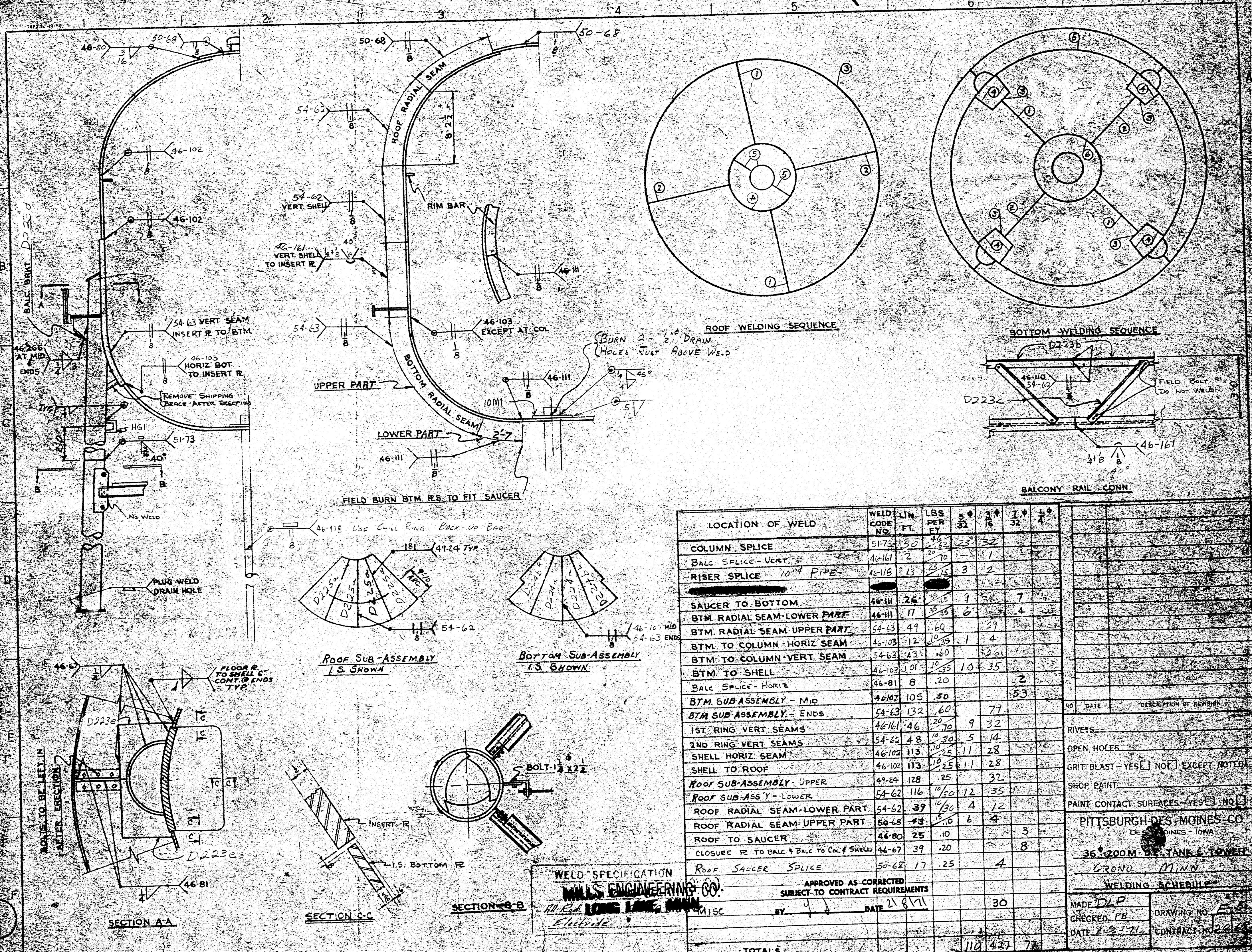


WELDING DIAGRAM 36° OF 300 M. TANK & TOWER
TANK DESIGN 4410
TOWER DESIGN 2413



LOCATION OF WELD	WELD CODE NO.	LN. FT.	LBS PER FT.	5/32	3/16	7/32	1/2
COLUMN SPLICE	51-73	50	46	23	32		
BALC SPLICE - VERT.	46-161	2	20	1			
RISER SPLICE 10" PIPE	46-118	13	25	3	2		
SAUCER TO BOTTOM	46-111	26	35	9		7	
BTM. RADIAL SEAM - LOWER PART	46-111	17	35	6		4	
BTM. RADIAL SEAM - UPPER PART	54-63	49	60			29	
BTM. TO COLUMN - HORIZ. SEAM	46-103	12	10	1	4		
BTM. TO COLUMN - VERT. SEAM	54-63	43	60		26		
BTM. TO SHELL	46-103	101	10	10	35		
BALC SPLICE - HORIZ.	46-81	8	20			2	
BTM. SUB-ASSEMBLY - MID	46-107	105	50			53	
BTM. SUB-ASSEMBLY - ENDS	54-63	132	60		79		
1ST RING VERT. SEAMS	46-161	46	20	9	32		
2ND RING VERT. SEAMS	54-62	48	10	30	5	14	
SHELL HORIZ. SEAM	46-102	113	10	25	11	28	
SHELL TO ROOF	46-102	113	10	25	11	28	
ROOF SUB-ASSEMBLY - UPPER	49-24	128	25		32		
ROOF SUB-ASSY - LOWER	54-62	116	10	50	12	35	
ROOF RADIAL SEAM - LOWER PART	54-62	39	10	30	4	12	
ROOF RADIAL SEAM - UPPER PART	50-68	43	10	6	4		
ROOF TO SAUCER	46-80	25	10			3	
CLOSURE RE TO BALC & BALC TO COL & SHELL	46-67	39	20			8	
ROOF SAUCER SPLICE	50-68	17	25		4		
TOTALS					110	427	7

WELD SPECIFICATION
MILL'S ENGINEERING CO.
ELECTRODE

APPROVED AS CORRECTED
SUBJECT TO CONTRACT REQUIREMENTS
BY *Y* DATE *2/8/71*

MISC

NO

DATE

DESCRIPTION OF REVISION

RIVETS

OPEN HOLES

GRIT BLAST - YES ☐ NO ☐ EXCEPT NOTED

SHOP PAINT

PAINT CONTACT SURFACES - YES ☐ NO ☐

PITTSBURGH-DES MOINES CO.
DES MOINES - IOWA

36° 300 M. TANK & TOWER

ORONO MINN.

WELDING SCHEDULE

MADE *DLP*

CHECKED *PB*

DATE *2-3-71*

DRAWING NO *E-5*

CONTRACT NO *22168*