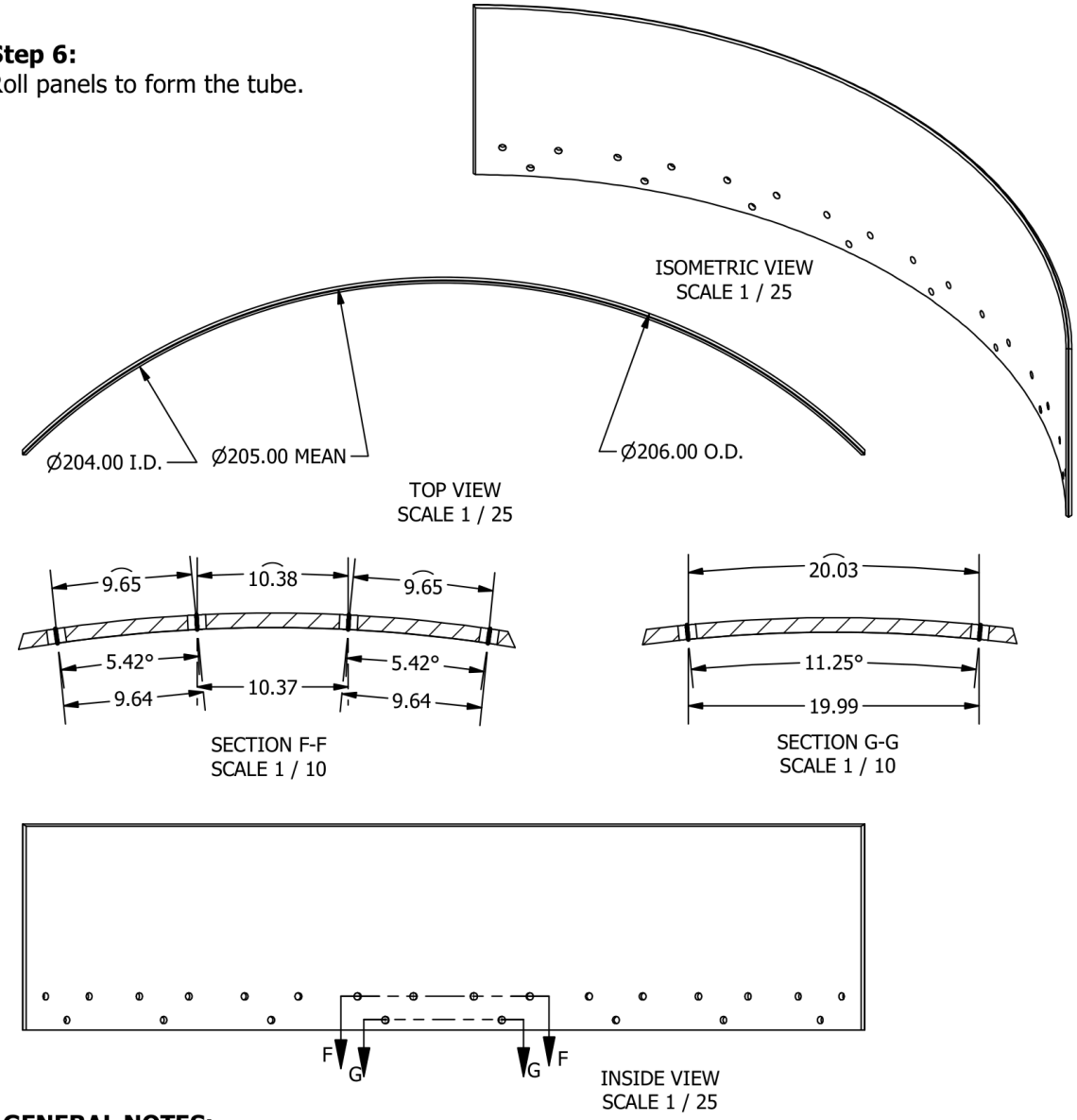
Rolled Steel Shell

Rolled plate segments, drilling and welded shell assembly.

Step 6:
Roll panels to form the tube.



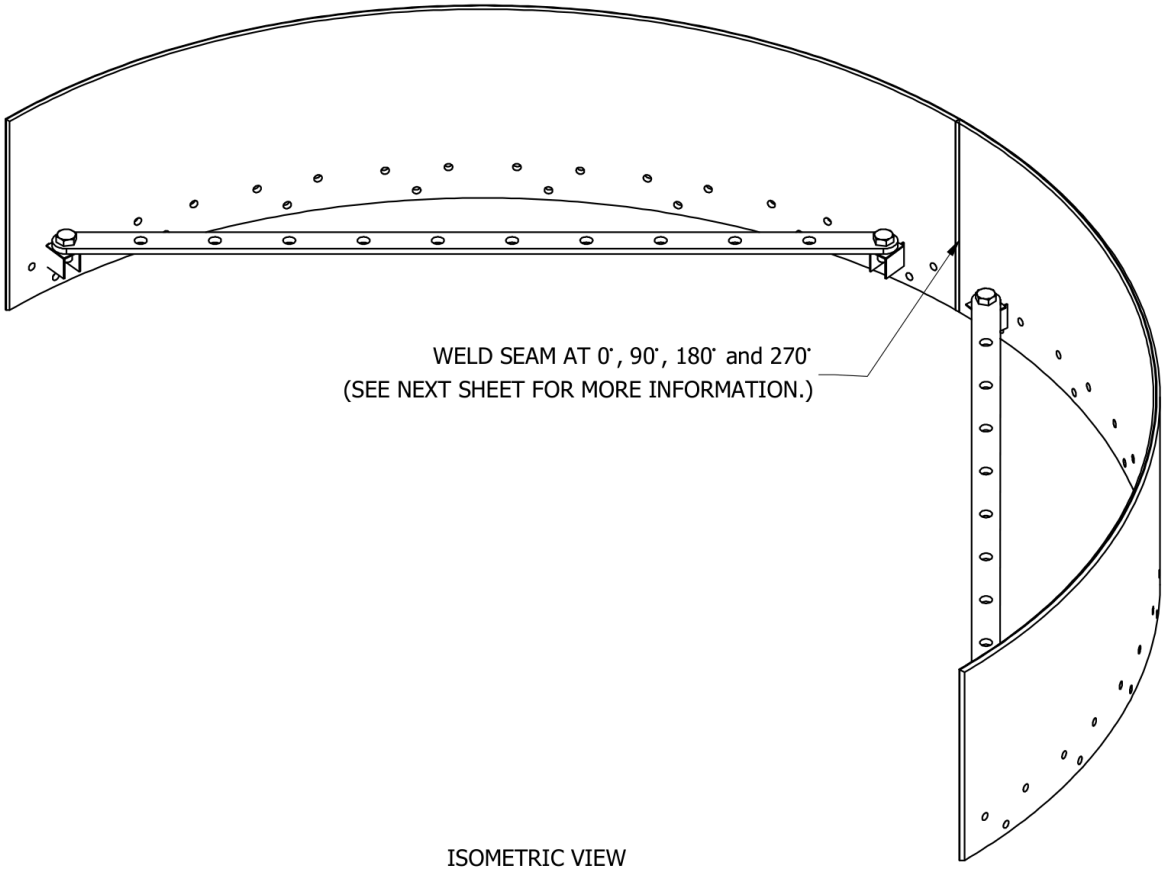
GENERAL NOTES:

1. Dimensions in inches (metric for reference only).
2. Tolerances per ASCE Y14.5-2018.
3. Hole spacing located by basic angular values.
4. Segment shown is 1 of 4; weld per assembly sheet.

Rolled Steel Shell

Rolled plate segments, drilling and welded shell assembly.

Step 7:
Prepared and clamping rolled plates for welding to form the tube.



ISOMETRIC VIEW
SCALE 1 /25

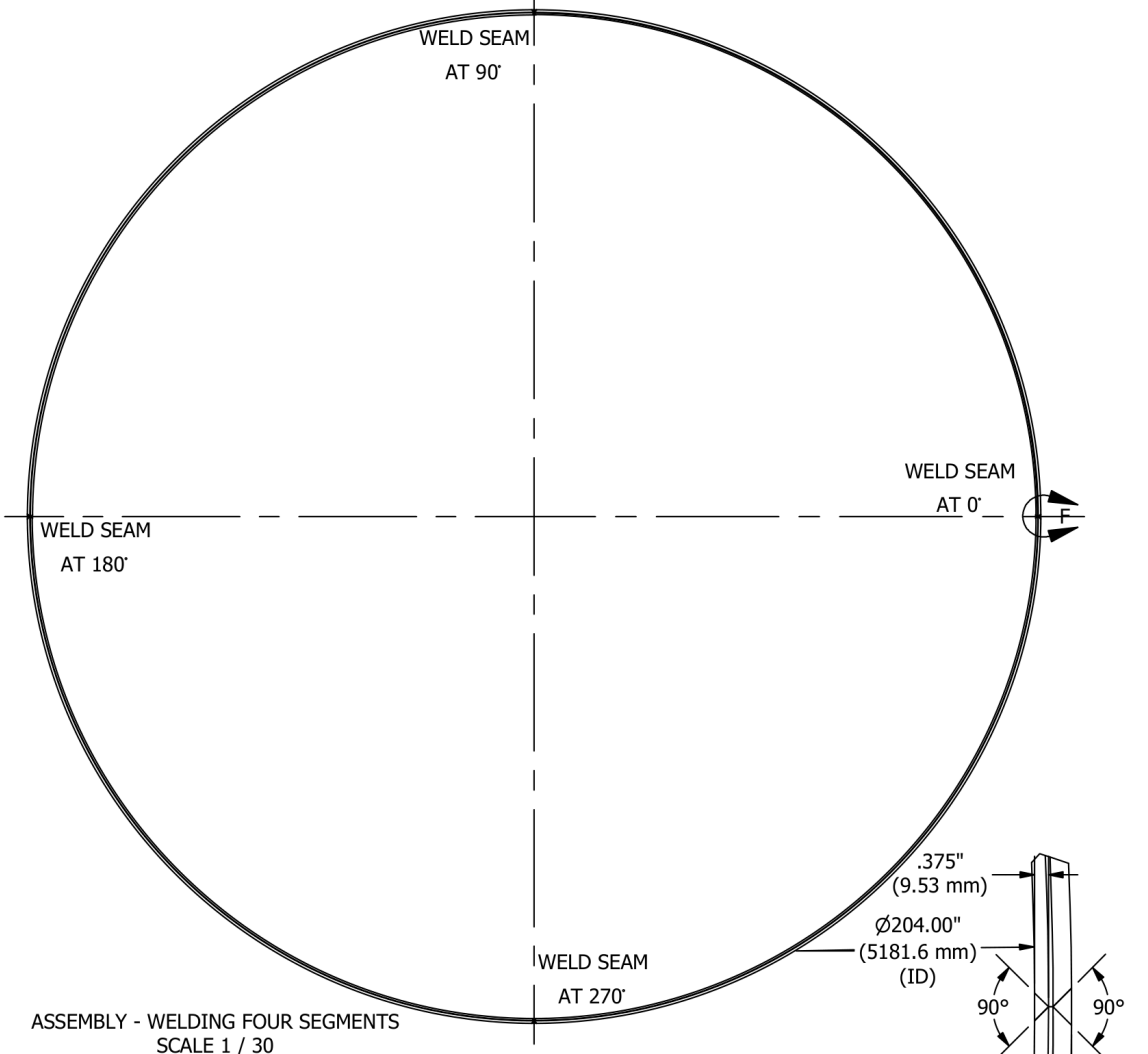
GENERAL NOTES:

1. Dimensions in inches (metric for reference only).
2. Tolerances per ASCE Y14.5-2018.
3. The isometric view is for reference only. The shop must add the necessary clamps to the rolled plate and secure it to the welding table in order to achieve quality welds that maintain the required Ø205 mean diameter of the tube.

Rolled Steel Shell

Rolled plate segments, drilling and welded shell assembly.

KILN SHELL ASSEMBLY			
ITEM	QTY	PART NUMBER	DESCRIPTION
KILN SHELL SEGMENT	4	DIA. 204 in I.D.	4 WELDED SEGMENTS



ASSEMBLY - WELDING FOUR SEGMENTS
SCALE 1 / 30

NOTES:

1. Weld sequence A, then B, then C and final D.
2. Weld per AWS D1.1 requirements.
3. Grind inside flush after welding.
4. Final diameter Ø204" (5181.6 mm) ± 0.0625" (± 1.59 mm)