

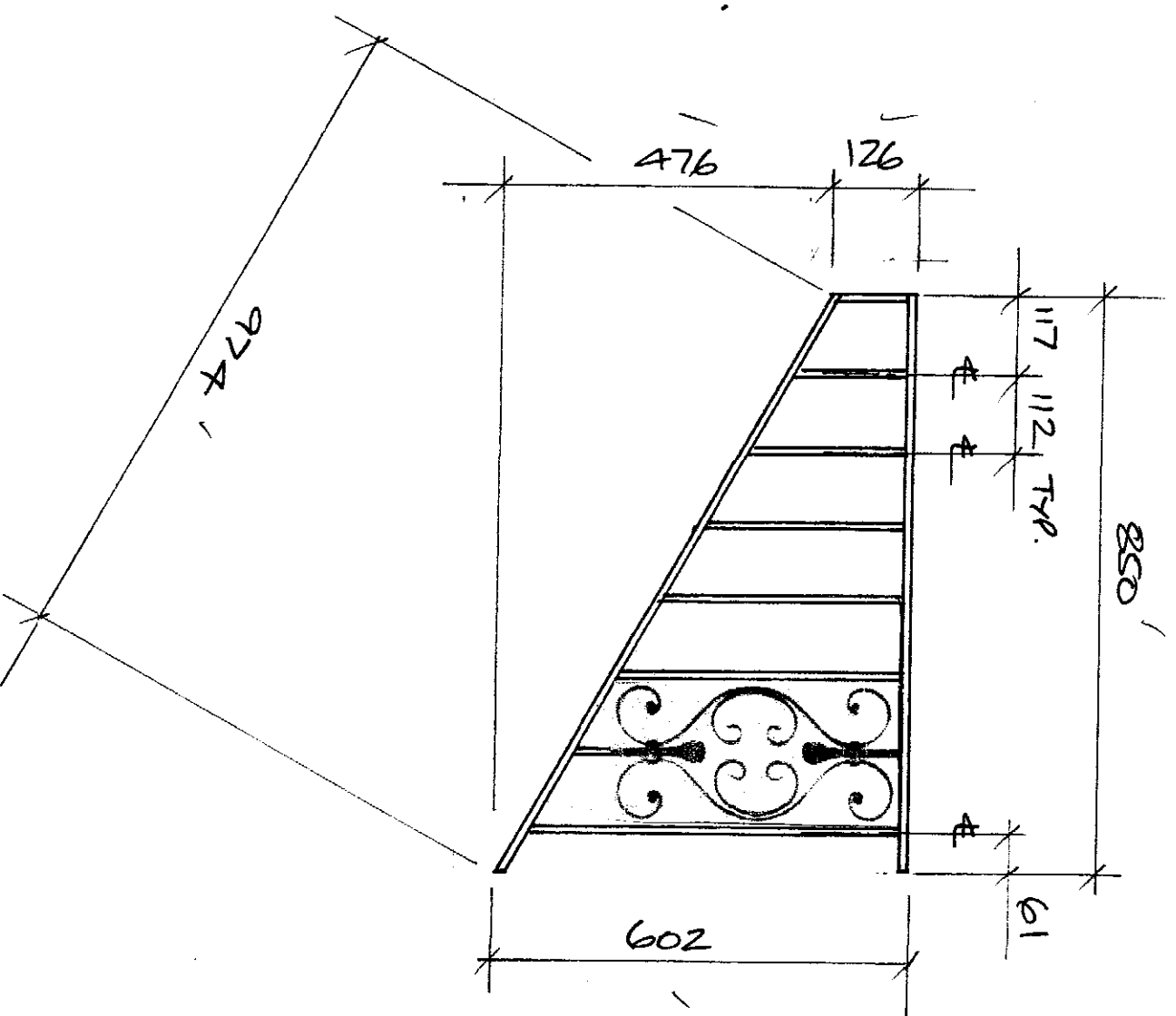
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Z
O
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A
M
G
D

* WHITE & WET SPRAY GLOSS BLACK *

WELDING SPECIFICATION: ALL WELDS TO BE MIN 6MM FILLET WELD UNDO ALL WELDING TO BE PERFORMED IN ACCORDANCE TO AN <u>Approved WPS</u> BS EN 1090-2 - EXECUTION CLASS: 2 WELD FINISH: As welded (Unless stated otherwise) WELD TESTING: 100% Visual Inspection Minimum NDT requirements as per table 24 (BS EN 1090-2)		MANUFACTURE TOLERANCE: GENERAL DIMENSION < 1000mm +/-1mm >1000MM +/-3MM ALL WORKS TO BE CARRIED OUT IN ACCORDANCE WITH ISO 1090 BS EN 1090-2:2008 + A1:2011 AND IN ACCORDANCE WITH SPECIALIST DRAWINGS ALL BURNT PROFILED PLATES TO HAVE 'TRDUGHING REMOVED FROM ALL EDGES ALL PLATE / CUT EDGES TO HAVE 'MARISED' CORNERS TO APPROX 1.5 TO 2.5mm RADIUS ALL WELD SPATTER TO BE REMOVED DURING THE FABRICATION PROCESS AND CHECKED AGAIN AT FINAL COMPLETION REMOVE ALL SHARP EDGES AND BURS. DRILLED AND TAPPED CONNECTIONS INTO HOLLOW SECTIONS ARE TO BE AVOIDED. ALL CH LVL <u>CUG</u> TROUGHS TO HAVE VENT AND DRAIN HOLES.			
QUALITY CONTROL: ALL DIMENSIONS ARE IN MILLIMETRES UNLESS SPECIFIED OTHERWISE.		MATERIAL: STEELWORK GRADES ARE AS FOLLOWS: GENERAL STRUCTURAL SECTIONS TO BS EN 10025-1 GRADE S275JR STRUCTURAL PLATES/ CONNECTIONS BS EN 10210-1 GRADE S275JR STEELWORK TO BE REMOVED FROM ALL EDGES ALL BOLTS AND STUDING TO BE GRADE 8.8 375N/mm² TO EN 14399 UNLESS NOTED OTHERWISE ALL EXTERNALLY EXPOSED BOLTS, NUTS AND WASHERS TO BE SPUN GALVANISED.			
DRAWN BY	DATE	SCALE	JOB NO.	DWG No.	Rev.
KHS	27.3.19	1:10		J 277/15 A	
W.E.S.		UTD.	CONTRACT		2 KENRAT ROAD
			DESCRIPTION		BALUSTRADE
A	20.4.19	Sched	DETAILS		KHS
			CODE		

WORKSHOP NOTE:
MAKE IT TO DRAWING - IF YOU SUSPECT A DRAWING ERROR STOP AND REPORT IT TO YOUR SUPERVISOR FOR IMMEDIATE REMEDY.

SOX10 / CAT TOP / BASE RAIL + L.H. END
12 □ INFILLS



120. REQ'D

* Peined & Gross Back Wet Spray *

ALL WELDS TO BE MIN 6MM FILLET WELD UNO

ALL WELDS TO BE MIN 6MM FILLET WELD UNO

ALL WELDING TO BE PERFORMED IN ACCORDANCE TO AN

BS EN 1090-2 - EXECUTION CLASS:2

As welded (Unless stated otherwise)

WELD TESTING:

100% visual inspection
Minimum NDT requirements as per table 24 (BS EN 1090-2)

MANUFACTURE TOLERANCE:

GENERAL DIMENSION $< 1000\text{mm}$ $\pm 1\text{mm}$ $> 1000\text{mm}$ $\pm 2\text{mm}$

A1:2011 AND IN ACCORDANCE WITH SPECIALIST DRAWINGS

ALL BURNT PROFILED PLATES TO HAVE 'TROUINGING' REMOVED FROM THE SURFACE

ALL WELD SPATTER TO BE REMOVED DURING THE FABRICATION PROCESS
ALL PLATE / COIL EDGES TO HAVE 'ARRISED' CORNERS TO APPROX 1.5 TO 2.5mm RADIUS

AGAIN AT FINAL COMPLETION

REMOVE ALL SHARP EDGES AND BURRS.

DRILLED AND TAPPED CONNECTIONS INTO HOLLOW SECTIONS ARE TO BE AVOIDED

ALL CALV ~~CURVED~~ TROUGHS TO HAVE VENT AND DRAIN HOLES.

QUALITY CONTROL:

ALL DIMENSIONS ARE IN MILLIMETRES UNLESS SPECIFIED OTHERWISE

MATERIAL:

STEELWORK GRADES ARE AS FOLLOWS:

GENERAL STRUCTURAL SECTIONS TO BS EN 10025:1 GRADE S275JR

STRUCTURAL PLATES/ CONNECTIONS BS EN 10210: GRADE S275JR.

Structure: Polygonal, 20' diam. 100' S. 355° E.

ALL BOLTS AND STUDDING TO BE GRADE 8.8 375N/mm² TO EN 1436

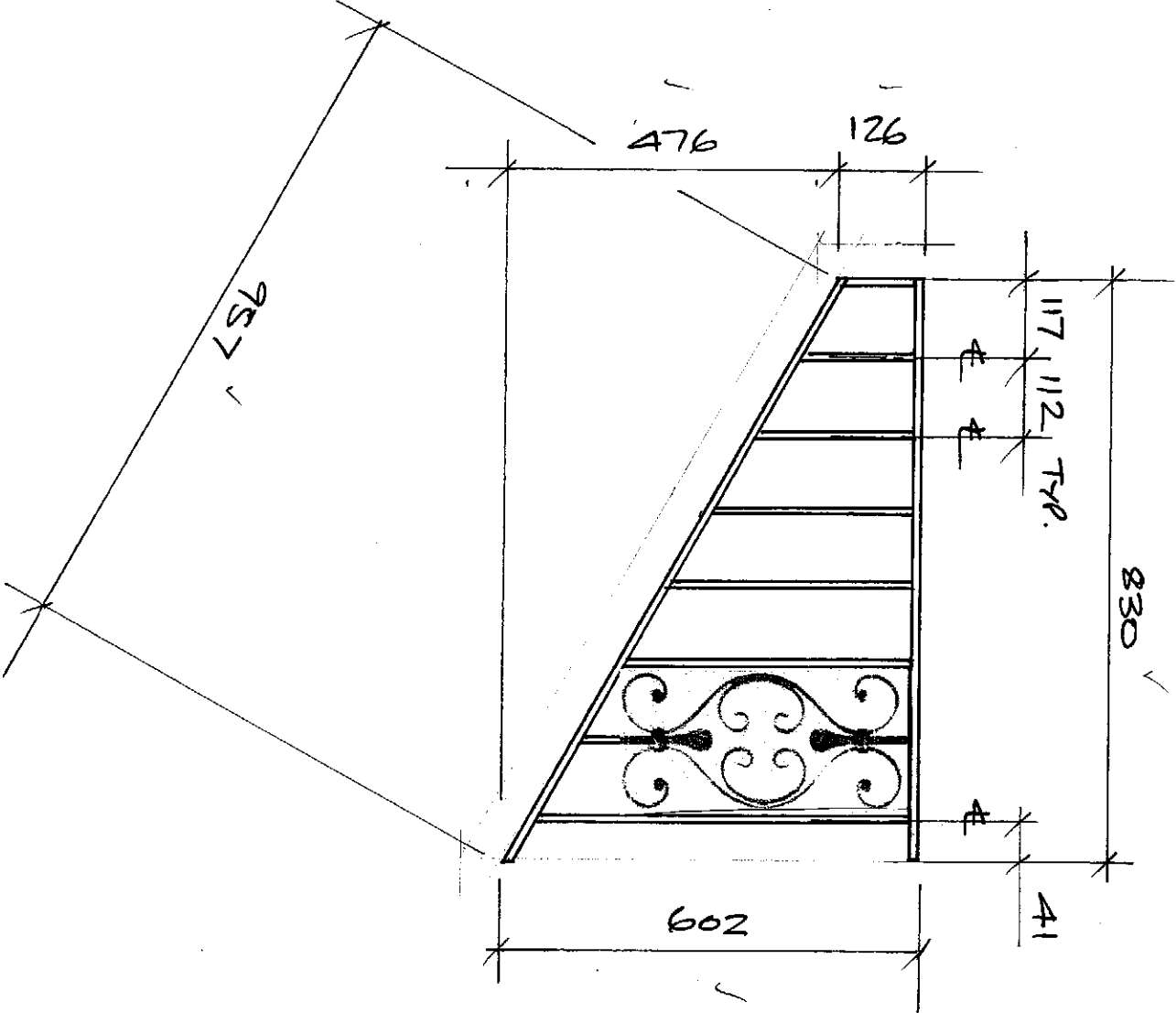
UNLESS NOTED OTHERWISE.

ALL EXTERNALLY EXPOSED JOINTS MUST BE WEATHERED TO THE MAXIMUM

A	20.4.19	SCABR DETAIL	40050		KHS
W.E.S. LTD.			CONTRACT	2 KENRWAY RD.	
			DESCRIPTION	BAULSTRADE	
DRAWN BY	DATE	SCALE	JOB NO.	DRG NO.	REV.
KHS	27.3.19	1:10		J277/K.A	

WORKSHOP NOTE:
MAKE IT TO DRAWING - IF YOU SUSPECT A DRAWING ERROR STOP AND REPORT IT TO YOUR SUPERVISOR FOR IMMEDIATE REMEDY.

50x10 flat top / BASE RAIL + L.H. END
12 @ INFILLS



1 NO. REQ'D

* PEINED & GROSS BACK WET SPRAY *

WELDING SPECIFICATION: ALL WELDS TO BE MIN 6MM FILLET WELD UNO ALL WELDING TO BE PERFORMED IN ACCORDANCE TO AN APPROVED WPS BS EN 1090-2 - EXECUTION CLASS:2 WELD FINISH: As welded (Unless stated otherwise) WELD TESTING: 100% Visual Inspection Minimum NDT requirements as per table 24 (BS EN 1090-2)		MANUFACTURE TOLERANCE: GENERAL DIMENSION < 1000mm +/-1mm >1000MM +/-3MM ALL WORKS TO BE CARRIED OUT IN ACCORDANCE WITH ISO 1090 BS EN 1090-2:2008 + A1:2011 AND IN ACCORDANCE WITH SPECIALIST DRAWINGS ALL BURNT PROFILED PLATES TO HAVE 'TROUGHING' REMOVED FROM ALL EDGES ALL PLATE / CUT EDGES TO HAVE 'ARRISED' CORNERS TO APPROX 1.5 TO 2.5mm RADIUS ALL WELD SPATTER TO BE REMOVED DURING THE FABRICATION PROCESS AND CHECKED AGAIN AT FINAL COMPLETION REMOVE ALL SHARP EDGES AND BURS. DRILLED AND TAPPED CONNECTIONS INTO HOLLOW SECTIONS ARE TO BE AVOIDED. ALL CH LV Cut out TROUGHS TO HAVE VENT AND DRAIN HOLES.				
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DRAWN BY KHS		DATE 27.3.19	SCALE 1:10	JOB No.	DRG No. J277/17 A	Rev. A