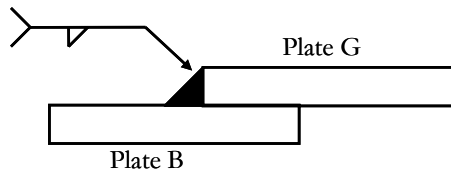
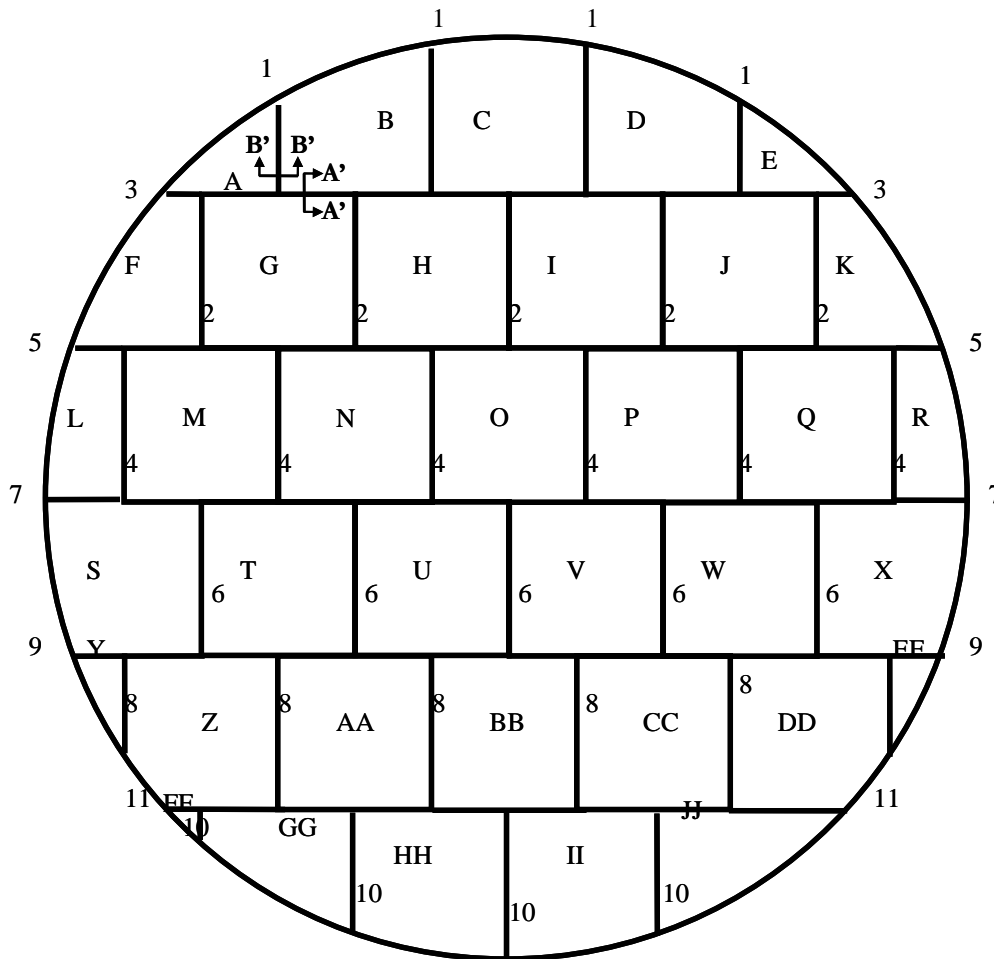
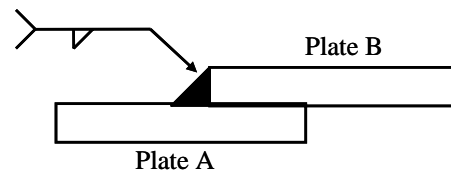


RECOMMENDED SEQUENCE FOR WELDING SEAMS JOINING BOTTOM PLATES



Section A'-A'



Section B'-B'

Instructions: Place bottom plates in alphabetical order and weld bottom plate in numerical order. When aligning and tack welding No. 2 seams, care should be taken to assure that Seam No. 3 is aligned the entire length. This procedure is repeated across the tank bottom with Seams No. 4 and 5, 6 and 7, 8 and 9, and 10 and 11. The minimum distance the top plate must lap over the bottom plate is 4 times the thickness of the thinner plate. Weld the entire bottom of the tank prior to welding the tank shell plates to the tank bottom.