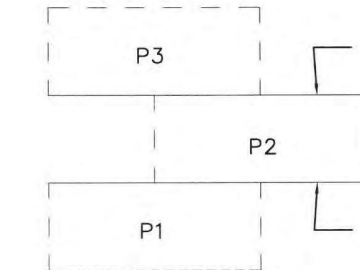
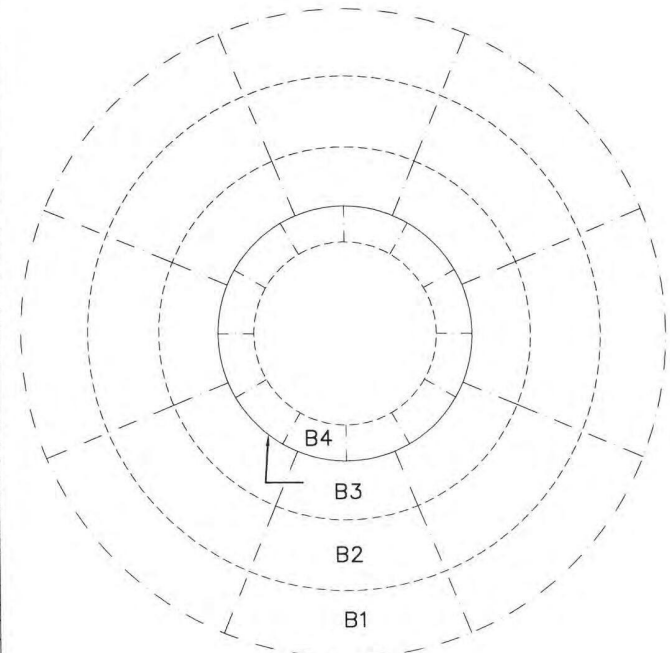


WELD LEGEND

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

WELDER	ID

X-Ray Requirements @ Franklin Co., VA E-8884 500 Ped						
55'-6" Dia x 37'-6" HR x 102'-6" HWL x 27'-6" Dia Base Cone x 10' Ø Pedestal						
Group ***	Thickness range	Seams Included	Field Footage	Qual Shots	Footage Shots	
Group 1P	1/4" - 3/8"	S4 - S4	104			104
		S3 - S3	174			174
		S2 - S2	161			108
		Total	439	2	4	386
Group 1S	1/4" - 3/8"	S3 - S4	153			
		S2 - S3	174			
		S1 - S2	161			
		Total	488	1	2	
Group 2P	23/32" - 27/32"	S1 - S1	161			108
		C4 - C4	86			
		C1 - C1				14
		Total	247	2	2	122
Group 2S	23/32" - 27/32"	C4 - S1	125			
		C3 - C4				89
		Total	125	1	1	89
Group 3P	15/16"	C3 - C3	86			
		Total	86	1	1	
Group 4P	1 1/8"	C2 - C2	15			75
		Total	15	1		75
Group 4S	15/16"	C2 - C3	52			
		Total	52	1	0	
Pedestal	N/A	B1 - B2				69
		B2 - B3				50
		B3 - B4	34			
		B4 - P1				31
		P1 - P2	31			
		P2 - P3	31			
		Total	96	1	0	150
		Total		10	10	7
Note: of the above Field Qual & Footage shots, (Excluding Group "Pedestal"), 6 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.						

ELEVATION OF STEM

PLAN VIEW OF BASE CONE


AS-BUILT

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.

NOTE:

- 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.

REV.	BY:	DATE	REMARKS
			
FRANKLIN COUNTY, VIRGINIA 500,000 GALLON PEDESHERE TANK			
BY:	JLH <i>✓</i>	TITLE: FIELD X-RAY LAYOUT	
DATE:	12/11/19	DRAWING NO.:	E-8884 XR2