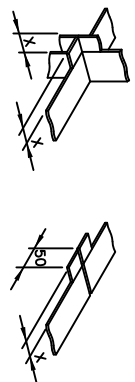


# FILLET

SYMBOL		SYMBOL	
MANUAL	**BTC-P5	ANGLE	
T	D	T	S
19<T≤25	8	T ≤ 7	SAME AS T
25<T≤32	10	7<T≤12	T-2
32<T≤40	12	12<T≤20	12
40<T≤50	16	CHANNEL	
AUTOMATIC	**T/C-P5=S **BTC-P5=GF		
T	D	T	S
19<T≤25	8	T ≤ 12	SAME AS T
25<T≤35	10	12<T≤20	12
32<T≤40	12	PLATE	
40<T≤50	16		
T	D	T	S1
19<T≤25	8	T ≤ 5	SAME AS T
25<T≤35	10	5<T≤10	T-2
32<T≤40	12	10<T≤15	12
40<T≤50	16	T ≥ 15	15

\* APPLY TO PARTIAL PENETRATION

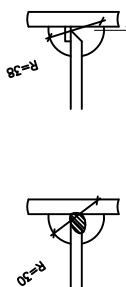
- B: BUTT WELD SHALL BE MADE WITH THE AID OF END AS FOLLOWS**



X = { NOT LESS THAN 35 mm AND 2 TIMES OF PLATE THICKNESS. ( MANUAL )  
NOT LESS THAN 75 mm AND 3 TIMES OF PLATE THICKNESS. ( AUTOMATIC )



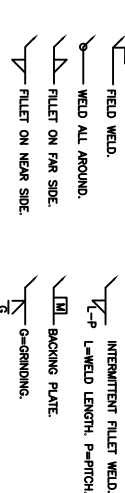
### 3 - SCALLOP



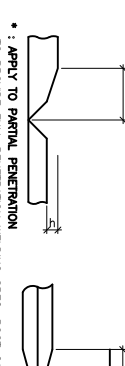
BUILT H BEAM

- 4 - FOR GROOVE WELD JOINTS GUSSETING BACK WELDING SHALL BE PERFORMED UNLESS OTHERWISE NOTED.
- 5 - IF WELDING IS DONE FROM ONE SIDE BACKING PLATE SHALL BE EMPLOYED ON BACK SIDE.
- 6 - SIZE OF FILLET SHALL BE EQUAL LESS.

7 - INDICATION OF WELDING.(ACCORDING TO ASTM STANDARD



- 8 - U: UNLIMITED
- 9 - T: BASE METAL THICKNESS
- 10 - LEGEND ON MKD.\*\* ARE JOINT DESIGNATION OF AWS.
- 11 - CHAMFER OF BUTT JOINT ARE AS FOLLOW



**DIMENSION SHOULD BE 2 mm MIN. .**

02	02 DATE	ISSUED FOR CONSTRUCTION	ISS	N/A	MINES & METALS
01	01 DATE	ISSUED FOR APPROVAL	IFA	N/A	MINES & METALS
REL.	DATE	DESCRIPTION	PURPOSE OF ISSUE	PREPARED	CHECK
Project					
KOWSAR GISD MEGA MODULE PROJECT					
Client		Contractor			
Sheet No	Project Code	Man Contractor	Area Code	Plant Group	Equipment Code
GISD	7-2	119	1003	7	AA
SHEET NO.		DATE	DESCRIPTION	TYPE	SIZE
DESIGNED		14/09/2016	AREA 350 / PIPE RACK AREA	04	S
CHECKED		14/09/2016	WELDING SPECIFICATION		
APPROVED		14/09/2016	KGMM SF 13 C3 103		
DRAWN		14/09/2016			
SCALE		REL.	SHEET		
AS SHOWN		02	A1		
SHEET		-/-			
CONT. & PROJ. NO.		14/09/2016			