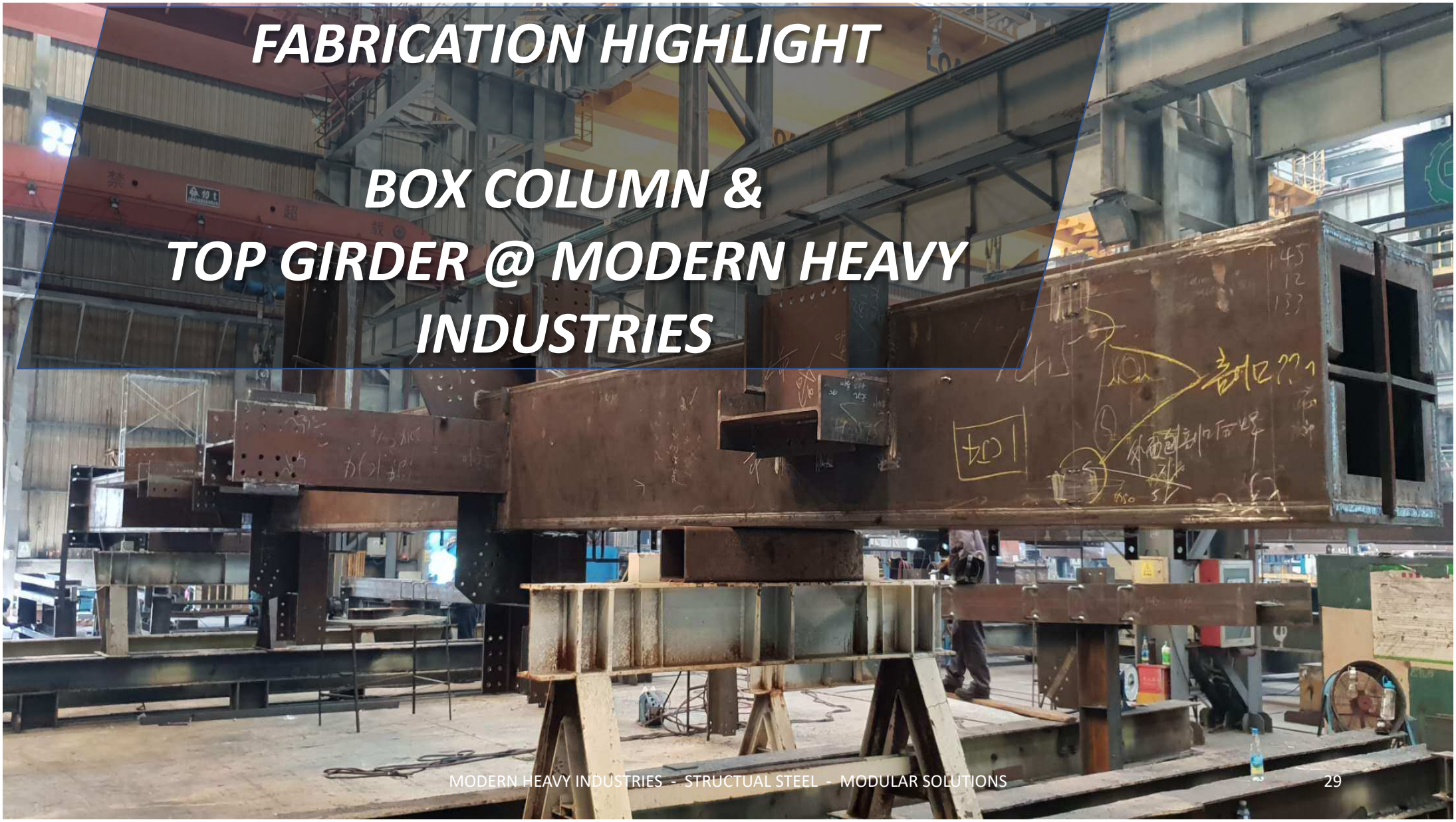


FABRICATION HIGHLIGHT

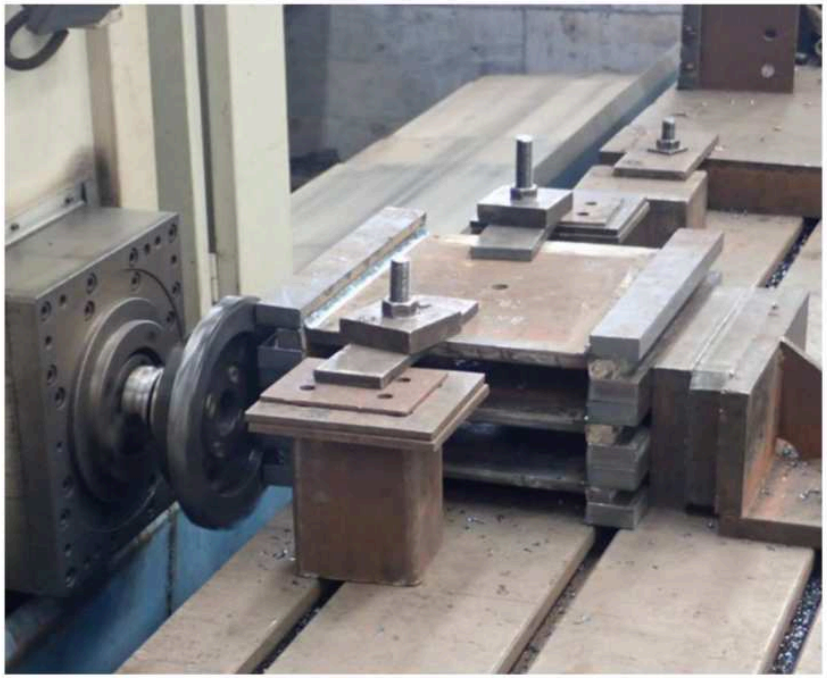
BOX COLUMN & TOP GIRDER @ MODERN HEAVY INDUSTRIES

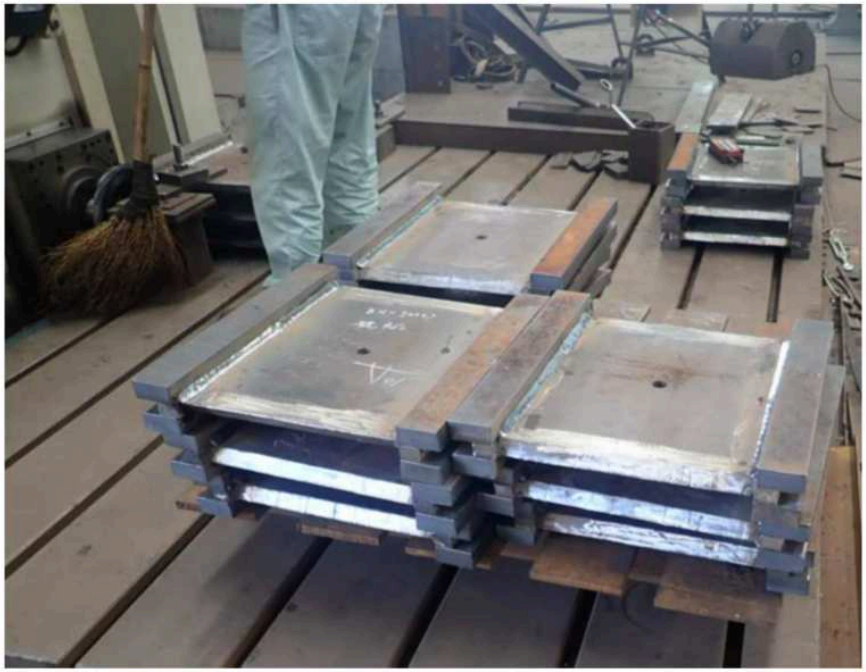
7. Beveling required for weld preparation for TG and BG will cut into plates using Track-Oxy flame cutter. All bevels will be controlled to maintain appearance and tolerance according to AWS.

Plate edge beveling according to weld preparation requirement.

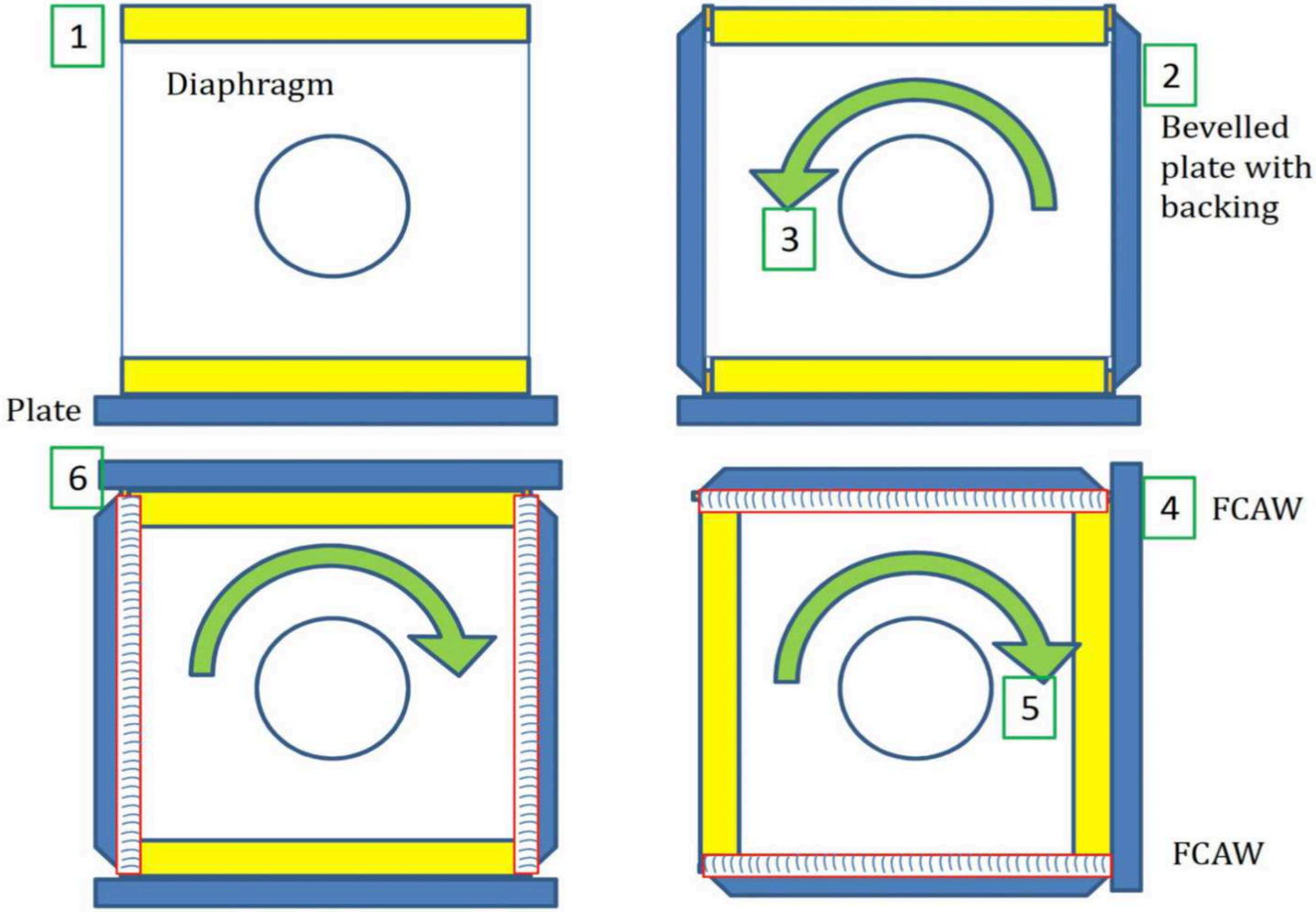
8. All plate bevels and plate edges will be ground in accordance to the quality standard.

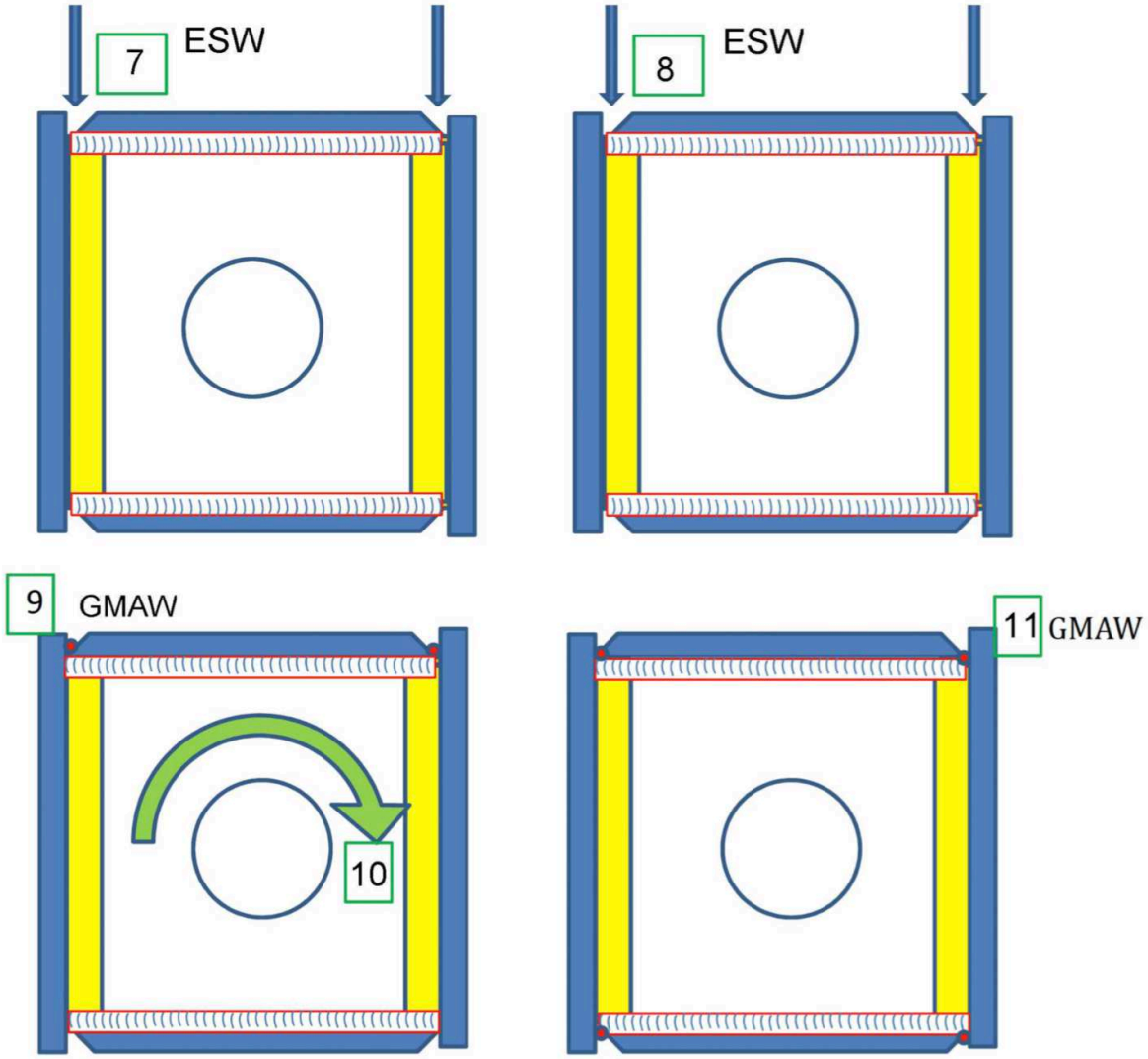
1. After plates are prepared as above, the diaphragm (stiffeners) are prepared & milled to dimensional accuracy.

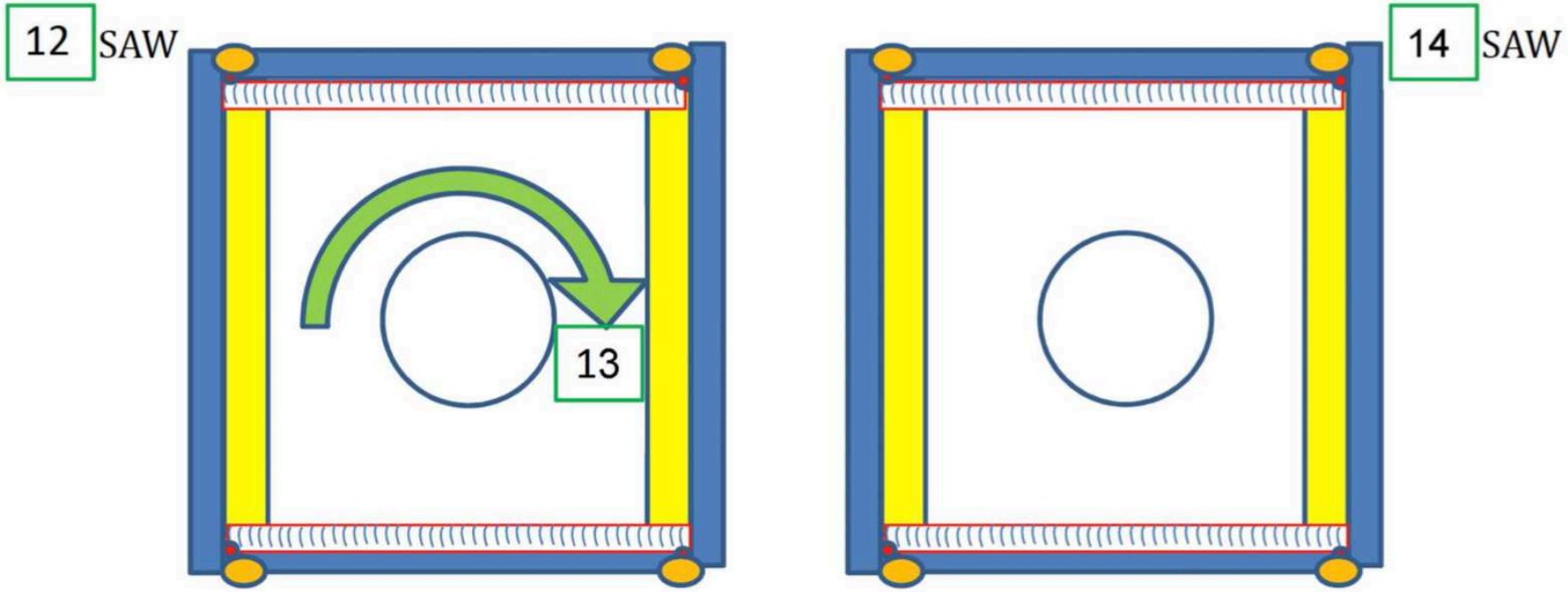




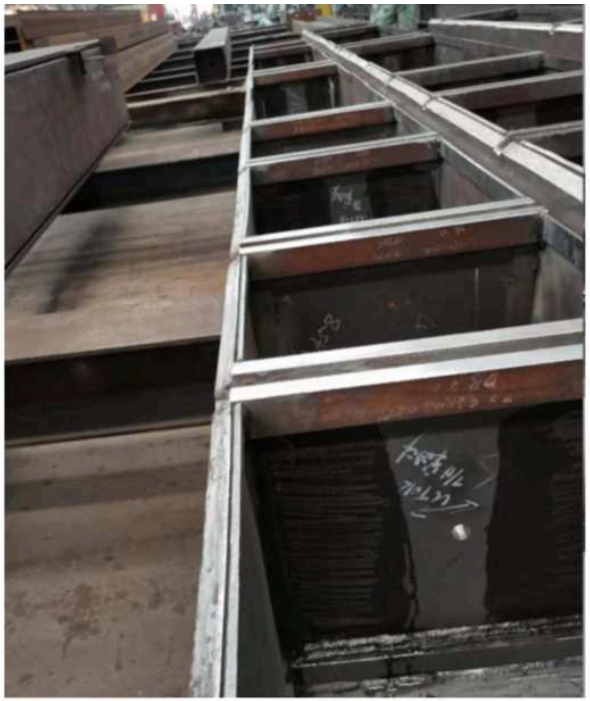
2. Backing bars are added top box column plates. The BC plates and stiffeners are fitted together.




7
ESW
8
ESW
9
GMAW
10
11
GMAW

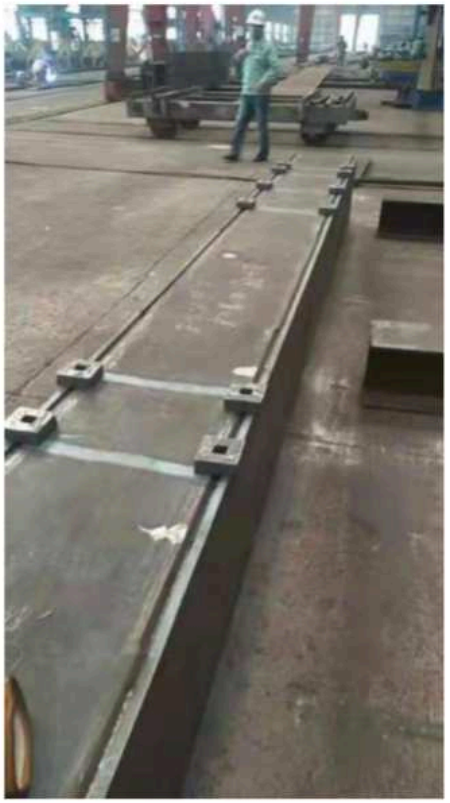


****Please note the order for ESW-to-root weld, or root weld-to-ESW may be reversed according to the methodology of fabrication and welding procedure. This is project specific.**



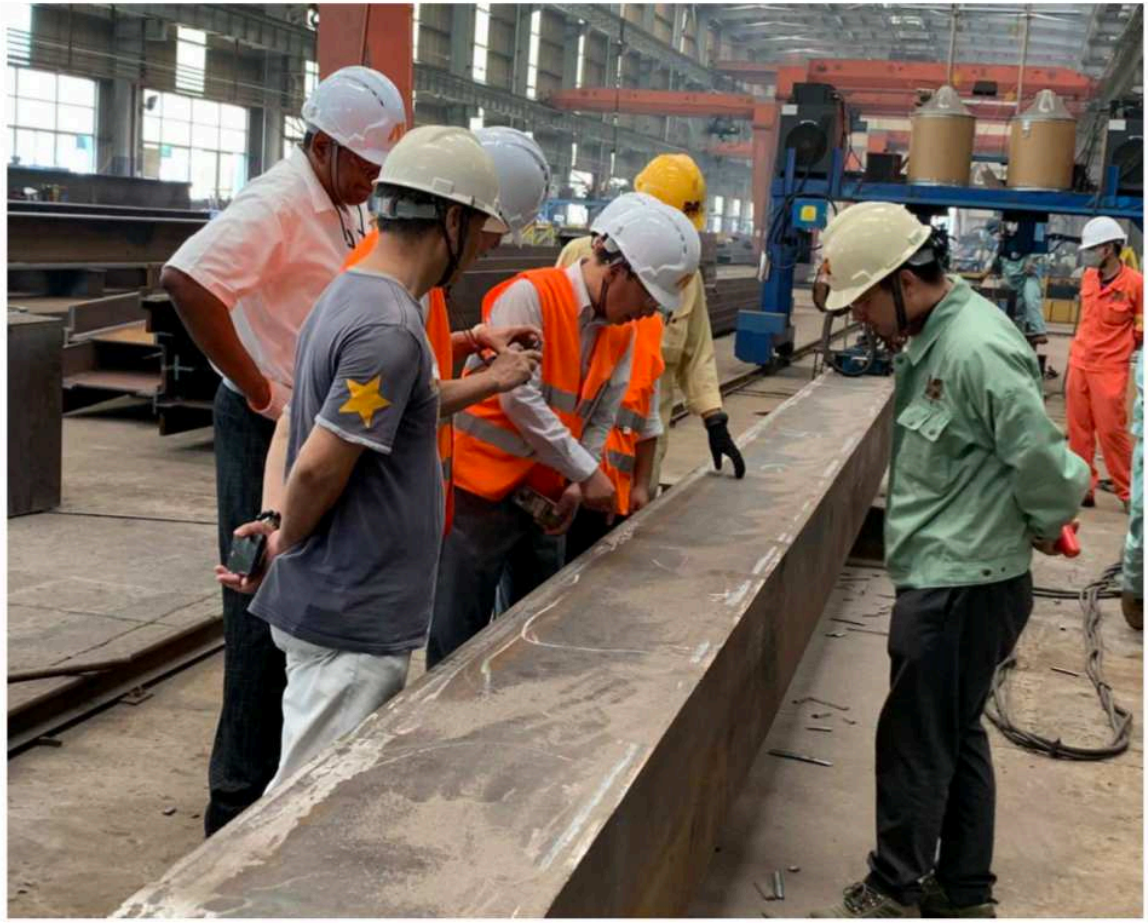
Stiffener & Box Assembly.

3. ESW slots are added to the box cover plate for ESW welding that will come later.



4. ESW welding is performed as required to complete stiffener internal welding.

5. SAW welding is performed to complete the joints.



7. The BC is moved to **Bay 3** for fit out.

8.All components are added to the box to complete the assembly.


MODERN HEAVY INDUSTRIES - STRUCTUAL STEEL & MODULAR SOLUTIONS

9. Completed BC will be blasted, painted, packed and delivered.