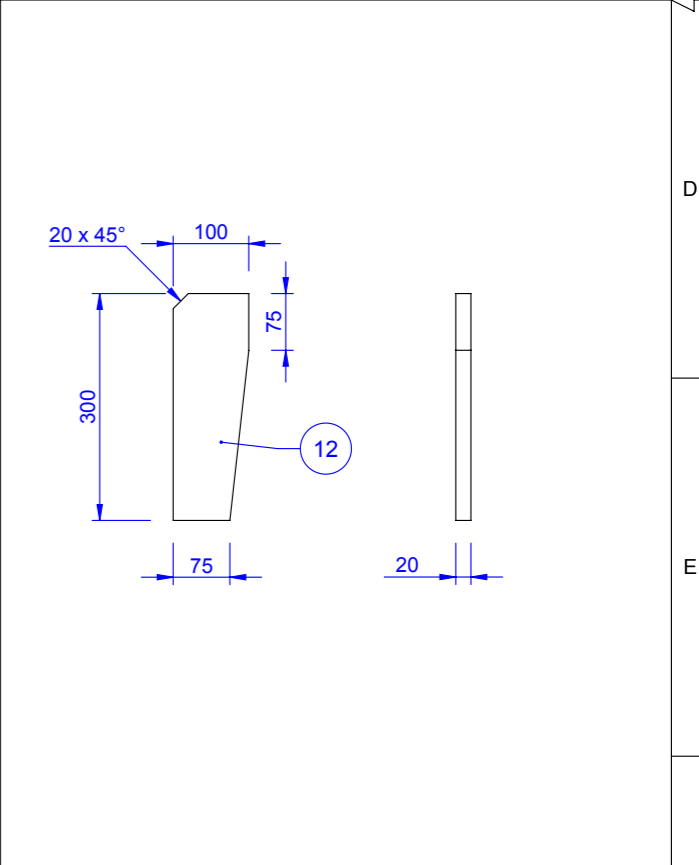
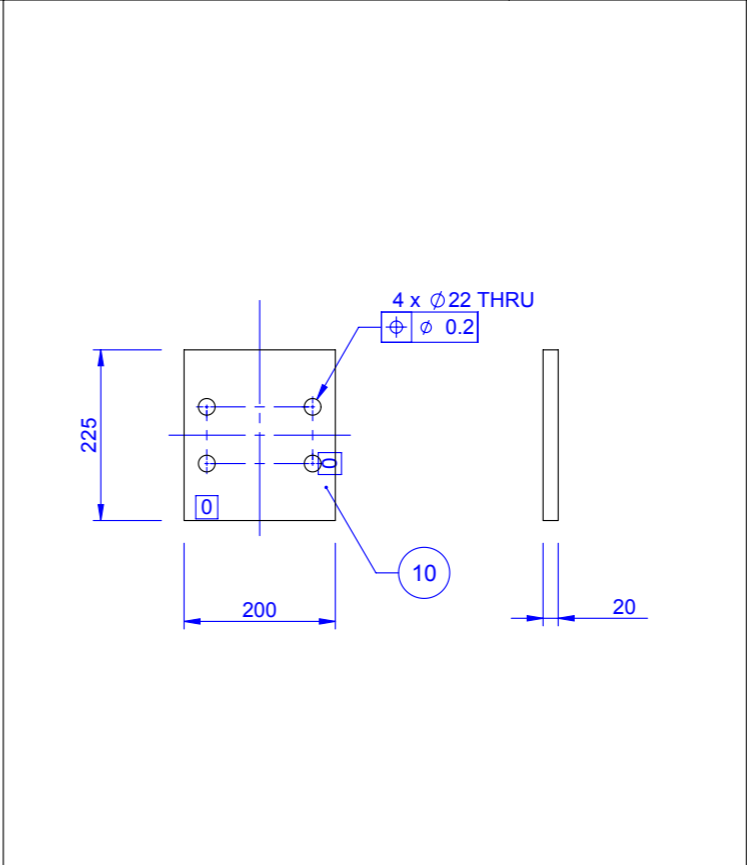
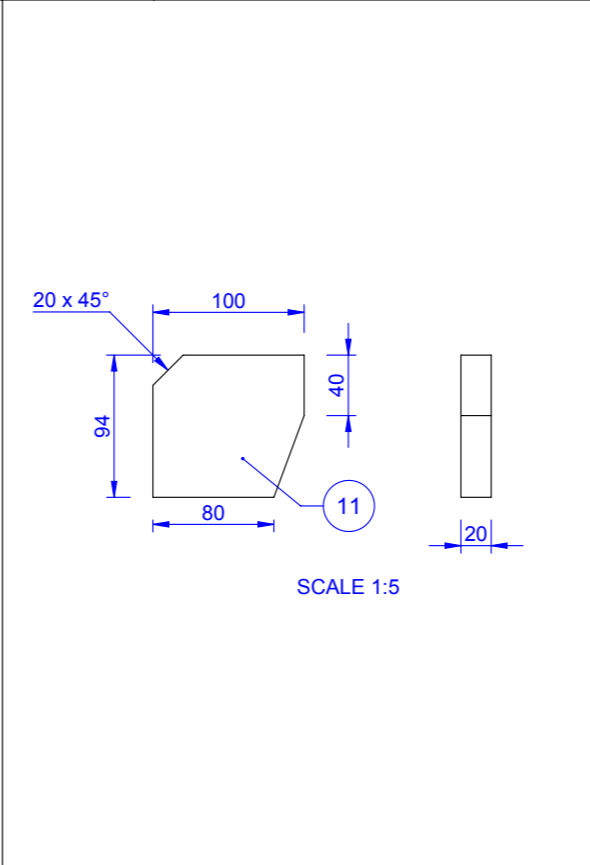
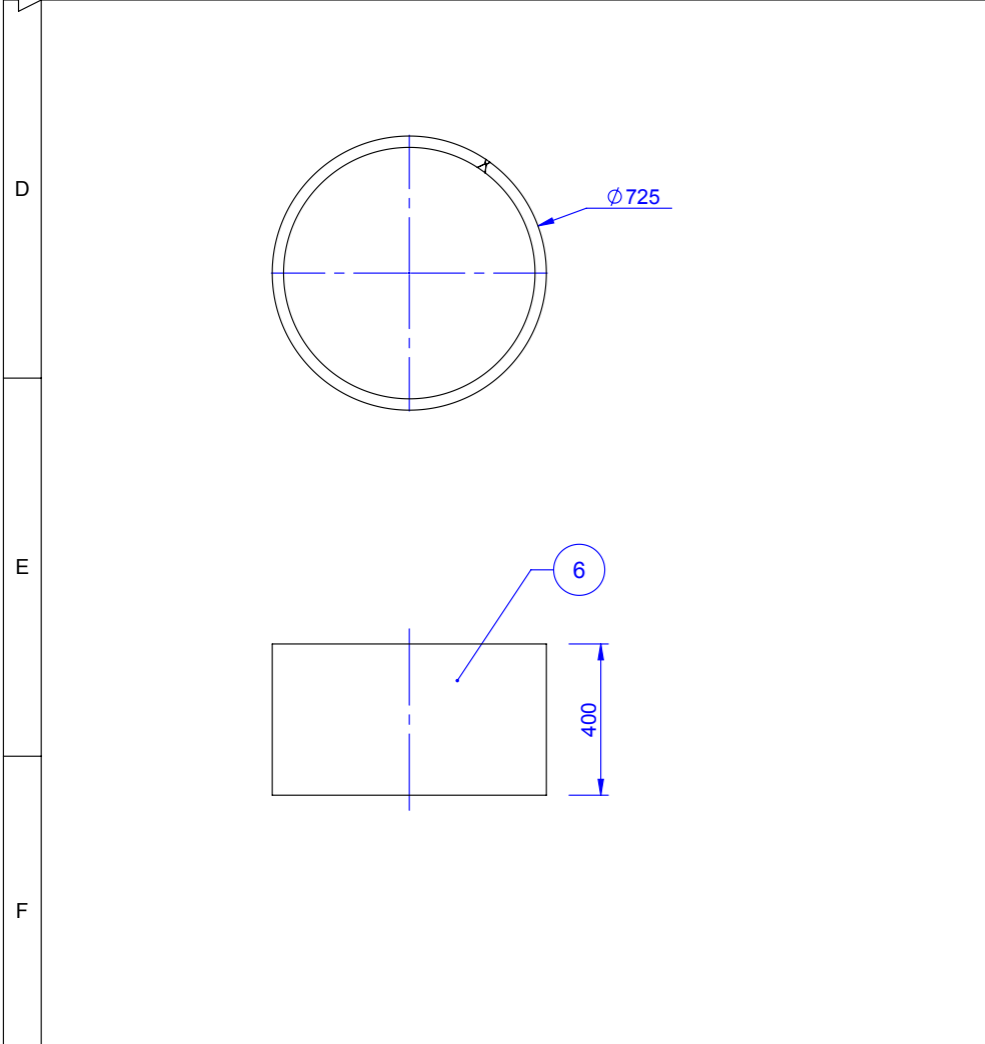
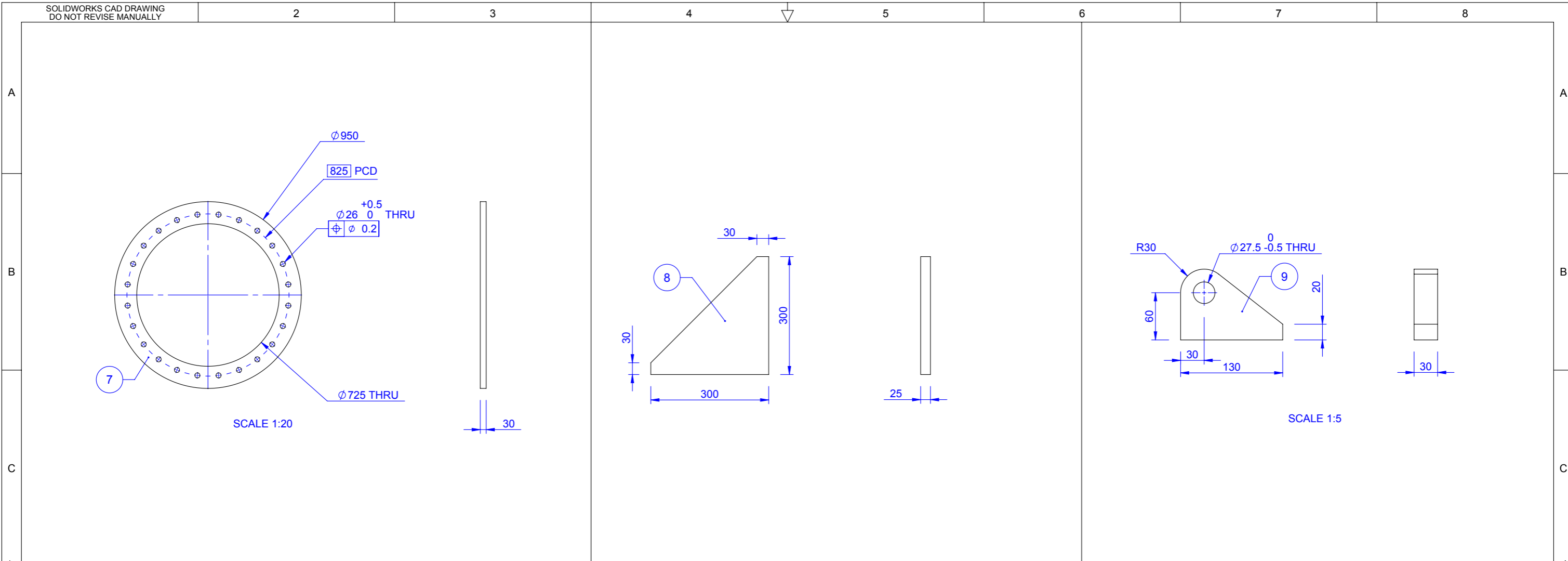


DETAIL F  
ROLLED CAN  
WELD DETAIL  
SCALE 1 : 2

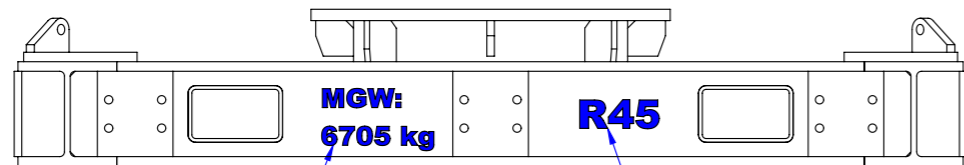
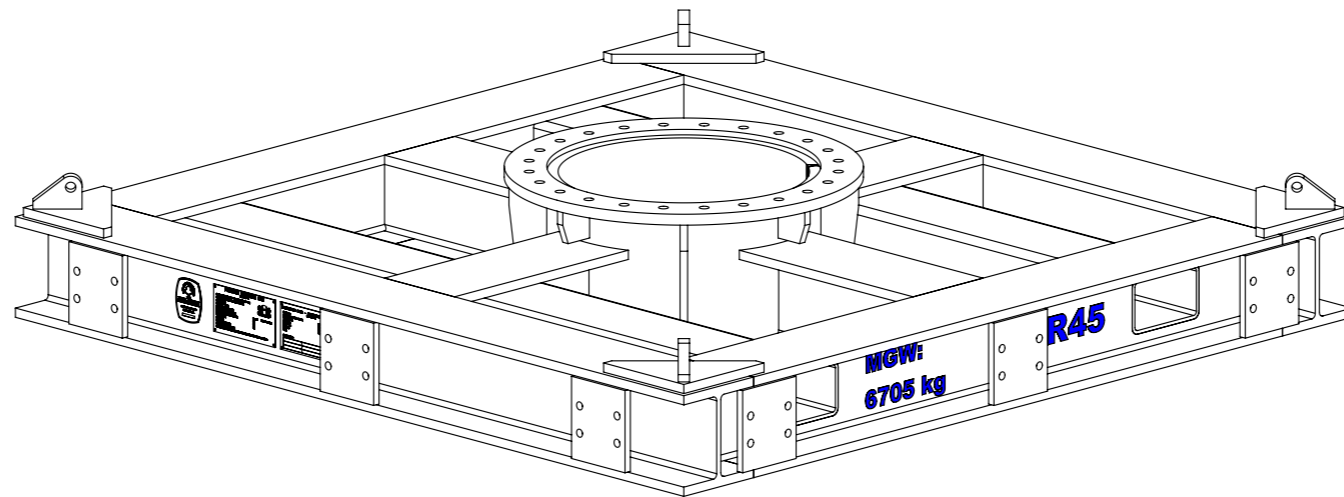


SECTION B-B

					MATERIAL	TOLERANCES U.O.S.		ALL DIMENSIONS ARE IN MILLIMETRES (INCHES) AND PRIOR TO ANY COATING (U.O.S)		TITLE		THISTLE GROUP		Thistle Marine ( Peterhead ) Ltd 5 Baltic Place Peterhead AB42 1TF Tel :- 01779 477210	
					SEE CUT LIST	0-199mm	+1			CRANE WELDMENT FRAME		THISTLE GROUP		000-M400-01	
						200-999mm	+2			WEIGHT IN AIR:		WEIGHT IN WATER:		REV. 01	
						1m - 3m	+3			2300 kg		N/A		SCALE SHEET	
						>3m	+5					DO NOT SCALE DRAWING		1:20 2 OF 4 A3	
						ANGULAR	±0.5°								
					ISSUED FOR MANUFACTURE	THIRD ANGLE PROJECTION									
					DESCRIPTION										
					REV										
					DRAWN										
					REVIEWED										
					APPROVED										
					DATE										
					01										
					JK										
					LGK										
					JC										
					09/07/2015										

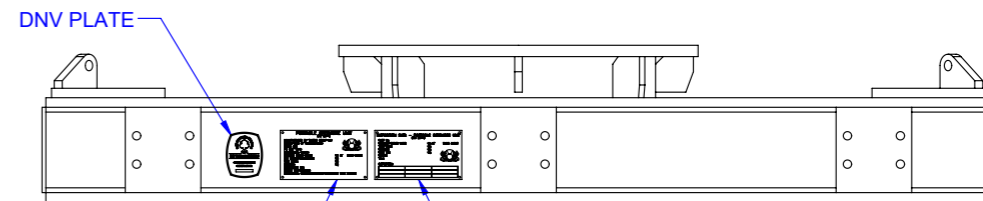


ISSUED FOR MANUFACTURE					01	JK	LGK	JC	09/07/2015	
DESCRIPTION					REV	DRAWN	REVIEWED	APPROVED	DATE	
MATERIAL					SEE CUT LIST					
FINISH					REMOVE ALL BURRS & SHARP EDGES, DRESS ALL WELDS, SURFACE FINISH TO BE 3.2µmRa OR BETTER EXCEPT WELDS					
TOLERANCES U.O.S.					0-199mm ±1 200-999mm ±2 1m-3m ±3 >3m ±5 ANGULAR ±0.5°					
THIRD ANGLE PROJECTION										
WEIGHT IN AIR:					2300 kg					
WEIGHT IN WATER:					N/A					
TITLE					CRANE WELDMENT FRAME					
THISTLE GROUP										
© 2013. THE INFORMATION CONTAINED WITHIN THIS DRAWING IS COPYRIGHT AND MAY NOT BE REPRODUCED OR DISCLOSED TO ANY THIRD PARTY WITHOUT THE EXPRESS WRITTEN AUTHORITY OF THISTLE MARINE (PETERHEAD) LTD					Thistle Marine ( Peterhead ) Ltd 5 Baltic Place Peterhead AB42 1TF Tel :- 01779 477210					
DO NOT SCALE DRAWING					SCALE		SHEET		REV.	
1:10					3 OF 4		A3		01	



SEE NOTE 9

SEE NOTE 10


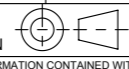


INFORMATION PLATE

INSPECTION PLATE

NOTES:

- 9. MAXIMUM GROSS WEIGHT TO BE CLEARLY MARKED USING 50mm WHITE LETTERS (RAL 9002) FONT ARIAL BOLD AS SHOWN
- 10. R45 TO BE TO BE CLEARLY MARKED USING 75mm WHITE LETTERS (RAL 9002) FONT ARIAL BOLD AS SHOWN

					MATERIAL	TOLERANCES U.O.S.	ALL DIMENSIONS ARE IN MILLIMETRES (INCHES) AND PRIOR TO ANY COATING (U.O.S)	TITLE	 Thistle Marine ( Peterhead ) Ltd 5 Baltic Place Peterhead AB42 1TF Tel :- 01779 477210	
					SEE CUT LIST	0-199mm +1 200-999mm +2 1m - 3m +3 >3m +5 ANGULAR ±0.5°		CRANE WELDMENT FRAME	WEIGHT IN AIR:	WEIGHT IN WATER:
					FINISH	THIRD ANGLE PROJECTION			2300 kg	N/A
					REMOVE ALL BURRS & SHARP EDGES, DRESS ALL WELDS, SURFACE FINISH TO BE 3.2µmRa OR BETTER EXCEPT WELDS	© 2013. THE INFORMATION CONTAINED WITHIN THIS DRAWING IS COPYRIGHT AND MAY NOT BE REPRODUCED OR DISCLOSED TO ANY THIRD PARTY WITHOUT THE EXPRESS WRITTEN AUTHORITY OF THISTLE MARINE (PETERHEAD) LTD		000-M400-01	REV. 01	
ISSUED FOR MANUFACTURE	01	JK	LGK	JC	09/07/2015	DO NOT SCALE DRAWING		SCALE 1:20	SHEET 4 OF 4	A3
DESCRIPTION	REV	DRAWN	REVIEWED	APPROVED	DATE					