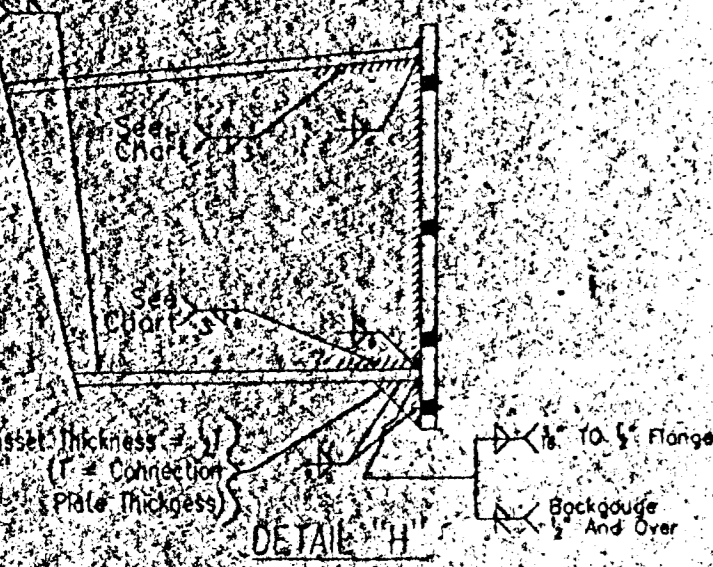
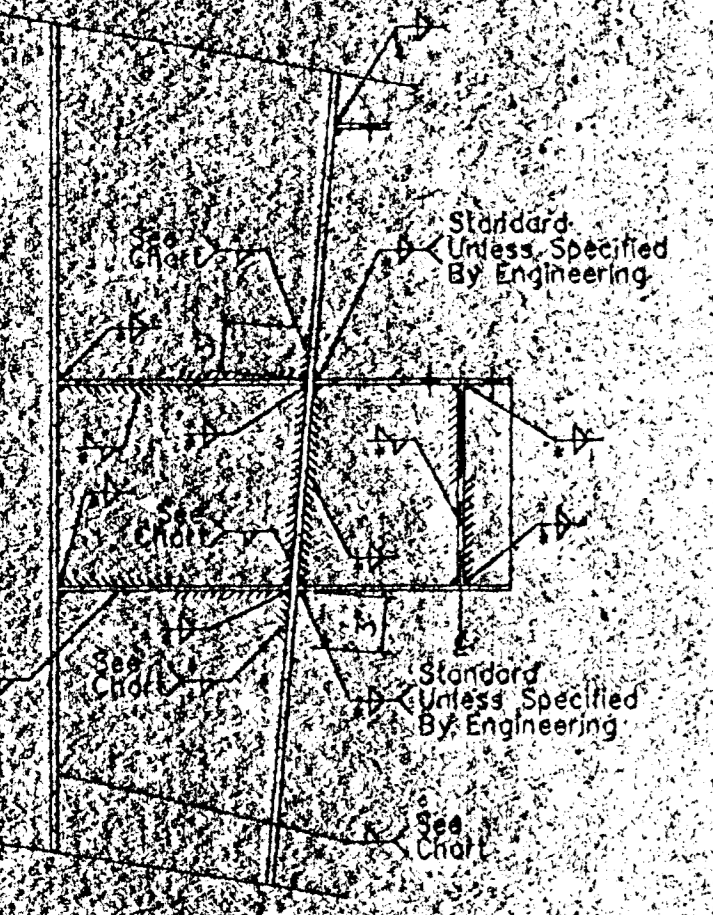
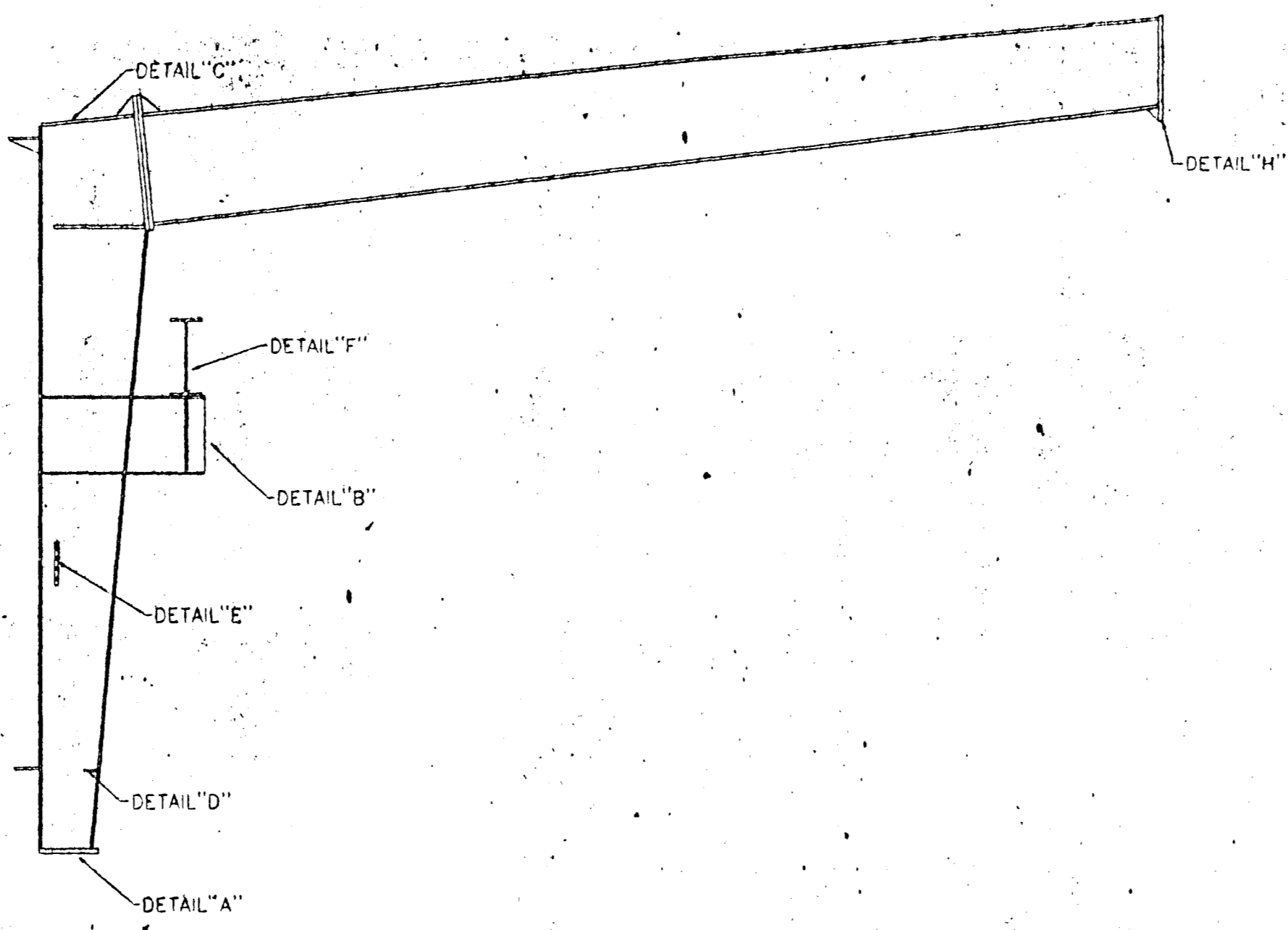


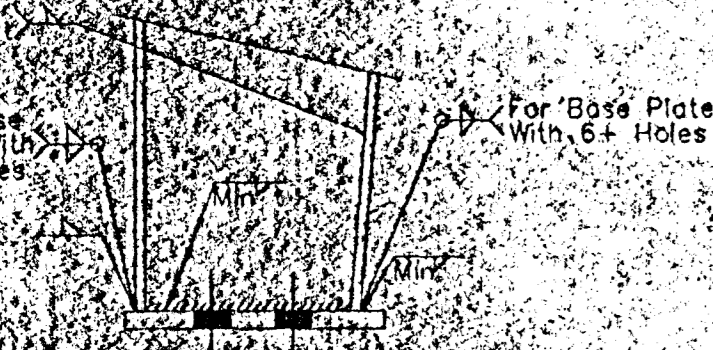
DETAIL "C"
COLUMN TO RAFTER FIELD SPLICE



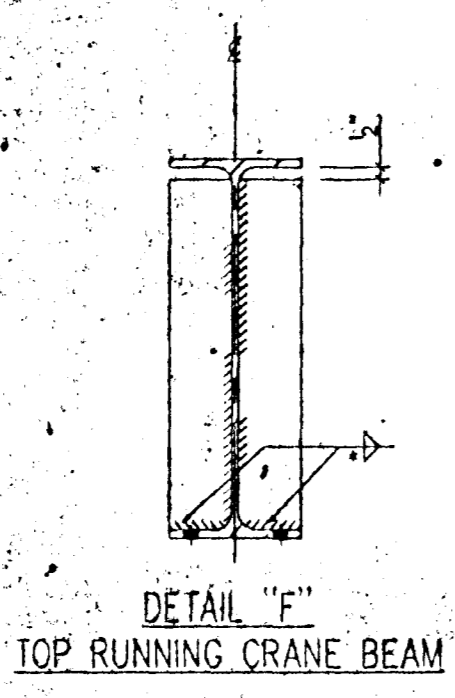
DETAIL "H"
RAFTER TO RAFTER PEAK FIELD SPLICE



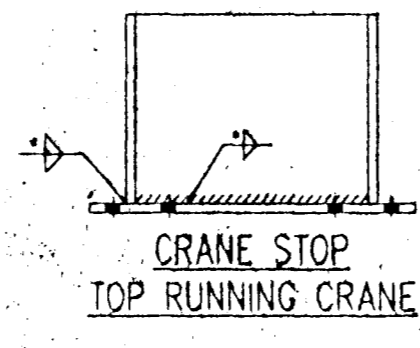
DETAIL "B"
TOP RUNNING CRANE BRACKET ATTACHMENT TO COLUMN



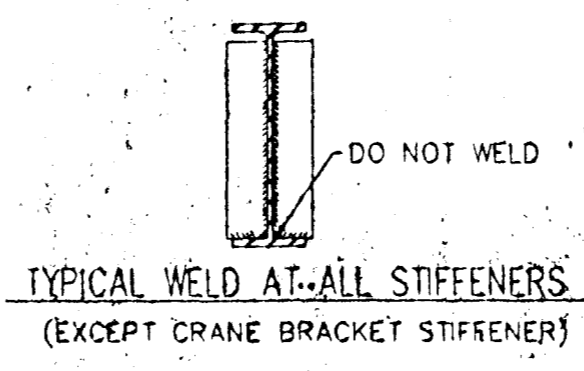
DETAIL "A"
COLUMN BASE PLATE



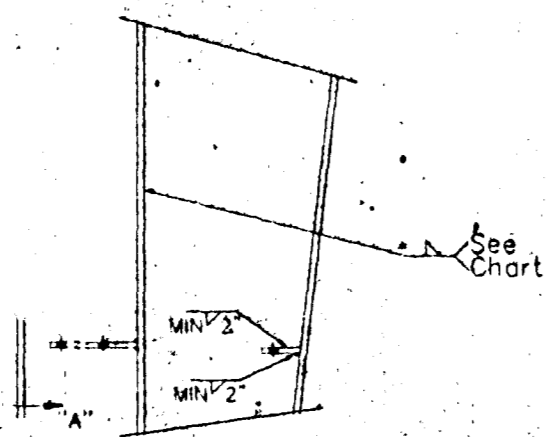
DETAIL "E"
TOP RUNNING CRANE BEAM



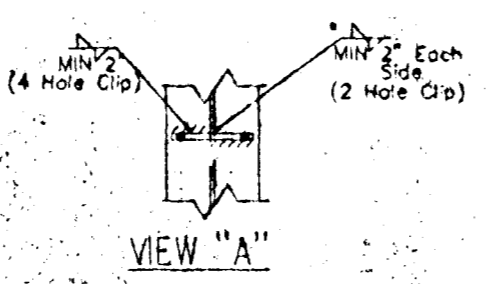
CRANE STOP
TOP RUNNING CRANE



TYPICAL WELD AT ALL STIFFENERS
(EXCEPT CRANE BRACKET STIFFENER)



DETAIL "D"
MISC. CLIP & BRACKET ATTACHMENT TO COLUMN



DETAIL "E"
MISC. WMG PLATE ATTACHMENT TO COLUMN

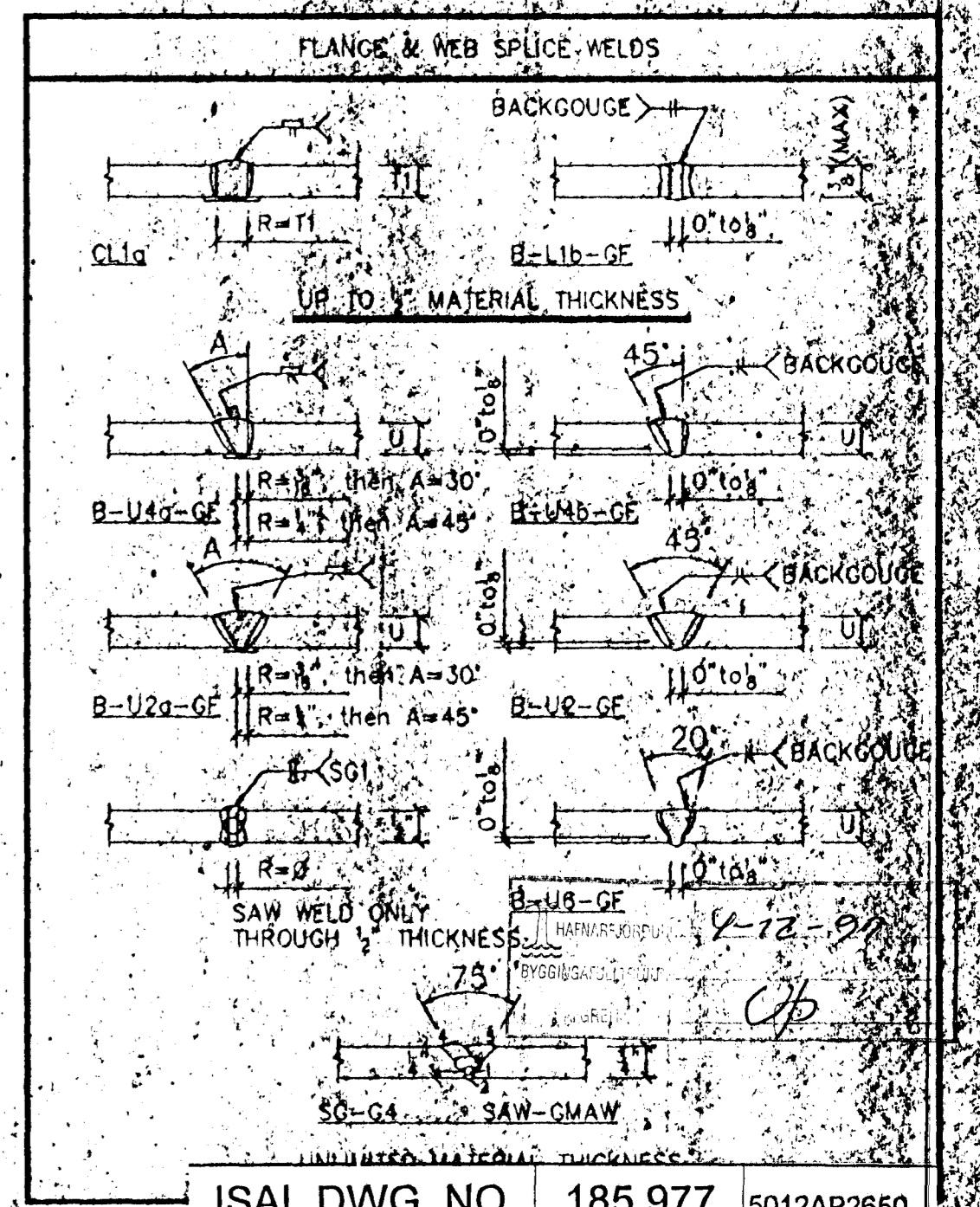
Thickness of thickest part at point of welding	MINIMUM TEMPERATURE (F)	
	GMAW, SAW or low hydrogen rods*	Other than low hydrogen rods
Up to 3/8"	none	none
Over 3/8" Thru 1 1/2"	50°	150°
Over 1 1/2" Thru 2 1/2"	150°	225°
Over 2 1/2"	225°	300°

WEB THICKNESS	FLANGE THICKNESS		
	3/8"	1/2" TO 3/4"	OVER 3/4"
10G & 10S	3/8"	3/8"	NOTE 2
1/2"	NOTE 1	3/8"	NOTE 2
3/8"	NOTE 1	3/8"	NOTE 2
3/4"	NOTE 1	3/8"	NOTE 3

NOTE: 1. 3/8" FLANGES ARE NOT TO BE USED FOR WEB THICKNESS OF 1/2" OR OVER UNLESS SPECIFIED BY ENGINEERING.
2. FILLET SIZE IS EQUAL TO THICKNESS OF WEB.
3. FOR WEB THICKNESS OF 3/8" AND OVER, ALL FILLET SIZES ARE TO BE SPECIFIED BY ENGINEERING.

* FOR WELD SIZES NOT INDICATED, USE THICKNESS OF THINNER PART JOINED.

MATERIAL THICKNESS OF THICKER PART JOINED	FILLET WELD SIZE
TO 1/4" INCLUSIVE	3/8"
OVER 1/4" TO 1/2"	3/8"
OVER 1/2" TO 3/4"	1/2"
OVER 3/4"	3/4"



ISAL DWG. NO. 185.977 5012AP2650

ISSUE	REV.	DESCRIPTION	DATE	BY	CHKD
A		APPROVAL	2/14/80		
0		CONSTRUCTION	2/14/80		

U.S.A.
UNITED STRUCTURES OF AMERICA, INC.
1818 BUSHONG
HOUSTON, TEXAS 77030
713-442-8247

DESCRIPTION: WELDING STANDARDS (RF)	FOR CONSTRUCTION
CUSTOMER: ISTAK HF	
LOCATION: STRAUMSVIK, ICELAND	
BUYER NO.	
DRAWING BY	CHECK BY
DATE	DATE
JOB # 19947	LOADS
RF-W1	E17