

FIELD SERVICES DEPARTMENT

BASE PLATE FIELD MODIFICATION

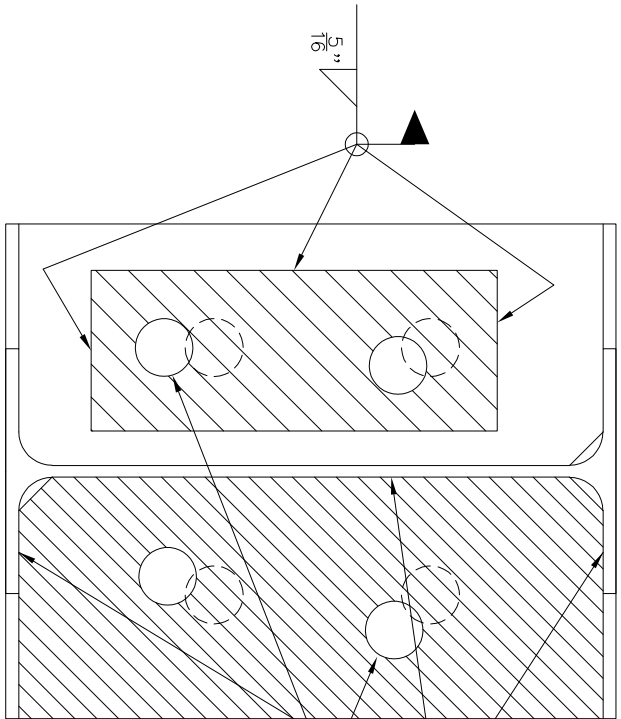
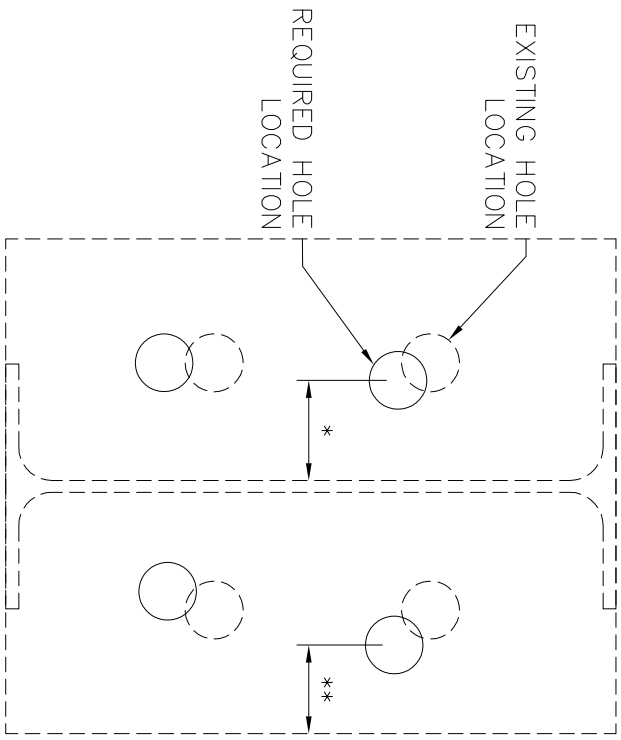
REF: 19-B-27802

PG: 1/L

DATE: 05-11-23

BY: WTW

**NOTE: WELD WASHER / PLATE MATERIAL
TO BE MINIMUM 50 KSI.
WELD WASHER / PLATE TO EQUAL
EXISTING PLATE THICKNESS.**



HOLE ϕ = BOLT ϕ
 $+\frac{3}{16}$ " for $\frac{5}{8}$ " - 1" ϕ
 rods, $+\frac{5}{16}$ " for $1\frac{1}{4}$ "
 and $1\frac{1}{2}$ " ϕ rods

* = MINIMUM DIMENSION ($\frac{1}{2}$ " MAX WIDTH OF NUT + WELD SIZE FOR WELD CLEARANCE)
 ** = MINIMUM EDGE ($\frac{15}{16}$ " FOR $\frac{5}{8}$ " ϕ BOLTS, 1" FOR $\frac{3}{4}$ " ϕ BOLTS, $1\frac{3}{8}$ " FOR 1" ϕ BOLTS, $1\frac{3}{4}$ " FOR $1\frac{1}{4}$ " ϕ BOLTS & 2" FOR $1\frac{1}{2}$ " ϕ BOLTS)

FIELD MODIFICATION FOR BASE PLATE

- ALL WELDING IS TO BE PERFORMED BY AWS CERTIFIED WELDERS QUALIFIED IN ACCORDANCE WITH AWS D1.1 FOR PROCESS AND POSITION REQUIRED.
- ALL WELDING IS TO BE PERFORMED USING ELECTRODE REQUIREMENTS FOR GROUP II STEEL IN ACCORDANCE WITH LATEST EDITION OF AWS D1.1 TABLES.
- THE CONTRACTOR SHALL PROVIDE ADEQUATE STRUCTURAL SUPPORT DURING MODIFICATIONS.