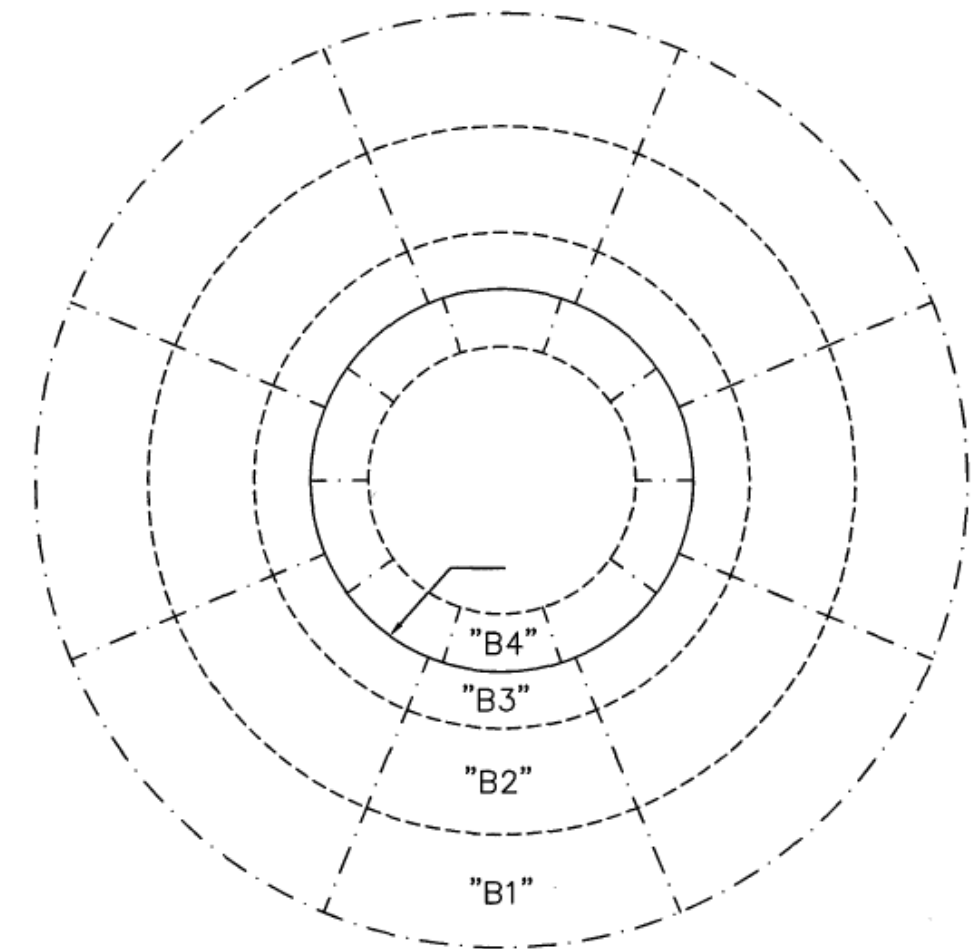


WELD LEGEND
--- SHOP
--- FIELD
--- NO X-RAY REQ'D

WELDER	ID

X-Ray Requirements @ Roanoke Co, VA E-8344 250 Ped						Shop	
43' -8" Dia x 31'-0" HR x 121'-0" HWL x 26' -0" Dia Base Cone						Shop Footage	Shop Ftg Shots
Group ***	Thickness range	Seams Included	Field Footage	Qual Shots	Footage Shots		
Group 1P	1/4" - 3/8"	S2 - S2	480	2	5		
Group 1S	1/4" - 3/8"	S1 - S2	137	1	1		
Group 2P	15/32" - 19/32"	S1 - S1	175			175	
		C4 - C4	43				
		C1 - C1	Shop			12	
		Total	218	2	2	187	2
Group 2S	15/32" - 19/32"	C4 - S1	97	1			
		C3 - C4	Shop			70	
		Total	97	1	1	70	1
Group 3P	5/8" - 3/4"	C3 - C3	43				
		C2 - C2	10			41	
		Total	53	2	1	41	1
Group 3S	5/8" - 3/4"	C2 - C3	42	1			
Pedestal	N/A	B1 - B2				64	
		B2 - B3				46	
		B3 - B4	30				
Note: Vertical seams in base cone and pedestal shaft do not require x-ray. No junctions are required.		B4 - P1				29	
		P1 - P2	29				
		P2 - P3				29	
		P3 - P4	29				
		P4 - P5				29	
		P5 - P6	29				
		Total	117	1	1	197	1
		Total		11	11		5
Note: of the above Field Qual & Footage shots, (Excluding Group "Pedestal"), 2 shall be junctions. Qualification shots are based on four welders, with two welders qualifying per shot; one welding inside and one welding outside. Add qualification shots for additional welders used in any group based on two welders per shot.							
*** "P" and "S" Differentiate between "Primary" and "Secondary" stress seams.							



PLAN VIEW OF BASE CONE **AS BUILT**

ELEVATION OF STEM

NOTE:
1. THIS DRAWING TO BE USED IN CONJUNCTION WITH DRAWING XR2.
2. NO X-RAY REQUIRED ON ALL VERTS ON BASE CONE AND STEM, TYPICAL.

NOTE:

THE SYMBOL ABOVE SHOULD BE USED TO DESIGNATE THE WELDER OF EACH SEAM. PUT THE OUTSIDE WELDER'S INITIAL ON TOP OF THE LINE AND THE INSIDE WELDER'S INITIAL ON THE BOTTOM OF THE LINE. IF DIFFERENT WELDERS WELDED SEAMS OF THE SAME SECTION, YOU MUST SPECIFY EACH WELDER AT EACH SEAM.

REV.	BY:	DATE	REMARKS
CALDWELL Since 1887 Water - Energy - Industrial			
ROANOKE COUNTY, VIRGINIA 250,000 GALLON PEDESHERE TANK			
BY:	JLH	TITLE:	FIELD X-RAY LAYOUT
DATE:	9/09/15	DRAWING NO.:	E-8344 XR2