



ILLUMINATION DETAIL - 70 NEW OXFORD STREET

JOB CARD			
WELD SET No.			
WELDING WIRE LOT/BATCH			
WELDING GAS LOT/BATCH			
ISSUE TO FAB	DATE:		
CUT BY	DATE:		
BENT BY	DATE:		
DIMENSIONAL CHECKS	DATE:		
FABRICATED BY	DATE:		
WELDED BY	DATE:		
WELD INSPECTION DURING MULTIRUN	DATE:		
COMPLETION OF MANUFACTURE	DATE:		
CHECKED BY RWC	DATE:		
YES	NO		
REWORK	DATE:		
YES	NO	NCR No.	
ANY REWORK MUST RELATE TO NCR AND FOLLOW NDT PROCEDURE WELD DEFECT TO BE COMPLETELY REMOVED AND REWELDED TO THE ORIGINAL PROCEDURE.			
GAS FLOW CHECK			
VISUAL INSPECTION	100%	PASS / FAIL	
MPI	%		
DPI	%		
PRE GALV CHECK			
POST GALV CHECK			
ON COMPLETION THIS DRAWING MUST BE SIGNED AND GIVEN TO THE QA/WORKSHOP SUPERVISOR.			
SIGNATURE AND DATE			
WELDING PLAN			
-ALL WELDS 6mm LEG LENGTH FILLET UNO			
-ALL STEELWORK TO EXC2			
-ALL TOLERANCES TO MEET BS 1090-2			
-MAKE SURE SURFACE IS FREE FROM GREASE & MILL SCALE			
-ACCEPTABLE CRITERIA TO BS EN 5817 (QUALITY LEVEL C)			
-LAMELLAT TEARING TO BE AVOIDED BY GOOD JOINT DESIGN			
-CORRECT MATERIALS, WELDING SEQUENCE AND TECHNIQUE			
-RESTRAINTS APPLIED, CLAMPS AND BRACES (IF REQUIRED)			
-TURNING OF COMPONENTS BY O/H CRANE AND 'a' FRAMES			
-MEASURES TO AVOID DISTORTION PRE-HEAT POST-HEAT			
-SPECIAL CONSUMABLES YES/NO			
WPS 01 SL FW(135)	WPS 03 SL FW(135) PIPE TO PLATE		
WPS 02 ML FW(135)	WPS 05 SL FW(141) STAINLESS		
WPS 06 SL FW(141) ALU	WPS 08 SL FW(141) SS PIPE-PLATE		
WPS 09 BW(135)			
 CUTTING EDGE SIGNAGE Enterprise House, Unit 1 Aber Park Industrial Estate Flintshire, CH6 5EX t: 01352 792000 f: 01352 792001 e: info@is-group.co.uk w: www.is-group.co.uk			
QTY	AS DETAILED		
MATERIAL GRADE	AS DETAILED		
SURFACE FINISH AND BS No.			
SITE	70 NEW OXFORD STREET		
TITLE	ILLUMINATION		
SCALE			
DATE	15.01.2018		
DRAWN	RH		
SHEET No.	1	SO No.	2494
DRAWING No.	S02494-01		

NOTE: THIS DRAWING AND ALL DESIGN DETAILS ARE CONFIDENTIAL AND THE EXCLUSIVE PROPERTY OF IS CONSULTANCY LTD WHICH RESERVES ALL PATENT AND OTHER RIGHTS.
 ALL DRAWINGS MUST BE RETURNED WHEN REQUESTED AND USED SUBJECT TO ABOVE CONDITIONS ONLY ON AUTHORISED COMPANY WORK. USE FIGURED DIMENSIONS. SCALING OF DRAWINGS IS AT CONTRACTORS RISK.