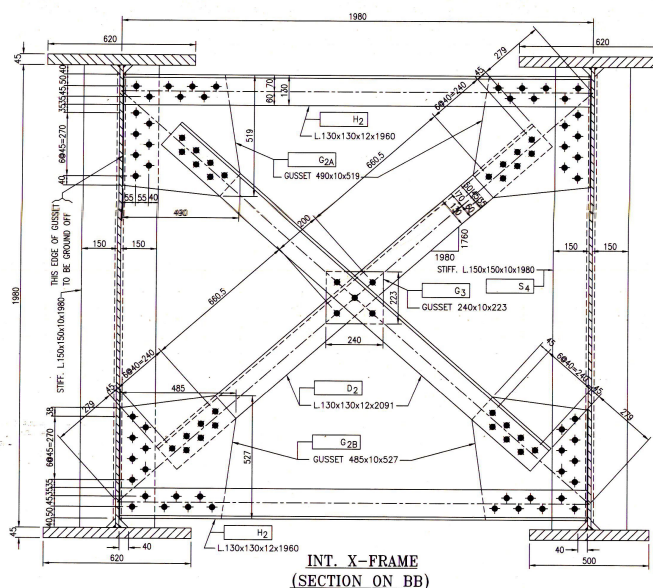
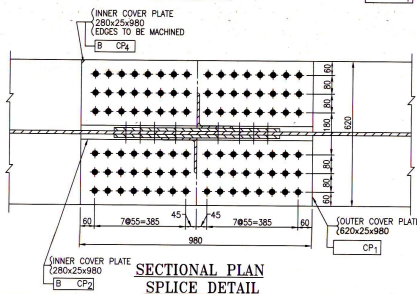


DESCRIPTION	REFERENCE
GENERAL ARRANGEMENT	RDSO/B-16005
ASSEMBLY DRAWING	RDSO/B-16005/2
DETAILS OF BEARING, PART LIST AND DESPATCH LIST	RDSO/B-16005/3
WELDING SEQUENCE	RDSO/B-16005/4

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R.	D.	S.	O.
MODIFIED B.G. LOADING - 1987			
PLATE GIRDER - WELDED TYPE			
24.4m SPAN (10^7 CYCLES)			
(BRACINGS & INT. STIFFENERS RIVETTED)			
DETAILS OF SPLICE AND X-FRAME			

RDS0/B-16005/1

DESCRIPTION	RIVETS	
	SHOP	FIELD
SNAP HEAD		
C.S.K. ON FAR SIDE		
C.S.K. ON NEAR SIDE		
C.S.K. ON BOTH SIDES		
ANCHOR BOLTS		
FILLET WELD (ONE SIDE)		
FILLET WELD (BOTH SIDES)		
SQUARE BUTT WELD		
DOUBLE V-BUTT WELD		

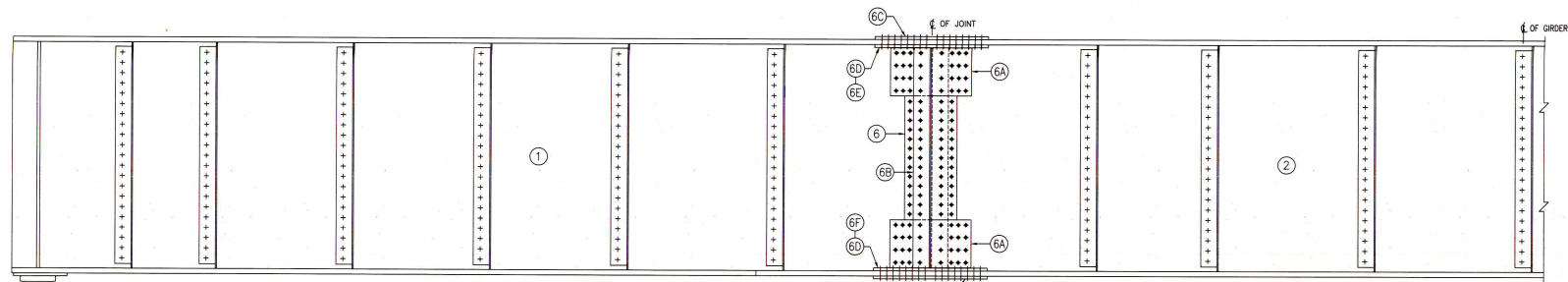
2. RIVET HOLES ARE 23.5 DIA. FOR 22 DIA. RIVETS.
1. ALL DIMENSIONS ARE IN MILLIMETRES.

MILLIMETRES

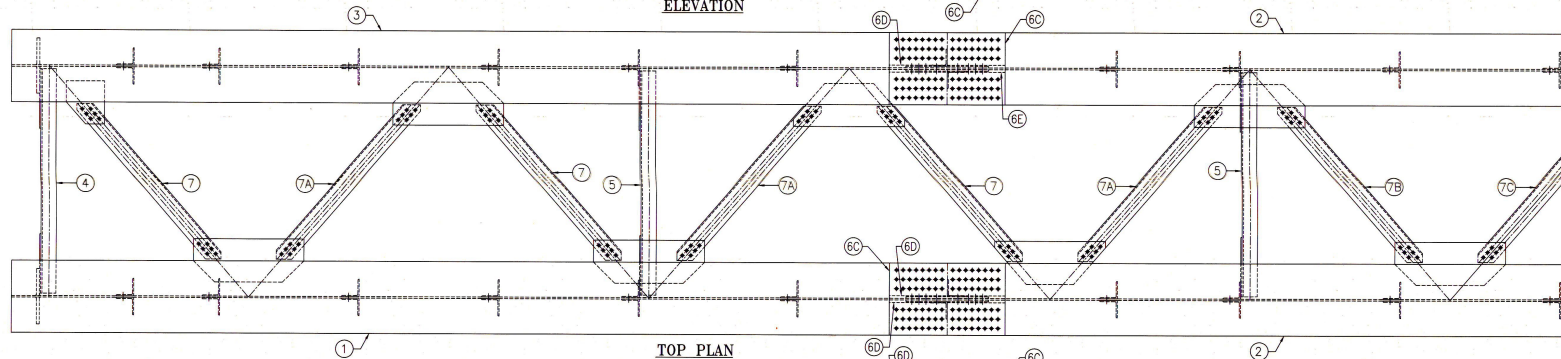
100 0 100 200 300 400 500 1:10

NOTE	SPECIFICATION	SCALE	ALT.	DESCRIPTION	DATE
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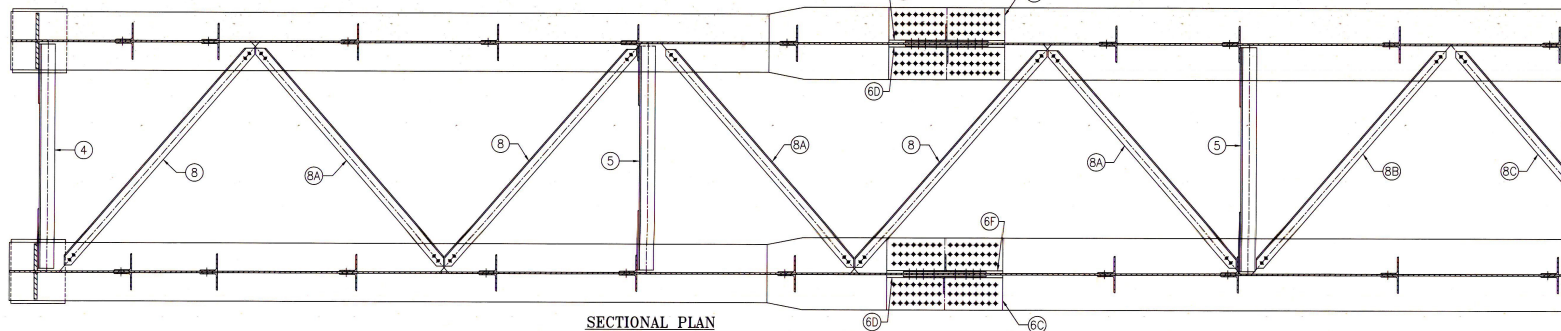
CALCULATION REGISTER No. DD/2005/7		DRAWN BY-MOND, AZHAR <i>Mond</i>		SCRUTINISED & CHECKED BY-	SCRUTINISED & CHECKED BY-	APPROVED BY-	AutoCAD FILE No. B16005-1	FLOPPY No.
PAGES	DONE BY- RAJEEV KUMAR <i>Rajeev</i>	CHECKED BY- RAJEEV KUMAR <i>Rajeev</i>	DATE B/S	DBS/SB-II <i>Mon</i>	EDBS <i>Mon</i>	<i>20.06.2005</i>	NOTIFICATION No.	
1 TO 61	CHECKED BY-M.M. SRIVASTAVA <i>M.M.</i>							



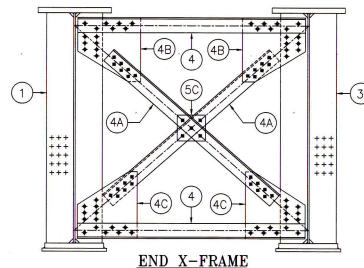
ELEVATION



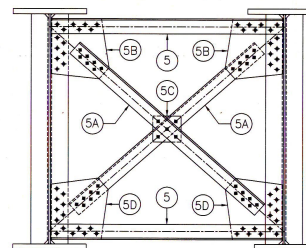
TOP PLAN



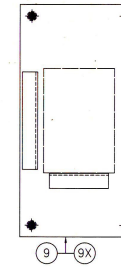
SECTIONAL PLAN



END X-FRAME



INT. X-FRAME



NOT TO SCALE

4. FOR DESPATCH LIST REFER DRG. No. RDSO/B-16005/3.
3. ERECTION MARKS ARE TO BE PAINTED IN WHITE LETTERS 100mm HIGH (OR AS LARGE AS THE MEMBER WILL PERMIT) ON EACH MEMBER BEFORE DESPATCH FOR THE WORKS AS THUS
2. ANCHOR BOLTS SHOWN THUS
1. FIELD RIVETS SHOWN THUS

NOTE

SPECIFICATION

SCALE

ALT. DESCRIPTION DATE

RELATED DRAWINGS

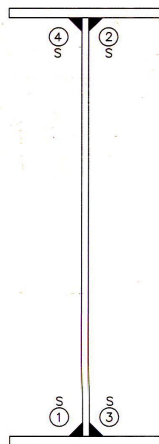
DESCRIPTION	REFERENCE
GENERAL ARRANGEMENT	RDSO/B-16005
DETAIL OF SPLICE AND X-FRAME	RDSO/B-16005/1
DETAILS OF BEARING, PART LIST AND DESPATCH LIST	RDSO/B-16005/3
WELDING SEQUENCE	RDSO/B-16005/4

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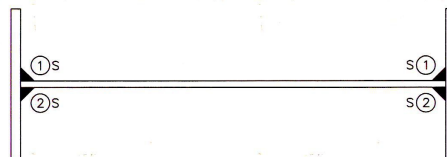
R. D. S. O.

MODIFIED B.G. LOADING-1987
PLATE GIRDER-WELDED TYPE
24.4m SPAN (10⁷ CYCLES)
(BRACINGS & INT. STIFFENERS RIVETTED)
ASSEMBLY DRAWING

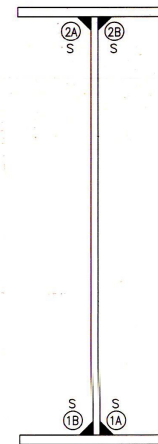
RDSO/B-16005/2



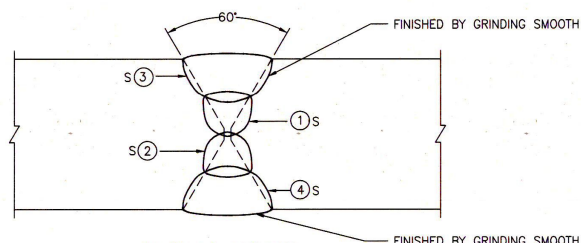
APPLICATION OF SINGLE HEAD MACHINE



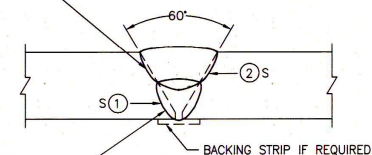
APPLICATION OF DOUBLE HEAD MACHINE ON GIRDERS:
LAID FLAT.



APPLICATION OF DOUBLE HEAD MACHINE
ON GIRDERS ON VERTICAL POSITION.



FLANGE SPLICE
(DOUBLE 'V')



WEB SPLICE
(SINGLE 'V')

BUTT WELDING

RELATED DRAWINGS

1. SEQUENCE AND POSITION OF WELDING.

ALL THE WELDING IS TO BE DONE ENTIRELY IN DOWN HAND POSITION. (S) INDICATES SUBMERGED ARC WELDING. Nos. 1,2,3 ETC. NEXT TO ABOVE NOTATION INDICATE SEQUENCE BY WHICH THE WELDING IS TO BE PERFORMED.

2. APPLICATION OF SINGLE HEAD MACHINE.

TO WELD GIRDERS WITH SINGLE HEAD MACHINE, FLANGES AND WEBS ARE TO BE SET IN FIXTURE AND TACKED. ON COMPLETION, THE ASSEMBLY IS TAKEN OUT AND PLACED ON THE WELDING STALLAGE FOR FINAL WELDING.

3. APPLICATION OF DOUBLE HEAD MACHINE ON GIRDERS LAID FLAT.

TWO WELDS ARE DEPOSITED ON ONE FACE OF WEB AT A TIME. THIS ARRANGEMENT DOES NOT REQUIRE REMOVAL OF THE ASSEMBLY FROM THE FIXTURE AFTER TACKING. THE FLANGE PLATES ARE SET AGAINST THE WEB IN THE FIXTURE AND TACKED MAIN WELDS, EACH JOINING FLANGE WITH THE WEB, ARE TO BE LAID WHILE ASSEMBLY IS STILL IN THE FIXTURE. AFTER COMPLETION OF FIRST FACE WELDING OF WEB, THE ASSEMBLY IS TO BE TURNED OVER AND WELDING OF THE SECOND FACE DONE.

4. APPLICATION OF DOUBLE HEAD MACHINE ON GIRDERS IN VERTICAL POSITION.

IN THIS CASE TWO WELDS ARE LAID JOINING EACH FLANGE WITH THE WEB AT A TIME. THIS WILL REQUIRE TACKING OF THE FLANGES WITH THE WEB, WHICH ARE PREVIOUSLY SET IN FIXTURE SPECIALLY MADE FOR THE PURPOSE. THE ASSEMBLY IS TO BE REMOVED FROM THE FIXTURE AFTER TACKING IS COMPLETED AND POSITIONED IN A MANIPULATOR, THE TWO WELDING HEADS ARE OPERATED IN SUCH A WAY ONE HEAD WILL BE AWAY BY 600 mm, BOTH THE HEADS TRAVELLING AT THE SAME SPEED. IT IS ADVISABLE TO LIMIT THE SINGLE RUN WELD TO 6 mm SIZE.

SCHEME OF SYMBOLS FOR WELDING : IS: 813
SUBMERGED ARC WELDING : IS: 4353
METAL ARC WELDING : IS: 9595
IRS WELDED BRIDGE CODE REVISED 2001
FABRICATION SPECIFICATION No. B1-2001, REVISED-2001

NOT TO SCALE

NOTE

SPECIFICATION

SCALE

ALT.

DESCRIPTION

DATE

RDSO/B-16005/4

R. D. S. O.

MODIFIED B.G. LOADING-1987
PLATE GIRDER-WELDED TYPE
24.4m SPAN (10⁷ CYCLES)
(BRACINGS & INT. STIFFENERS RIVETTED)
WELDING SEQUENCE

CALCULATION REGISTER No. DD/2005/7

PAGES DONE BY-RAJEEV KUMAR
1 TO 61 CHECKED BY-M.M. SRIVASTAVA

DRAWN BY-MOHD. AZHAR

CHECKED BY-RAJEEV KUMAR
M.M. SRIVASTAVA

SCRUTINISED & CHECKED BY-

ADE/SS-1

SCRUTINISED & CHECKED BY-

DBS/SB-II

APPROVED BY-

EDBS

AutoCAD FILE No. B16005-4

NOTIFICATION No.

FLOPPY No.