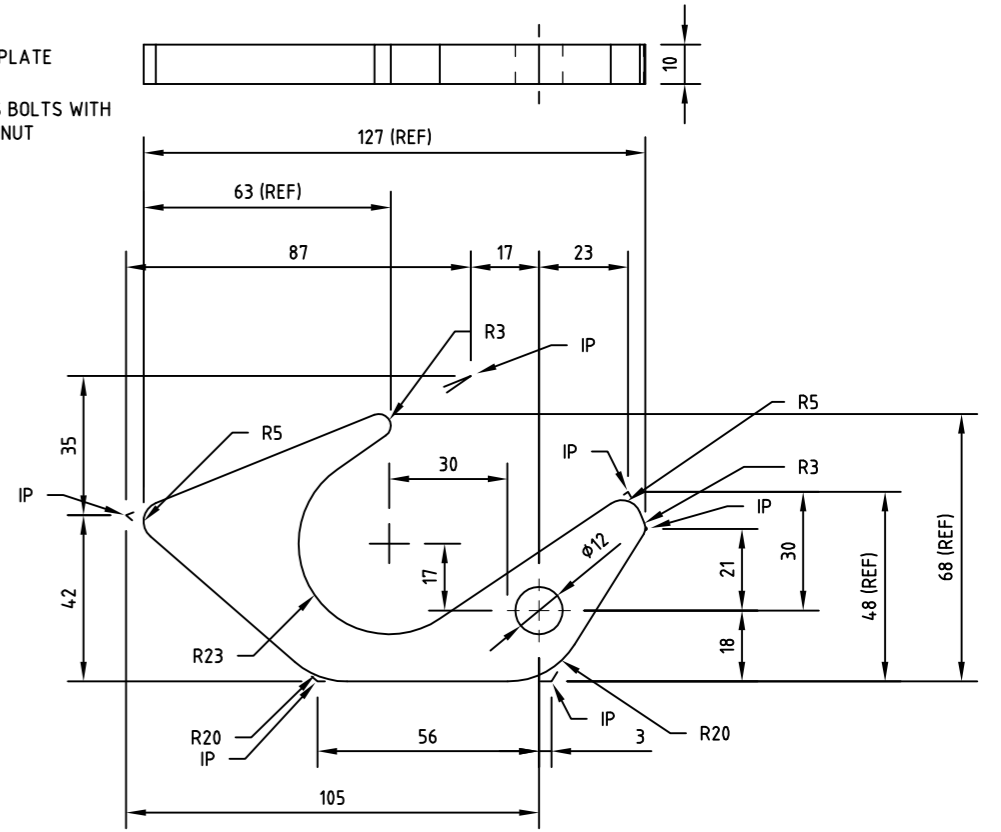
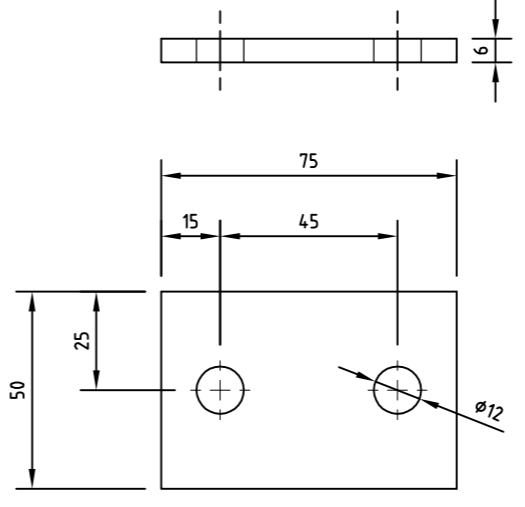
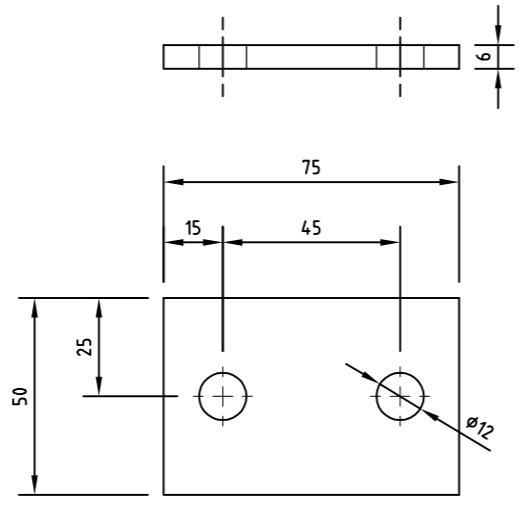
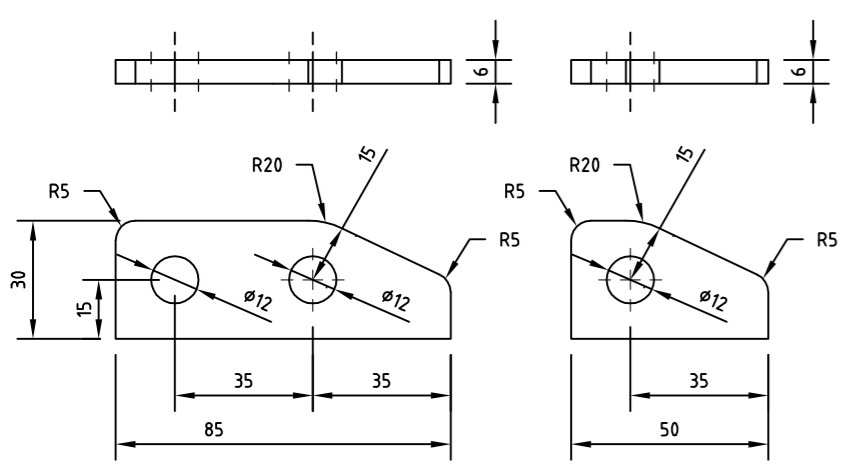
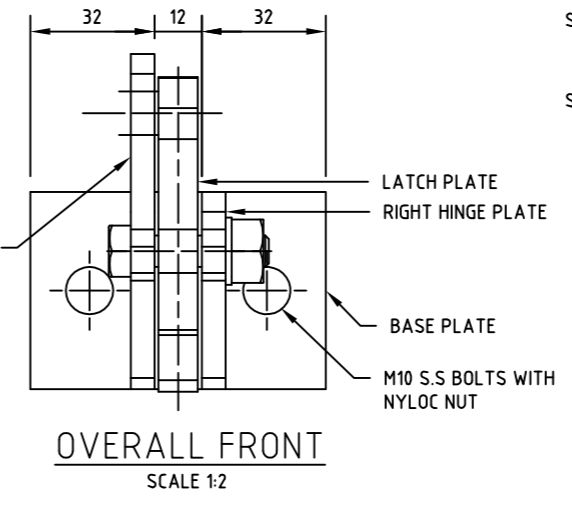
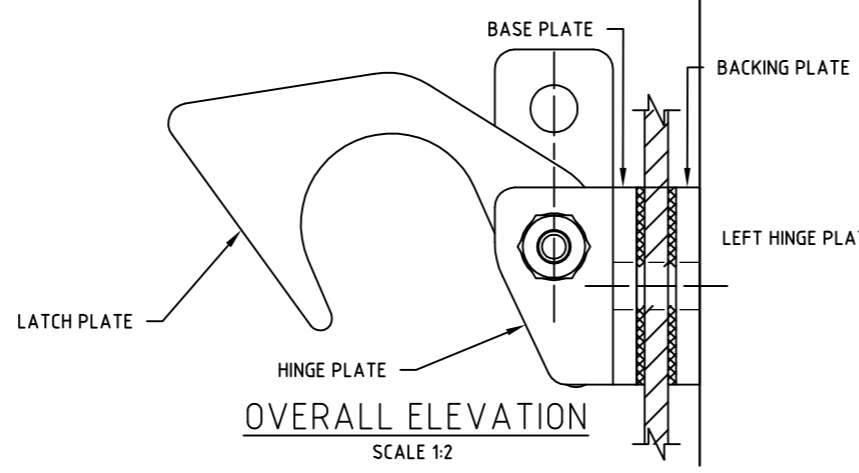
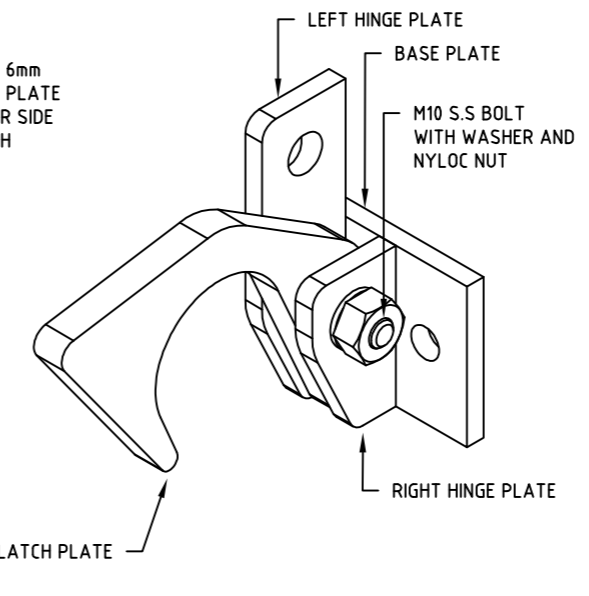
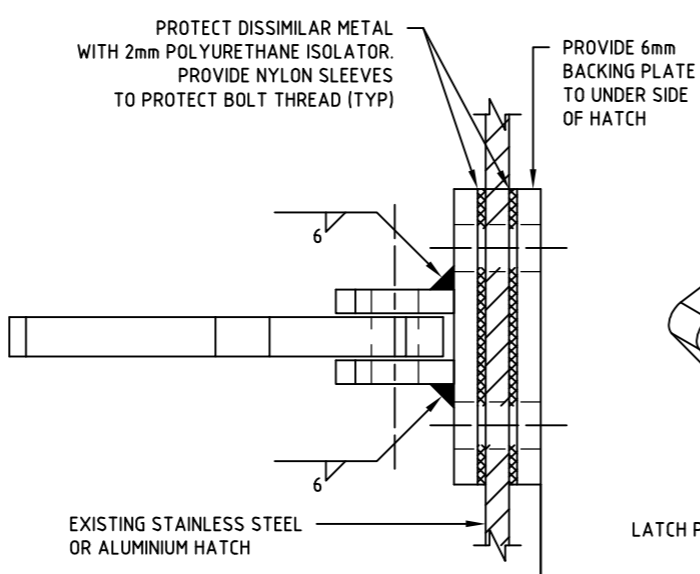
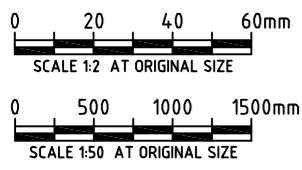


OPERATIONAL WIND SPEED 120km/h OR 65 KNOTS WITH ONE HATCH LID OPEN (MAXIMUM 800x900mm SIZE)



- GENERAL**
- G1. READ THESE NOTES IN CONJUNCTION WITH OTHER ENGINEERING DRAWINGS AND SPECIFICATIONS AND WITH SUCH OTHER WRITTEN INSTRUCTIONS ISSUED.
 - G2. NOMINATION OF PROPRIETARY ITEMS DOES NOT INDICATE EXCLUSIVE PREFERENCE, BUT INDICATES REQUIRED INSTALL PROPRIETARY ITEMS IN ACCORDANCE WITH MANUFACTURE'S REQUIREMENTS AND RECOMMENDATIONS.
 - G3. DO NOT OBTAIN DIMENSIONS BY SCALING FROM DRAWINGS.
 - G4. DIMENSIONS ARE IN MILLIMETRES, LEVELS ARE IN METRES UNO, CHAINAGES ARE IN METRES UNO.
 - G5. WORKMANSHIP AND MATERIALS TO COMPLY WITH REQUIREMENTS OF RELEVANT BUILDING AUTHORITIES. ALL STANDARDS REFERRED TO ARE THOSE CURRENT (AS AMENDED) AT COMMENCEMENT OF CONTRACT.

- STAINLESS STEEL**
- S1. WORKMANSHIP AND MATERIALS TO COMPLY WITH AS4673 FOR STAINLESS STEEL.
 - S2. DEVELOP WELD PROCEDURES TO SUIT JOINT DETAILS AND SHOW ON SHOP DRAWINGS. USE PREQUALIFIED WELD PROCEDURES AND CONSUMABLES TO AS/NZS1554.1 CLAUSE 4.3 OR DEVELOP QUALIFICATION OF WELD PROCEDURE AND CONSUMABLES BY TESTING TO AS/NZS1554.1 CLAUSE 4.2. LIST APPLICABLE PARAMETERS ON WELDING PROCEDURE QUALIFICATION RECORD AND MAKE RECORD AVAILABLE FOR INSPECTION.
 - S3. WELDING TO BE UNDERTAKEN BY SUITABLY QUALIFIED EXPERIENCED WELDER UNDER SUPERVISION OF QUALIFIED WELDING SUPERVISOR.
 - S4. CARRY OUT WELDING TO AS/NZS1554: ALL INTERFACES BETWEEN STEEL SECTIONS TO BE CONNECTED WITH 6mm CONTINUOUS FILLET WELDS ALL ROUND, BOTH SIDES UNO.
 - WELDS TO BE SHOP WELDED UNO.
 - WELDS TO BE CATEGORY GP..
 - S5. EXTENT OF WELD INSPECTION/TESTING TO BE:
 - VISUAL SCANNING: 100%
 - S6. REPAIR FAULTY WELDS REVEALED BY WELD INSPECTION/TESTING AND REPEAT THE EXAMINATION.
 - S7. WELDING SYMBOLS ARE TO AS1101.3. "CFW" INDICATES CONTINUOUS FILLET WELD. "
 - S8. PROVIDE STAINLESS STEEL GRADE 316L UNO.
 - S9. BOLTS AND NUTS TO BE STAINLESS STEEL GRADE 316L A4 CLASS 50 TO ISO 3506. WASHERS TO BE STAINLESS STEEL TO ISO 7089 OR ISO 7090.
 - S10. WELDS TO BE CLASS 1A FOR STAINLESS STEEL, WELD SURFACE FINISH GRADE I OR II. ELECTRODES TO BE E316LXX UNO, PRE-APPROVED TO AS/NZS1554.
 - S11. DO NOT FLAME CUT STAINLESS STEEL. KEEP STAINLESS STEEL SURFACES CLEAN AND FREE OF BLEMISHES THROUGHOUT FABRICATION.
 - S12. FABRICATE STAINLESS STEEL IN WORKSHOP AREAS SEGREGATED FROM CARBON STEEL FABRICATION AREAS. USE TOOLS DEDICATED TO STAINLESS STEEL FABRICATION. WIRE BRUSHES AND WIRE WOOL USED IN FABRICATION OF STAINLESS STEEL TO BE STAINLESS STEEL OR CLEAN INERT MATERIALS.
 - S13. PREVENT CONTACT BETWEEN STAINLESS STEEL AND CARBON STEEL, IRON, CHEMICALS, OILS AND/OR GREASE.

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APPROVED		APPROVED	
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STANDARD CONSTRUCTION PRACTICE
SEWERAGE STANDARD

WWPS
FALL PREVENTION HANDRAIL
HINGED COVERS LATCH DETAIL

CAD FILE NAME: SCP-823

SCP-823

ISSUED: 2016

A3