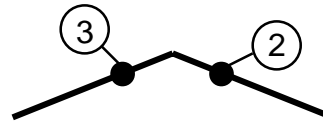


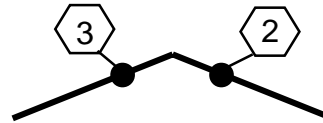
Overview

These slides cover the following Welding topics -

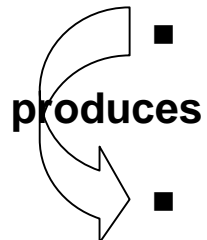
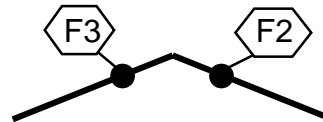
- Weld Numbering



- Weld Number Enclosures



- Weld Number Prefixes



- Weld Definition File

- A Weld Summary Box - Plotted and Printed

Welding output facilities are controlled in the following ways :-

1) By Option Switches - OS 53 OS 54 and OS 75

2) By Weld Number Prefixes - Records -130 -131 -132 -133

(These are input into the Pipeline Header but we have to find out how to do this in I-SKETCH)

3) By the Welding Definition File - WDF

(This is a WELDING-DEFINITION record in the FLS)

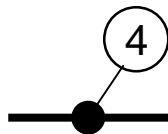


1) By Option Switches - OS 53 OS 54 and OS 75

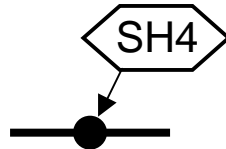
For details - see the Option Switch slide set - full information is given there

Then use the Options Switches Editor to make the required settings to these Option switches

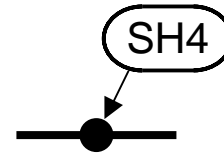
These are the alternative enclosure shapes obtainable by setting OS 75 Position 1



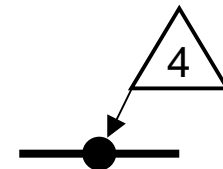
0



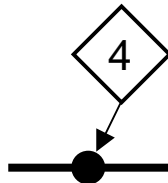
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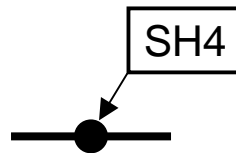
2



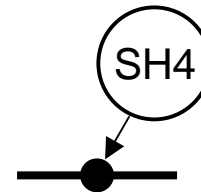
3



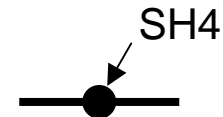
4



5



6

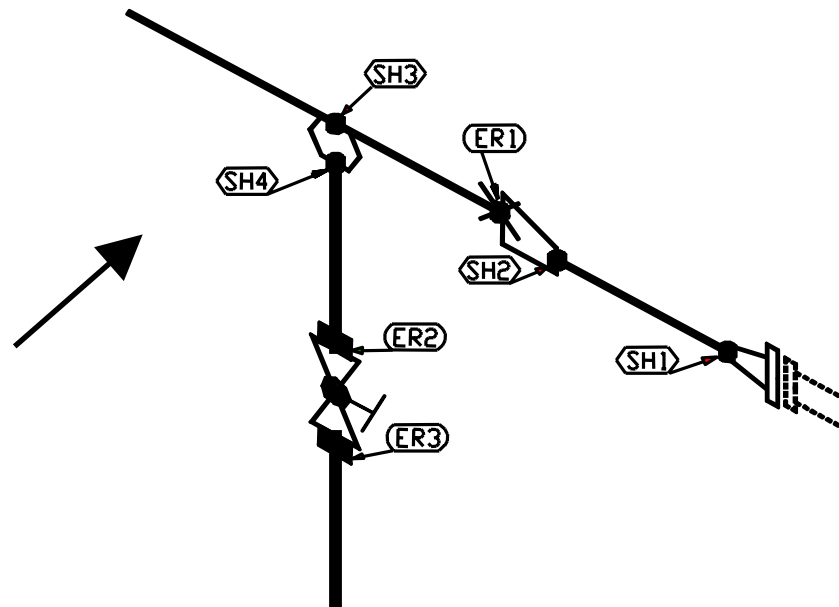


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2) By Weld Number Prefixes

- 130 General Weld Number Prefix
- 131 Fab Weld Number Prefix
- 132 Erection Weld Prefix
- 133 Offshore Weld Prefix

Then the Weld Prefix
identification
on the isometric
looks like this -



Weld Summary Box

A plotted User Defined Weld
Summary Box looks
like this -

WELD No	SIZE INS	WELD TYPE	WELD CATEGORY
FA1	4"	BW	S
FA2	3"	BW	S
ER3	4"	BW	F
FA4	4"	BW	S
ER5	2"	BW	F
FA6	1"	LET	S
ER7	1"	BW	F
FA8	1"	BW	S
FA9	1"	BW	S

This is a 'STYLE 2' line / column
based type of Weld Summary Box

It is produced from this type
of WDF control file and by setting
OS 53 Pos 2 = 1

WELD-BOX-HEADINGS

WELD No	SIZE INS	WELD TYPE	WELD CATEGORY
------------	-------------	--------------	------------------

WELD-BOX-DATA-ITEMS

'WELD-NO'	4	R
'N. S. '	14	L
'WELD-TYPE'	22	L
'WELD-CAT'	32	L

The WDF is named in the FLS
with a WELDING-DEFINITION
record

Weld Box Data - Permissible Data Items -

' WELD-NO' n j
' N. S. ' n j
' WELD-TYPE' n j
' WELD-CAT' n j
' THICKNESS/RATING' n j
' WELD-SPEC' n j
' WELD-REM' n j

n =
column
position

j =
justification
(L or R)

' WELD-NO' 4 R
' N. S. ' 14 L
' WELD-TYPE' 22 L
' WELD-CAT' 32 L
' THICKNESS/RATING' 38 L
' WELD-SPEC' 46 L
' WELD-REM' 52 L

You may only list
this item if
you are using a CIF

You may only list
these two items if
there are
WELD-SPEC and
WELD-REM entries
present in the IDF

There is also a 'Style 3' type of Weld Summary that looks like this

WELD OPERATIONS			
WELD NO.	SIZE	WELD TYPE	SCHEDULE
1	6"	BW	040
2	6"	BW	040
3	6"	BW	040
4	6"	BW	040

This type of Weld Summary box may only be used in conjunction a User Defined backing sheet

The headings and enclosure lines are made part of the backing sheet and the data items are edited in using X-Y co-ordinate data that is specified in the WDF like this

Also - set OS 53 Pos 2 = 2

WELD-INFO-CONTROLS
CONTINUOUS-DOWN
START-POSITION 256.0 121.0
VERTICAL-SPACING 3.8
TEXT-HEIGHT 2.4
MAXIMUM-ENTRIES 18

WELD-INFO-DATA-ITEMS
'WELD-NO' 256.0
'N. S.' 288.0
'WELD-TYPE' 338.0
'THICKNESS/RATING' 389.0