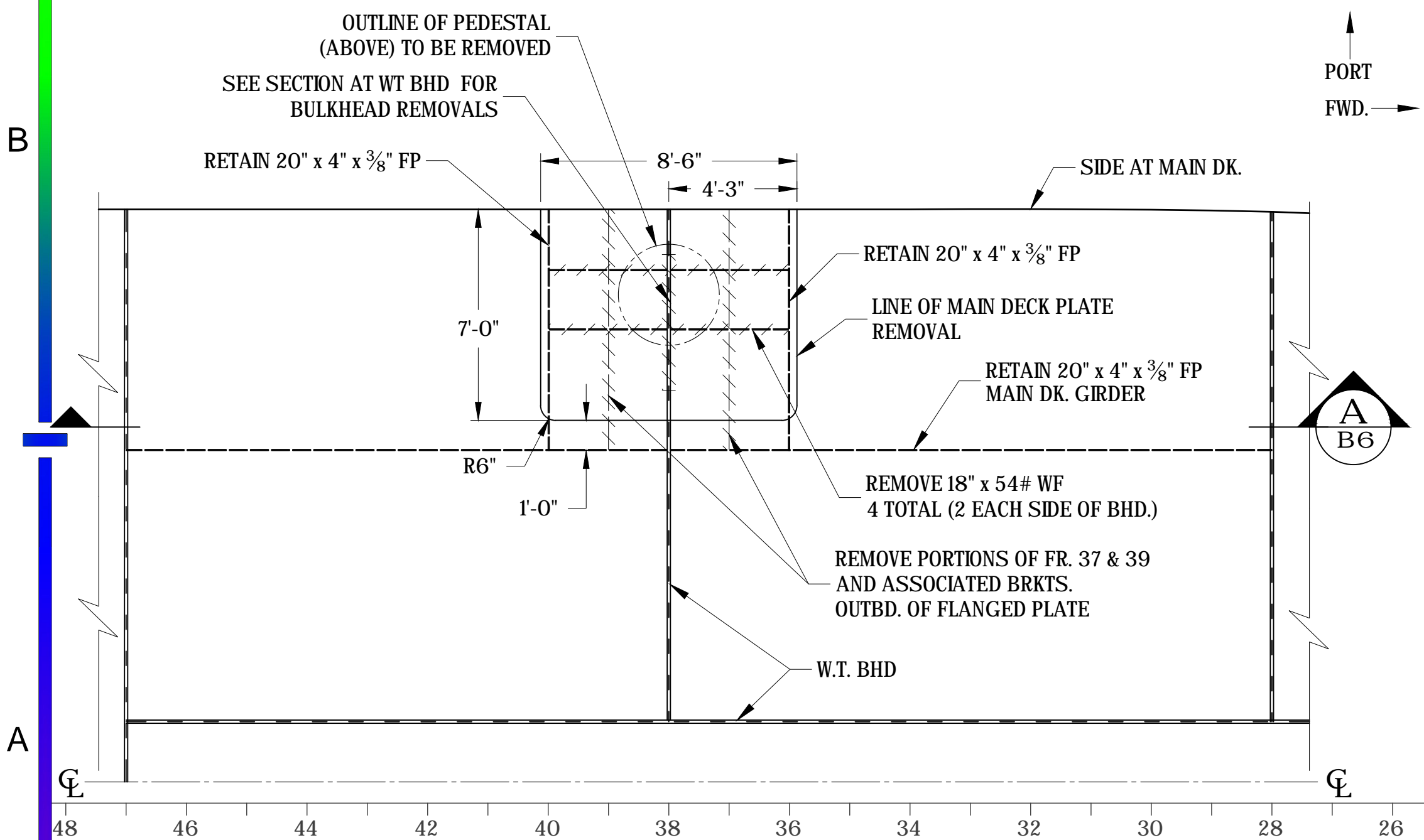


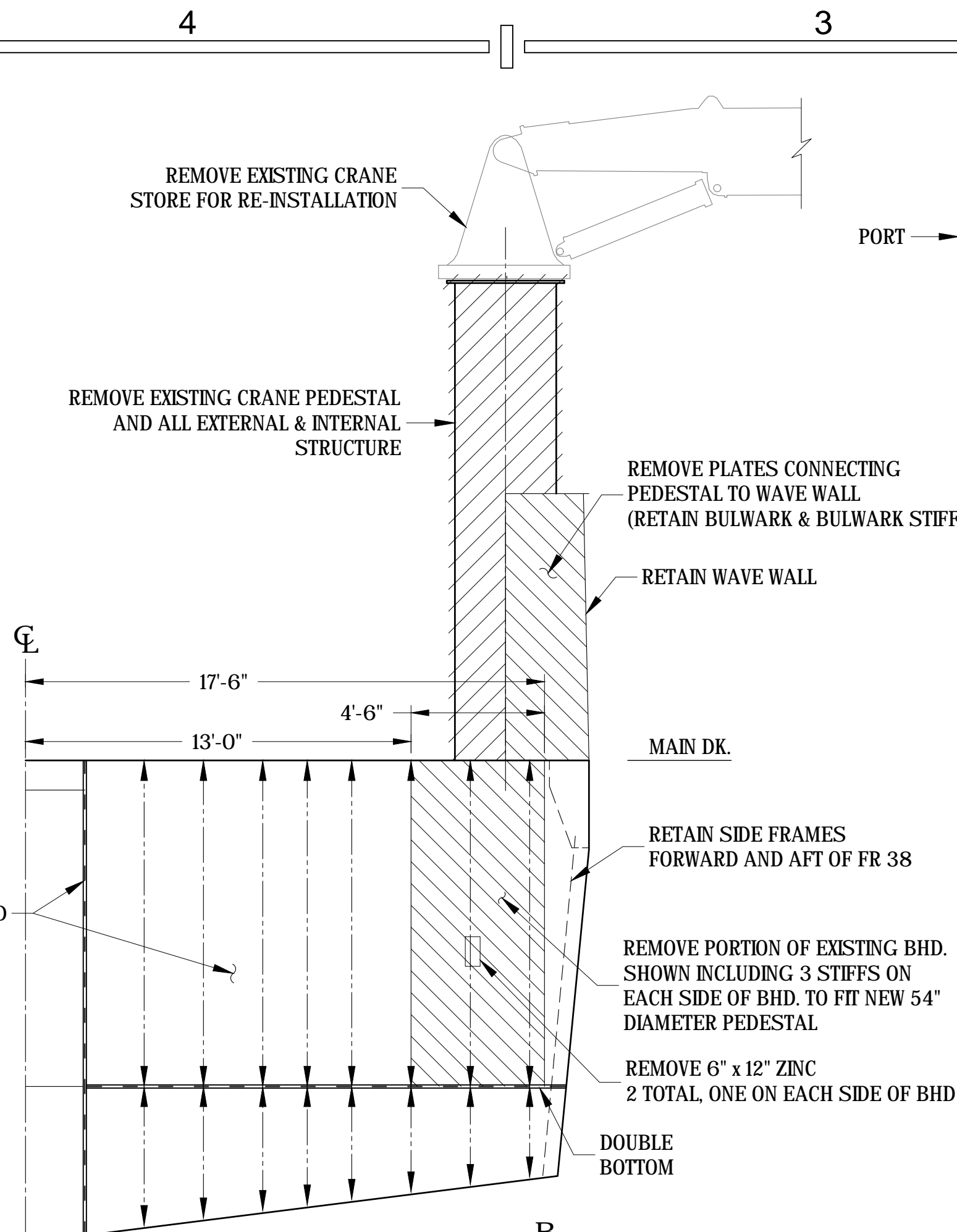
A4 Longl. Section I.W.O. Removals

Looking to Port
Scale $\frac{1}{4}" = 1'-0"$



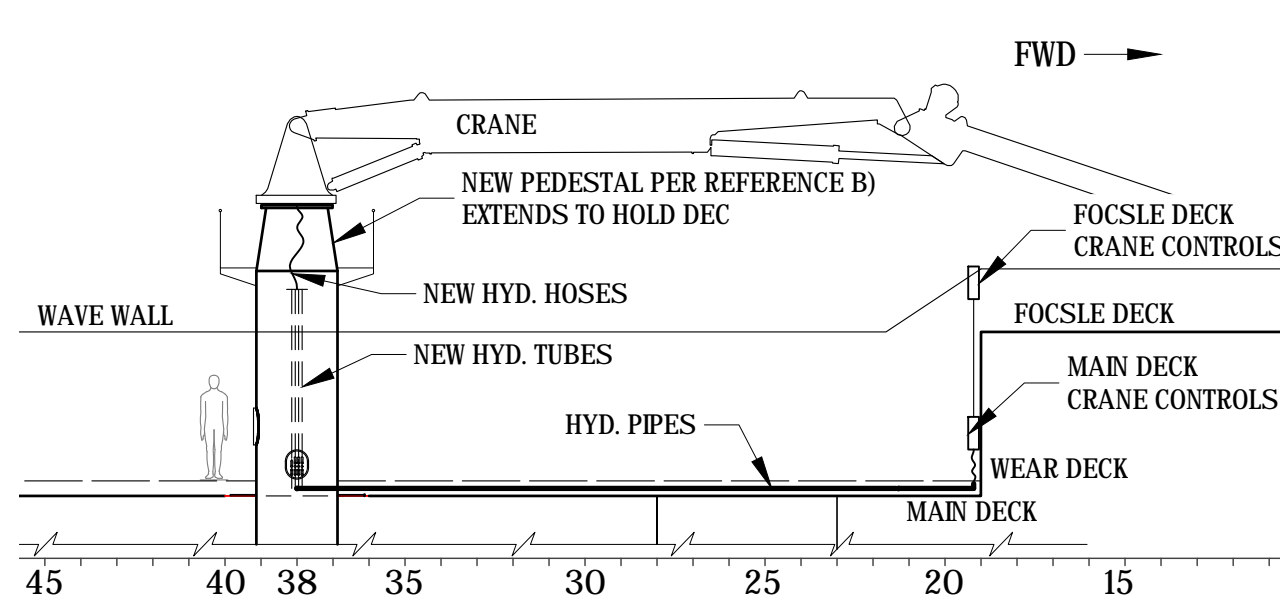
A6 Structural Removals at Main Deck, I.W.O. Pedestal

Port Side - Plan View
Deck Plate & Deck Frames Omitted for Clarity
Scale $\frac{1}{4}" = 1'-0"$



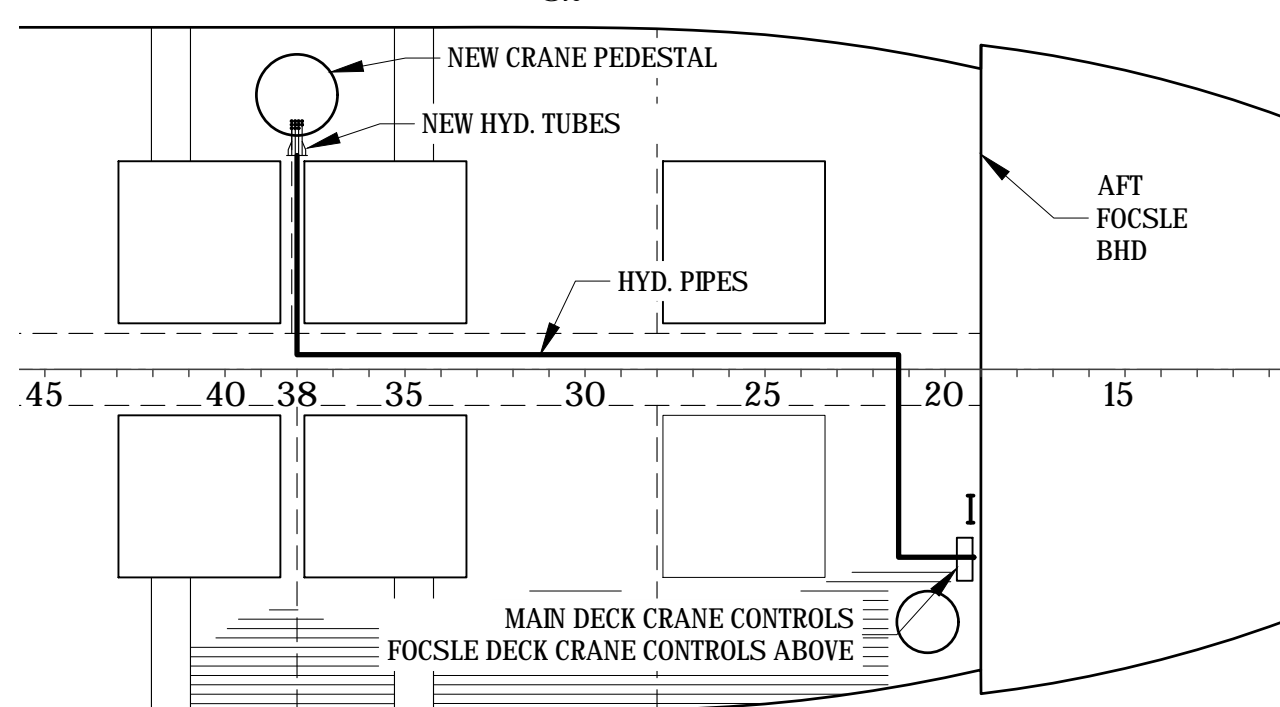
B6 Section at W.T. Bhd - Fr. 38

Port Side - Looking Aft
Scale $\frac{1}{4}" = 1'-0"$



B6 Key Profile

Scale $\frac{3}{32}" = 1'-0"$



B6 Key Plan

Scale $\frac{3}{32}" = 1'-0"$

No.	Welding Specifications
1.	WELD SCHEDULE Unless specifically noted otherwise, all welds shall be double continuous fillet welds. Fillet size of double continuous welds shall be approximately equal to $\frac{1}{8}"$ less than the thickness of the thinnest plate. Welding shall develop the full strength of the materials being joined.
2.	WELD PROCEDURES AND PREPARATION Prior to completing any welding, Contractor shall submit weld procedures to the Owner for approval. Weld procedures shall be based on ABS Rules for Material Welding, or similar AWS criteria. Weld procedures shall clearly describe allowable electrode, weld geometry, fit-up gap, edge preparation, weld type, amperage, gas, number of passes, etc.
3.	WELDER CERTIFICATION All welding shall be done by welders holding a valid qualification issued by ABS or AWS for the approved weld procedures. Contractor shall maintain a copy of all certifications for review by the State.
4.	WELD TESTING Weld testing shall occur as follows; a. All watertight welds shall be soap/vacuum box, or hose tested. Watertight welds are: all insert plate welds, pedestal to main deck welds, pedestal to bhd 38 welds, pedestal to hold deck welds, and welds at the bolted access in the Hold. Any defects found during weld testing shall be removed, re-welded, and re-tested. Contractor shall submit all weld test results to the Owner for approval. Additional weld testing of pedestal critical welds is required after a 125% Load Test. See Reference B).

Line Key

- W.T. OR O.T. BULKHEAD
- N.T. BULKHEAD
- GIRDER OR DEEP FRAME
- FRAME
- STIFFENER

No.	General Notes
1.	DESIGN BASIS The new pedestal in this drawing was designed in accordance with ABS Rules for Certification of Lifting Appliances 2017. This engineering is based on the crane load capacities in Reference A) and the overturning moments and vertical loads shown in the "Design Requirements" table in Reference B).
2.	CONSTRUCTION a. The new crane pedestal shall be provided fully assembled, as shown in Reference B). b. Pedestal shall be installed in accordance with ABS Rules for Certification of Lifting Appliances. c. All new steel plate, bar, and shapes shall be ASTM A36 with a minimum yield stress of 36 ksi or greater. d. Sharp or ragged edges shall be ground smooth to prevent injury to personnel or damage to equipment. Discontinuities, undercutting, notches, or other mechanical damage which might initiate or propagate cracks in the structure shall be eliminated or repaired. e. Where items are cut away from the vessel's structure, the remaining material shall be ground smooth with adjacent structure and new coatings applied to match adjacent structure. f. Contractor is responsible for the temporary removal of interferences to access and hot work. Materials removed as interferences shall be restored to like new conditions with new materials. Existing materials may be reinstalled if the surface has no damage or blemishes.
3.	OPERATION The crane shall be operated within the limits provided in the Design Requirements Table in Reference B) and the crane manufacturer's recommendations.

No.	References
A.	NPCC SWEEP CHART, ALASKA MARINE CRANE MODEL MCKT-2265, AS RIGGED SWEEP LOAD CHART, SC-2154.
B.	CWC dwg 17012-08-02 REV - CRANE PEDESTAL
C.	HOMEPORT MARINE dwg P-2 REV A FILLS, VENTS & SOUNDS

Rev.	Sheet	Zone	Revisions	Responsible Engineer
-	INITIAL ISSUE			PTE

Agency	Date	Approvals	Action
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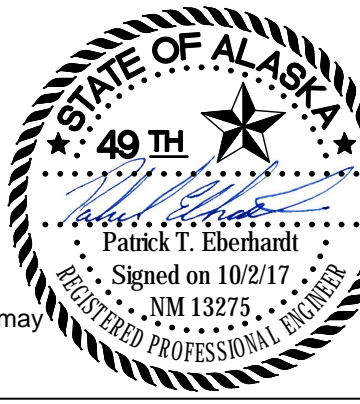
Responsible Engineer	Date	Company	Authorization	Scope
PTE	10-02-17	COASTWISE	AECCL476	REV. - :STRUCTURE ALL SHEETS



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Drawn	OEC	Title	SubTitle
Project #	17012	Project	PV Stimson Crane
Scale	As noted on 34" x 22" Sheet	Client	AK Dept. of Public Safety
Dwg. No.	17012-02-01	Sheet 1 of 2	Rev. -



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