



ONE DUCT 5GD-4

SHOP BOLTS:
20-l2x1 1/2 SCREW

**WORK THIS SHEET WITH
"5GD-4a"**

MILL CERTS REQ'D. - YES NO
 SANDBLAST PER SSPC - SP6 - YES NO

DIMENSION CHECK	DATE	CHECKED BY
VISUAL WELD INSPECTION	DATE	CHECKED BY

SHOP NOTES

1. PAINT ERECTION MARKS ON LEFT OF MEMBER AS DETAILED. FOR BEAMS - LEFT END - TOP FLANGE & NEAR SIDE OF WEB.
2. OMIT PAINT FROM ALL NELSON STUDS AND SURFACES NOTED "*".
3. BOTH SIDES OF MATERIAL ADJACENT TO OPEN HOLES MUST BE FREE OF LOOSE SCALE AND BURRS.
4. ALL WELDING TO BE DONE A.W.S. CERTIFIED WELDERS AND PER A.W.S.-D1.1.
5. WELDS SHOWN ARE FOR STRENGTH - SEAL WELD ALL JOINTS WHEN GALVANIZING IS REQ'D.

ERECTOR NOTE!
USE I-HIGH STRENGTH WASHER OVER ALL SLOTS IN CONNECTION ANGLES FOR ALL BEAM TO BEAM AND BEAM TO COLUMN CONNECTIONS.

ALL VERIFIES WILL BE ASSUMED CORRECT AS SHOWN UNLESS NOTED OTHERWISE BY APPROVER

REV	DATE	DESCRIPTION
2	06-24-15	HOLES ADDED
1	06-05-2015	REVD WELDS
0	05-26-2015	FOR FABRICATION

HOLES 13/160	PAINT ONE COAT RED OXIDE PRIMER
JOB and LOCATION	
ITEM GAS RECIRC DUCT TO FURNACE	
CUSTOMER ALSTOM POWER INC.	
DRAWN BY IH	DATE MAY '15
CHECKED BY VP	REF. 27155-4E9196
ORDER NO. S11152-2	SHEET NO. SGD-4
REV. 2	