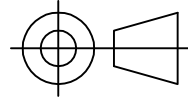


DRAWING LIMITATIONS:

CRACKS IN CHASSIS WEB ONLY
EXCLUDES ALL FLANGE CRACKS



DO NOT SCALE – IF IN DOUBT ASK

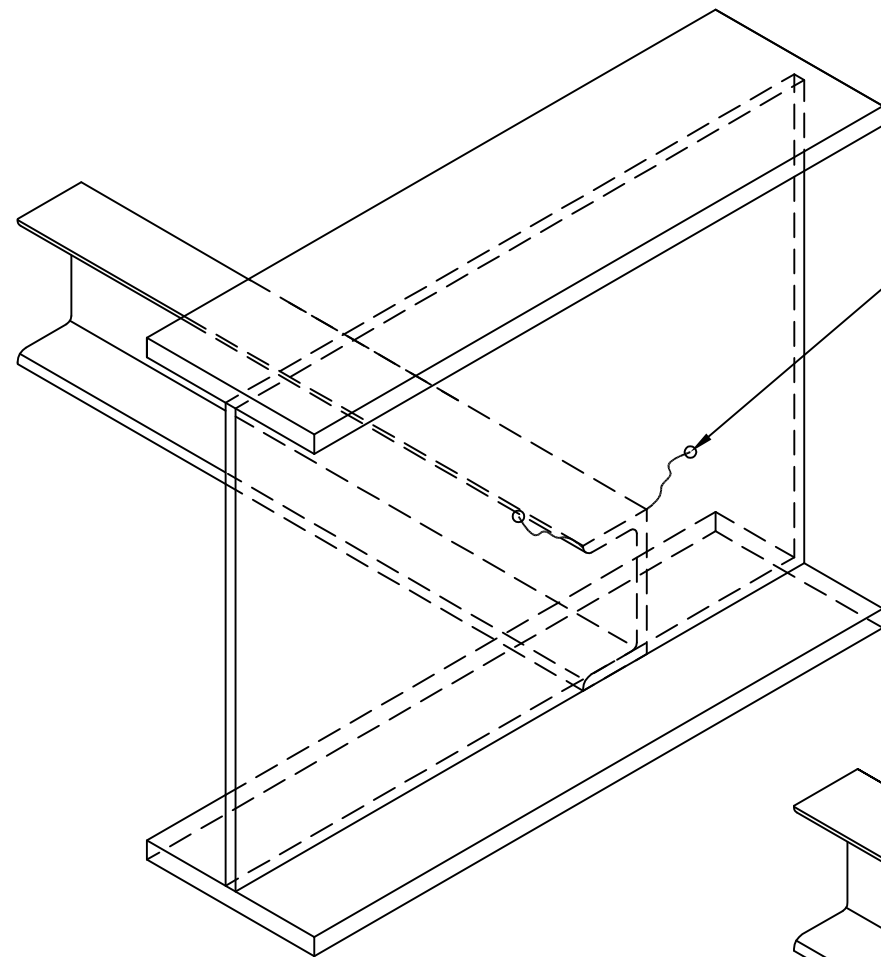
ALL DIMENSIONS IN MILLIMETRES
TOLERANCES CLASS II UNLESS
OTHERWISE SPECIFIED
WELD SYMBOLS TO AS1101.3-1987

NOTES:

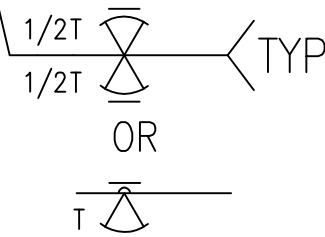
1. WELDING OF STEEL SECTIONS TO COMPLY WITH AS/NZS1554 PART 1(CATEGORY SP)
 - WELDING AND JOINT PREP. TO COMPLY WITH SECTION 4.
 - WELDER TO BE CURRENTLY CERTIFIED TO CLAUSE 4.11.2 IN APPROPRIATE POSITIONS AND TECHNIQUES USED. (ALL POSITIONS AND STEELS UP TO CLASS 3 MIN.)
 - WELDING CONSUMABLES TO COMPLY WITH SECTION 4.5 FOR THE TYPE AND GRADE OF MATERIALS USED.
 - INSPECTION TO BE CARRIED OUT AS PER SECTION 7.
2. CHASSIS MATERIAL TO BE IDENTIFIED BEFORE REPAIR
ADDITIONAL MATERIAL TO BE EQUIVALENT
3. REMOVE ALL BURRS AND SHARP EDGES, DRESS WELD TERMINATIONS
4. ENSURE WELDING COMPATIBILITY OF MATERIAL.
THIS REPAIR IS ONLY SUITABLE FOR CHASSIS MATERIAL UP TO 350 MPa YIELD. CONSULT AN ENGINEER WITH THE CHASSIS CATEGORY IF HIGHER YIELD MATERIAL IS USED
5. STEEL PLATE TO MEET AS/NZS 3678 &/OR 3679 OR EQUIVELANT (UNLESS SPECIFIED)

WELD SYMBOLS TO AS/NZS 1554.1

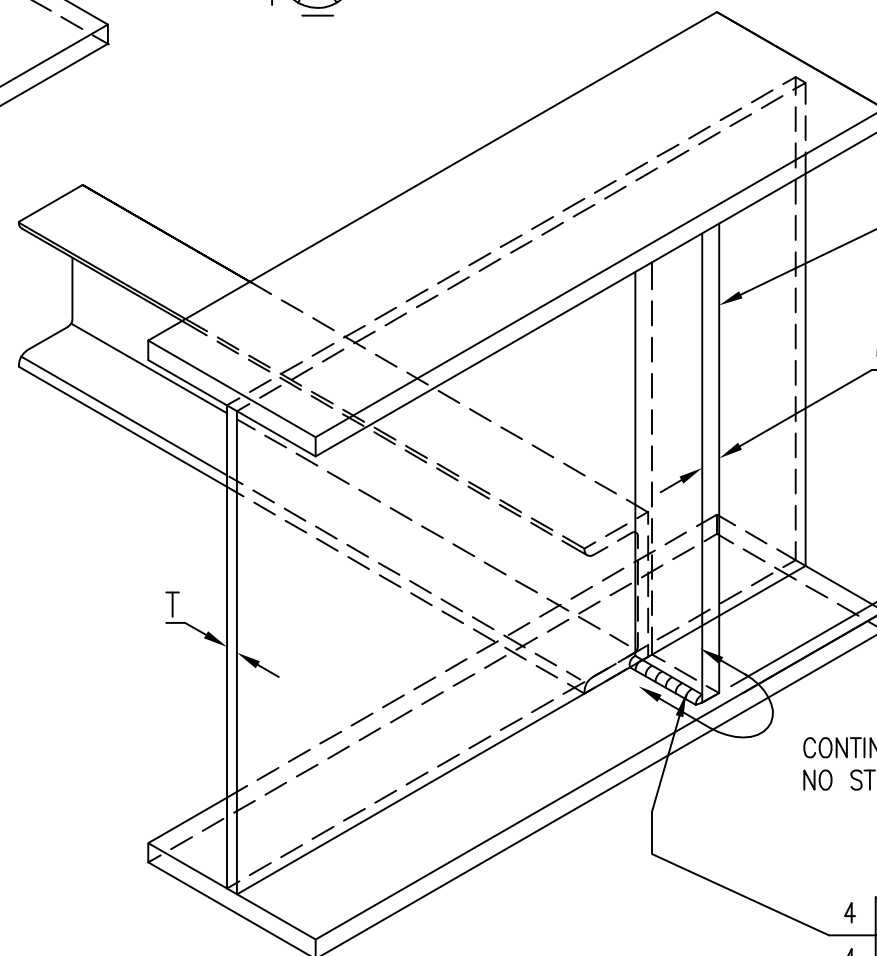
SYMBOL	JOINT	TABLE
	B-C2a	E1
	B-C3	E1
	F1	E3



WEB CRACKS
GRIND OUT, DRILL $\phi 3\text{mm}$ HOLE
AT END OF CRACK AND RE-WELD



WEB CRACK DETAIL

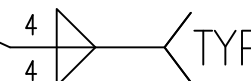


ADD STIFFENERS TO OUTSIDE OF WEB

6

>15mm

CONTINUOUS WELD
NO STOP STARTS



REINFORCEMENT DETAIL

C			
B	09/07/19	UPDATE FOR ISSUE IN NZTA VIRM	
A		FIRST ISSUE TO CLIENT	
ISSUE	DATE	CHANGES MADE	BY

WORKSHOP	
OWNER	
MAKE	MODEL
CERTIFIER	CERT. No.
JOB #	