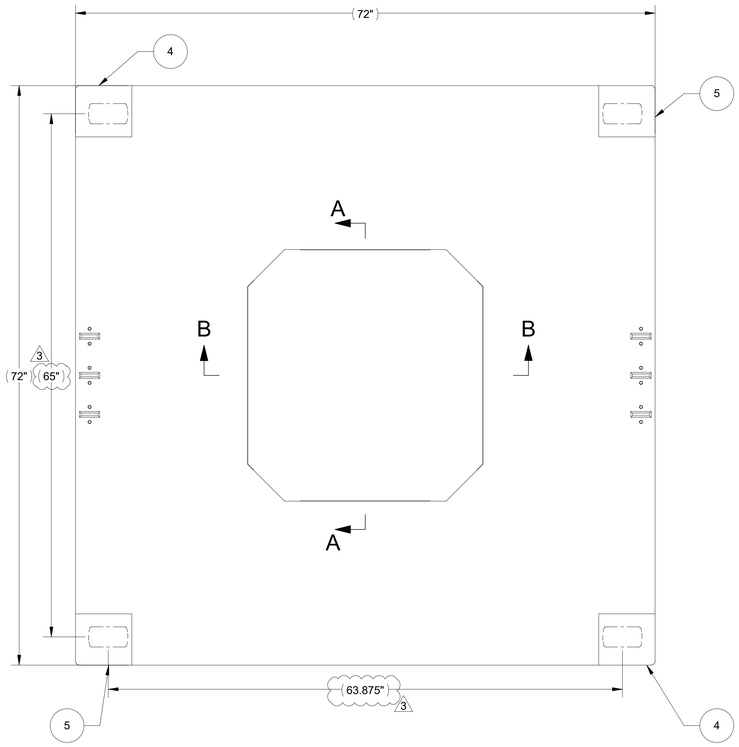
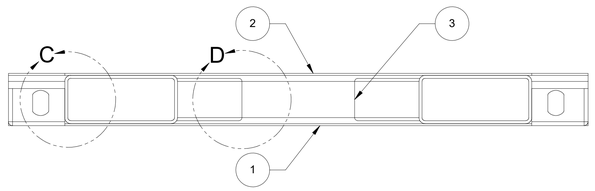
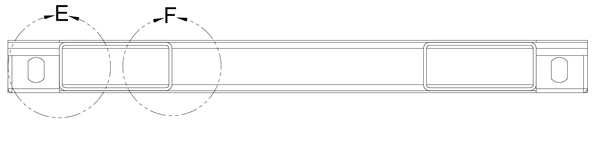
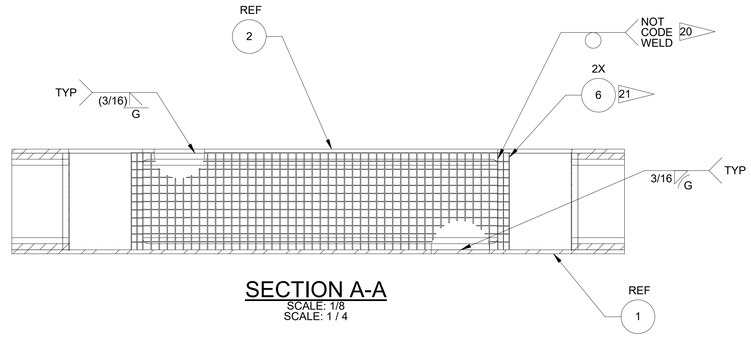


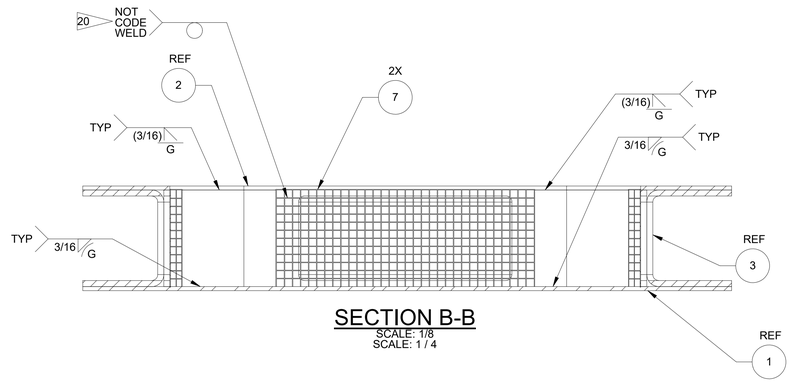




OVERALL WELDMENT
SCALE: 1/8



SECTION A-A
SCALE: 1/8
SCALE: 1 / 4



SECTION B-B
SCALE: 1/8
SCALE: 1 / 4

PARTS/MATERIAL LIST					
QL	QTY	PART/DRAWING NUMBER	NOMENCLATURE/DESCRIPTION	MATERIAL/REFERENCE	SH	ITEM
QL-3	1	H-14-111728	BOTTOM PLATE, 1/4 THK	ASTM A36	1	1
QL-3	1	H-14-111729	TOP PLATE, 1/4 THK	ASTM A36	1	2
QL3	1	H-14-111730	MIDDLE WELDMENT	N/A	1	3
QL3	2	243000C-BL	CORNER, BOTTOM LEFT	TANDEMLOC	1	4
QL3	2	243000C-BR	CORNER, BOTTOM RIGHT	TANDEMLOC	1	5
CM	2	N/A	2 MESH .047" 304SS WELDED 6 x 24	DWT	1	6
CM	2	N/A	2 MESH .047" 304SS WELDED 6 x 16	DWT	1	7

GENERAL NOTES:

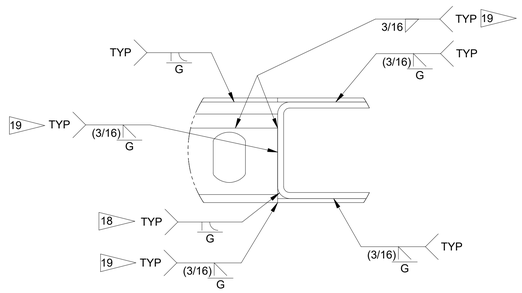
1. ALL DIMENSIONS, TOLERANCES, LIMITS OF SIZE, FORM, LOCATION, AND RELATED TERMINOLOGY AND SYMBOLS SHALL BE INTERPRETED IN ACCORDANCE WITH ASME Y14.5.
2. FOR FABRICATION AND MANUFACTURING SEE DATA SHEET DS-ILAW-EG-0001.
3. REMOVE ALL BURRS, WELD SPLATTER AND SHARP EDGES.
4. ASSEMBLY/WELDMENT WEIGHT: 1,690 LBS
5. SURFACE TEXTURE SYMBOLS AND RELATED TERMINOLOGY SHALL BE INTERPRETED IN ACCORDANCE WITH ANSI Y14.36M AND ANSI B46.1.
6. WELD JOINT SYMBOLS AND DEFINITIONS SHALL BE INTERPRETED IN ACCORDANCE WITH AWS A2.4 AND AWS A3.0.
7. EQUIVALENT COMPONENTS AND/OR SOURCES OF SUPPLY MAY BE SUBSTITUTED UPON THE APPROVAL OF BUYER.
8. WELD AND VISUALLY INSPECT PER AWS D1.1 STATICALLY LOADED CRITERIA.
9. ASSEMBLY IS INTENDED TO BE MOVED AND LIFTED VIA FORK POCKETS.
10. WELD PREPARATIONS SHALL BE CAREFULLY EXAMINED PRIOR TO WELDING AND THE CORRECT GAP AND ALIGNMENT MAINTAINED DURING THE WELDING PROCESS.
11. ALL WELDS TO BE CONTINUOUS UNLESS OTHERWISE STATED.
12. ALL WELDS TO BE GROUND FLAT OR CONTOURED AND POLISHED TO MATCH ADJACENT MATERIAL.
13. POLISHING TO BE LIMITED TO 1 INCH EITHER SIDE OF THE WELD.
14. FILLET WELD LEGS AND THROAT SHALL BE LARGE ENOUGH TO GRIND AND ACHIEVE THE REQUIRED RADIUS AND THROAT THICKNESS AS SPECIFIED.
15. FOR PAINT APPLICATION NOTES, SEE H-9-6036.
16. APPLY ANTI-GALLING COMPOUND TO FASTENERS PRIOR TO INSTALLATION.
17. FILL GAPS WITH DEVCON OR XTRABOND HT HIGH TEMP RTV SILICONE PRIOR TO PAINTING TO ALLOW FOR DECONTAMINATION AND MINIMIZE WELD FINISH REQUIREMENTS.

18 > WELD ITEM 1 TO ITEM 3 PRIOR TO WELDING ITEMS 4 AND 5.

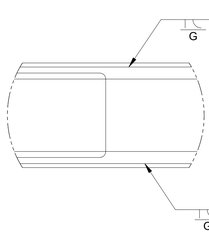
19 > CRITICAL WELD.

20 > SPOT WELD SCREEN IN ALL CORNERS AND TWO PLACES TOP AND BOTTOM EVENLY SPACED TO SECURE TO REST OF PALLET IN ACCORDANCE WITH AWS D1.6.

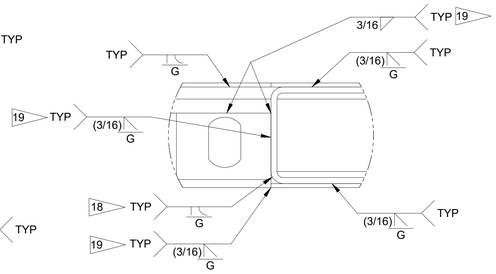
21 > BEND SCREEN TO MATCH INTERFACING COMPONENT ANGLES PRIOR TO WELDING



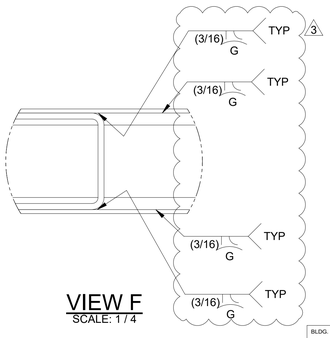
VIEW C
SCALE: 1 / 4



VIEW D
SCALE: 1 / 4



VIEW E
SCALE: 1 / 4



VIEW F
SCALE: 1 / 4

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES. REMOVE BURRS & SHARP EDGES. THIRD ANGLE PROJECTION TOLERANCES .X = ± .1 .XX = ± .01 .XXX = ± .005 X/XX = ± 1/16 ANGLE = ± .5 DEG MACHINED SURFACES 125 MACHINED INSIDE RADII = .04 ±.02

REVISION APPROVAL RECORD					
DISCIPLINE	BY	DATE	DISCIPLINE	BY	DATE
ARCH.	N/A	N/A	MECHANICAL	N/A	N/A
BUILDING SERVICES	N/A	N/A	PIPING	N/A	N/A
CIVIL	N/A	N/A	PROCESS	N/A	N/A
ELECTRICAL	N/A	N/A	QA / QC	N/A	N/A
ENVIRON.	N/A	N/A	STRUCTURAL	N/A	N/A
GEN. ARRANG.	N/A	N/A			
I & C	N/A	N/A			
HVAC	N/A	N/A			

DRAWING STATUS				
ISSUED	REV	DATE	SDE	PEM
N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A	N/A

NOT APPROVED FOR CONSTRUCTION UNLESS SIGNED AND DATED. DESTROY ALL PRINTS BEARING EARLIER DATE AND/OR REV.NO.

DRAWING TRACEABILITY LIST	
DWG NUMBER	TITLE

REFERENCES	
REF NUMBER	TITLE
NEXT USED ON H-9-6036	

REVISIONS							
REV NO.	DESCRIPTION	ORG	CHK	APVD	IDV	DATE	
3	REVISED PER ECN-ILAW-ME-0023						
2	REVISED PER ECN-ILAW-ME-0021						
1	REVISED PER ECN-ILAW-ME-0015						

BLDG. NO. N/A

INDEX NO. N/A

CAUTION
NOT COMPLETE WITHOUT CURRENT CHANGE DOCUMENTS FROM DATABASE

ATTENTION
DESTROY THIS DOCUMENT BY SHREDDING MAY CONTAIN SENSITIVE INFORMATION

DATE
COMPANY
ENGINEER

U.S. DEPARTMENT OF ENERGY
Office of River Protection

ILAW TRANSPORTER PALLET WELDMENT

SIZE	DRAWING NUMBER	SHEET	REV
F	H-14-111727	1	3

SCALE SHOWN

PLOTID

DOE_TB_F.DWG (NOV 2015)