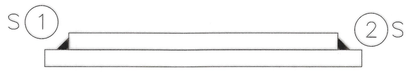
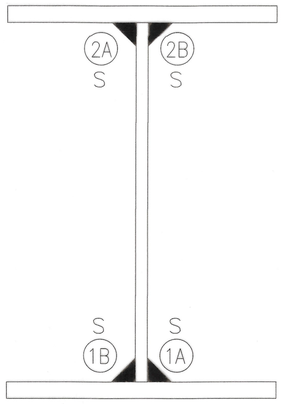
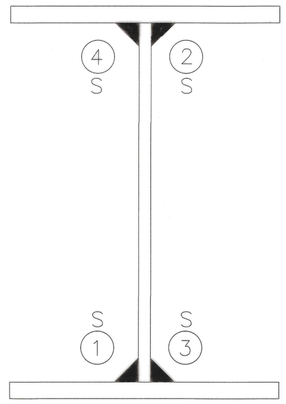


FILLET WELDING OF MULTIPLE FLANGE PLATES (IF ANY)

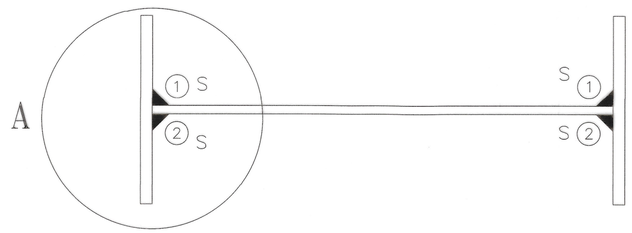
WELDING STAGE I



APPLICATION OF DOUBLE HEAD MACHINE ON GIRDERS ON VERTICAL POSITION.



APPLICATION OF SINGLE HEAD MACHINE



APPLICATION OF DOUBLE HEAD MACHINE ON GIRDERS: LAID FLAT.

WELDING STAGE II

WELDING STAGE I: {FILLET WELDING OF MULTIBLE FLANGE PLATES (IF ANY)}

SEQUENCE AND POSITION OF WELDING.

1. ALL THE WELDING IS TO BE DONE ENTIRELY IN DOWN HAND POSITION. S INDICATES SUBMERGED ARC WELDING.
2. RUN-ON AND RUN-OFF PIECES SHALL BE PROVIDED.
3. AFTER EACH RUN OF WELDING, PLATES SHALL BE CHECKED FOR DEFORMATION.

WELDING STAGE II: (WELDING OF WEB WITH FLANGE PLATES)

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. RUN-ON AND RUN-OFF PIECES SHALL BE PROVIDED.

2. APPLICATION OF SINGLE HEAD MACHINE.
   TO WELD GIRDERS WITH SINGLE HEAD MACHINE, FLANGES AND WEBS ARE TO BE SET IN FIXTURE AND TACKED.

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.

5 AFTER EACH RUN OF WELDING, THE FABRICATED ARTICLE SHALL BE CHECKED FOR ANY DEFORMATION. IN CASE OF DEFORMATION BEYOND PERMISSIBLE LIMITS, THE SAME SHALL BE RECTIFIED BEFORE NEXT STAGE WELDING IS TAKEN UP.

MAIN DRAWING

DESCRIPTION	REFERENCE
DETAILS OF MAIN GIRDER	RDSO/B-16016/R1

THIS DRAWING IS THE PROPERTY OF
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R. D. S. O.

"25t LOADING-2008"
PLATE GIRDER-WELDED TYPE
24.4m SPAN

WELDING SEQUENCE

PROVISIONAL DATE-28-02-2023

RDSO/B-16016/4R1

NOTES	SPECIFICATION	SCALE	ALT.	DESCRIPTION	DATE
		(SIZE A3) NOT TO SCALE			

DESIGN REGISTER No. DD/2023/	DESIGN BY- NILESH KUMAR (SSRE/SB-II)	DRAWN BY -ALOK RANJAN(JE/D/SB-II)	SCRUTINISED & CHECKED BY-	SCRUTINISED & RECOMMENDED BY-	APPROVED BY-	AUTOCAD FILE No. RDSO-B-16016-4R1
	CHECKED BY-SONU (JE/D/SB-II)	CHECKED BY-ASHOK KUMAR(SSRE//SB-II)	SANDEEP AGARWAL (ADE/SB-II/B&S)	MANISH KUMAR (DBS-VII/B&S)	RAJESH KUMAR SRIVASTAVA (ED/B&S)	NOTIFICATION No.