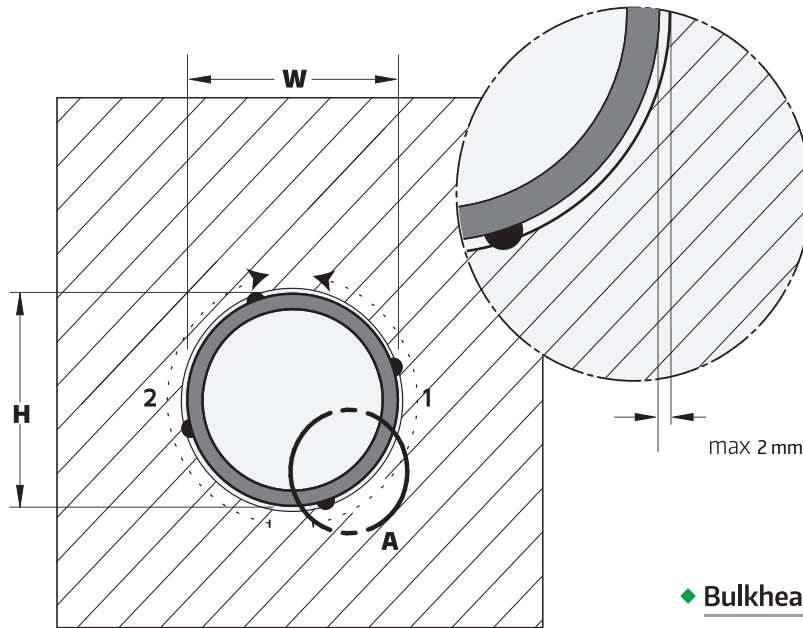
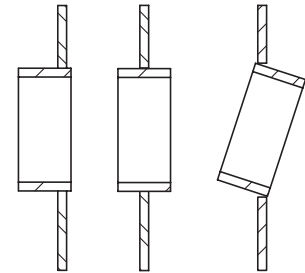


SLEEVES WELDING INSTRUCTIONS

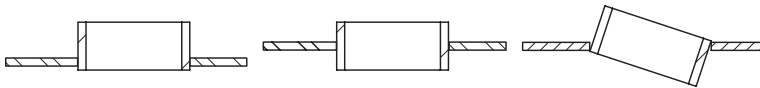
1. Check the measures of the precut hole and external dimensions of the frame. Recommended gap around the frame is in between 1mm and 2mm (0.5-1mm on every side of the frame). See frames dimension chart page...56



Bulkhead welding positions

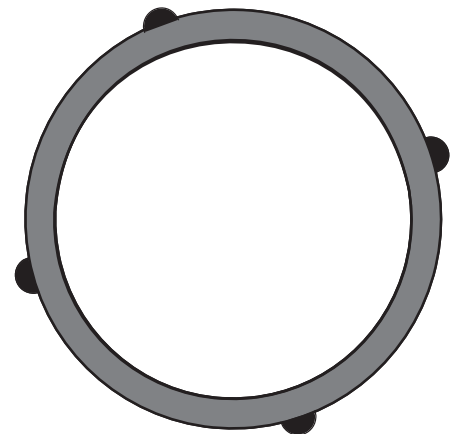
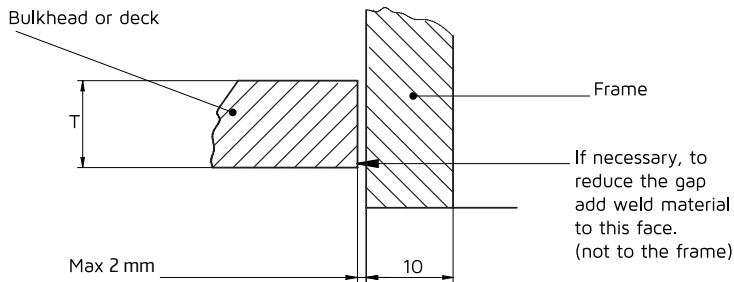


Deck welding positions



2. Tack weld on the front side, centring the frame onto the cut-out hole:

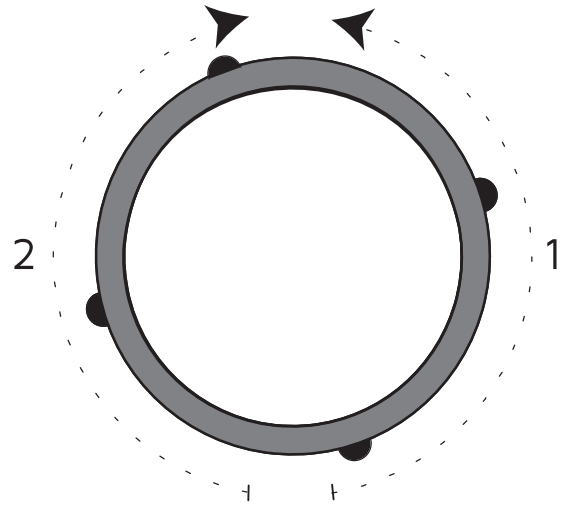
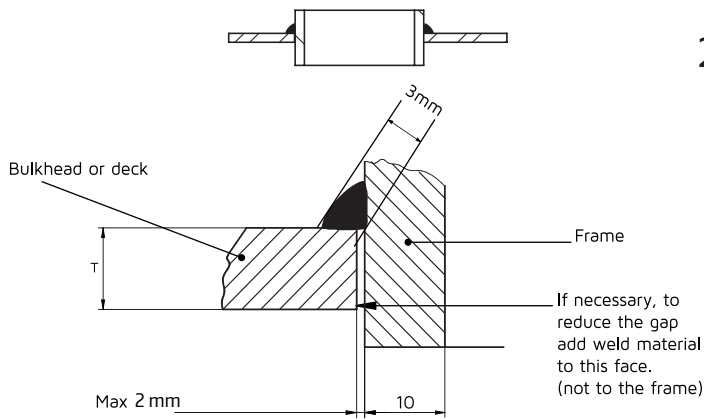
Check the gap measures all around the frame are maintained. If necessary, add weld material to the bulkhead/deck to reduce the gap (not to the frame)



3. Start welding the frame with a sealing fillet weld on the backside. Follow appropriate welding sequence. This welding throat should not exceed 3mm.

The interpass temperature should not exceed 200°C for mild steel and aluminium and 150°C for stainless steel.

- ◆ Máx run lenght: { Mild Steel 200 mm
Stainless Steel 150 mm
Aluminium 200 mm



$$\text{Heat Input (KJ/mm)} = \frac{V \cdot I \cdot \eta}{\text{vel} \cdot 1000}$$

V = volts / I = amperes / vel = mm/s

$$\eta = \begin{cases} 1 & \text{SMAW} \\ 0,8 & \text{GMAW / FCAW} \\ 0,6 & \text{GTAW} \end{cases}$$

	Máx. Heat Input (KJ/mm)		
	Mild Steel	Stainless Steel	Aluminium
a = 3 mm	1,2	1,1	2

4. Grind off weld tacks before start filled weld. Weld runs should not start or stop at a tack weld but should run over a tack.

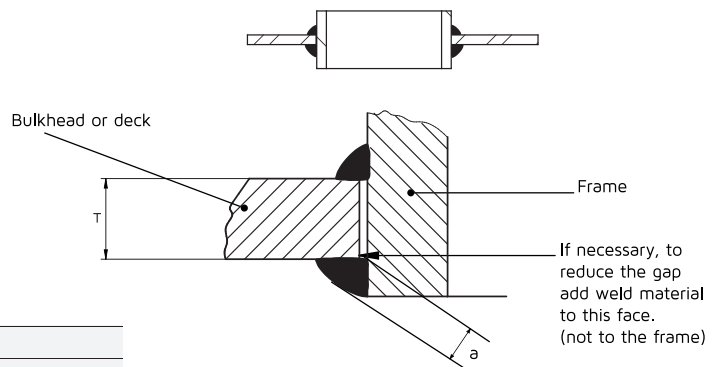
Follow same welding sequence for correct procedure.

The interpass temperature should not exceed 200°C for mild steel and aluminium and 150°C for stainless steel.

This welding throat should not exceed following values:

- T > 7mm a=5mm
T ≤ 7mm a=4mm

- ◆ Máx run lenght: { Mild Steel 200 mm
Stainless Steel 150 mm
Aluminium 200 mm



	Máx. Heat Input (KJ/mm)		
	Mild Steel	Stainless Steel	Aluminium
a = 4 mm	1,2	1,1	2
a = 5 mm	1,4	1,1	2