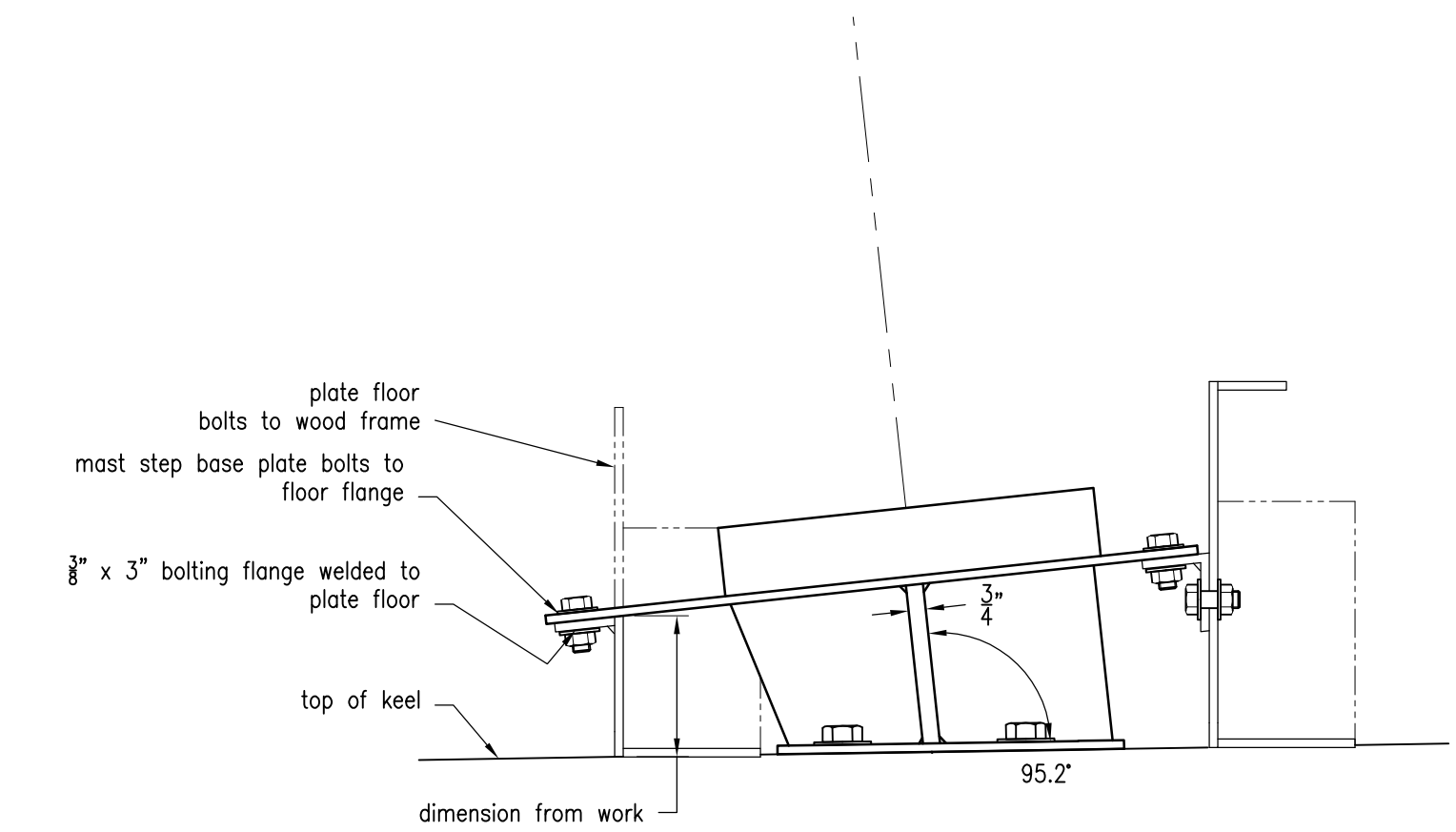
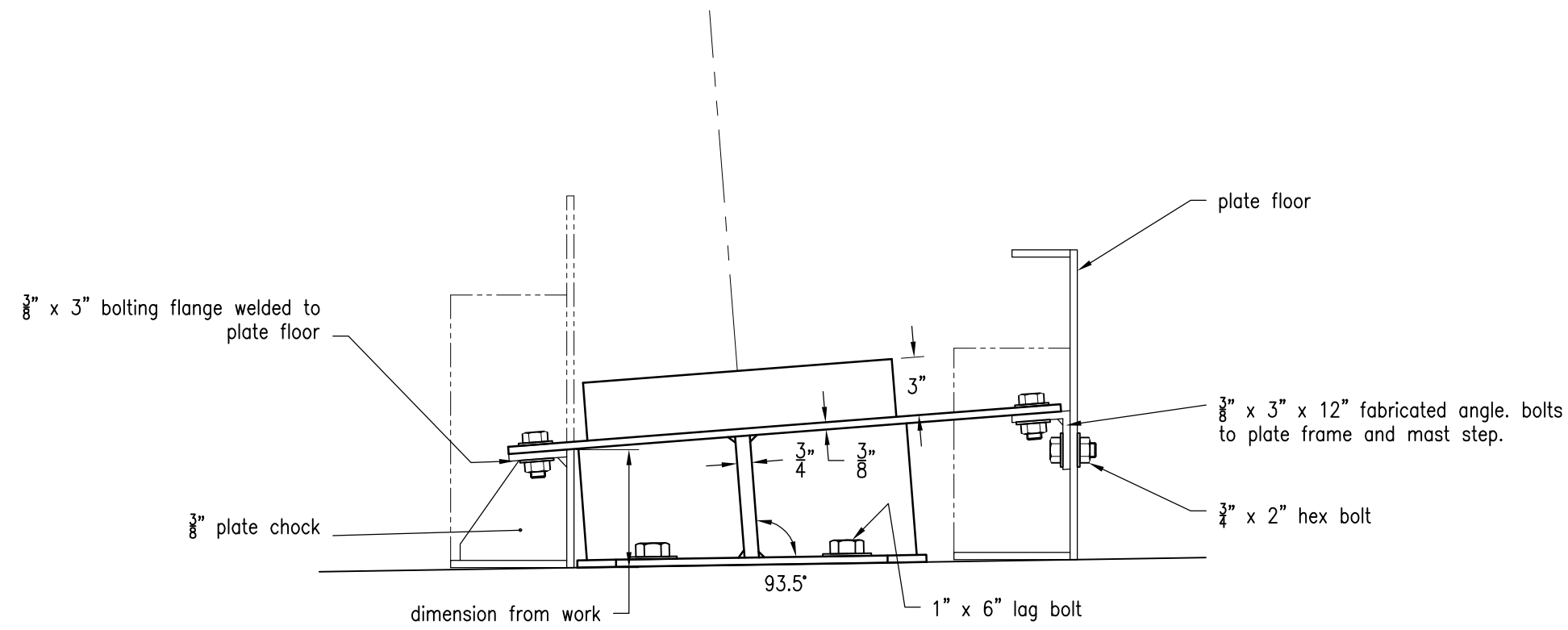


C:\jobs\MT Brigantine\dwgs\numbered\20 Structure\512400 Mast steps.dwg, 512400 Mast steps.dwg, 7/25/2012 10:14:22 AM



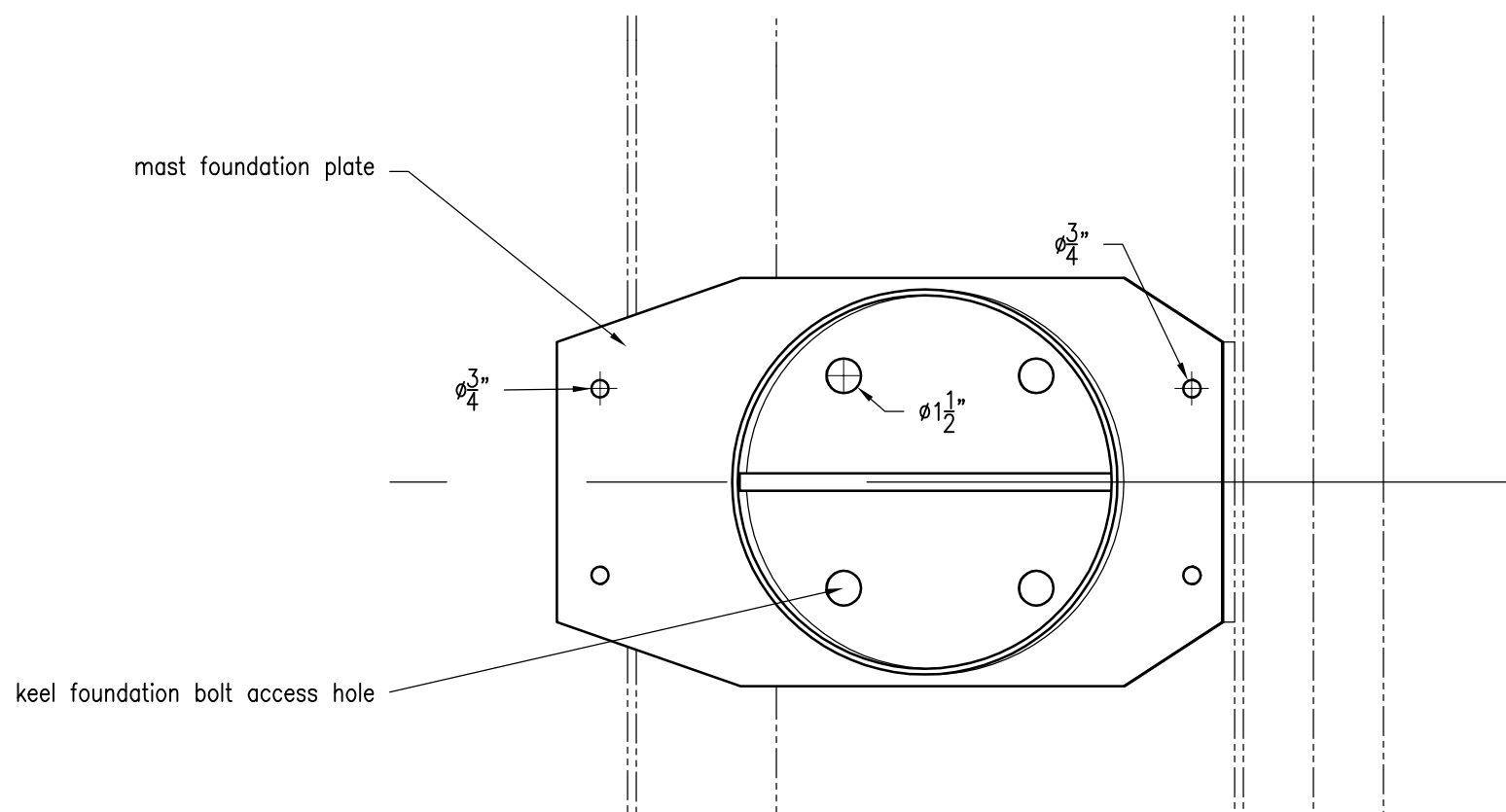
Main mast step side elevation



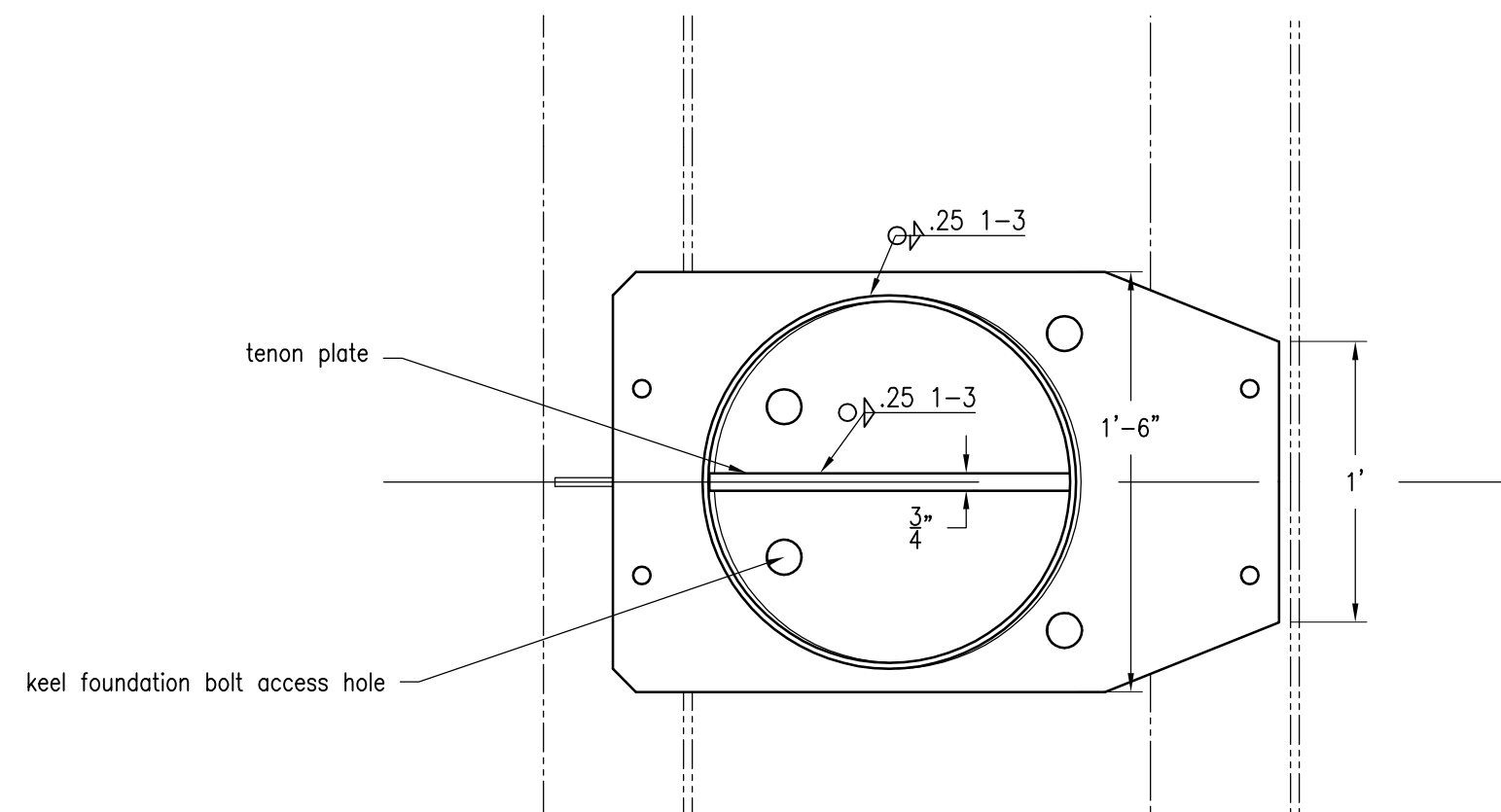
Fore mast step side elevation

26 25

12 11

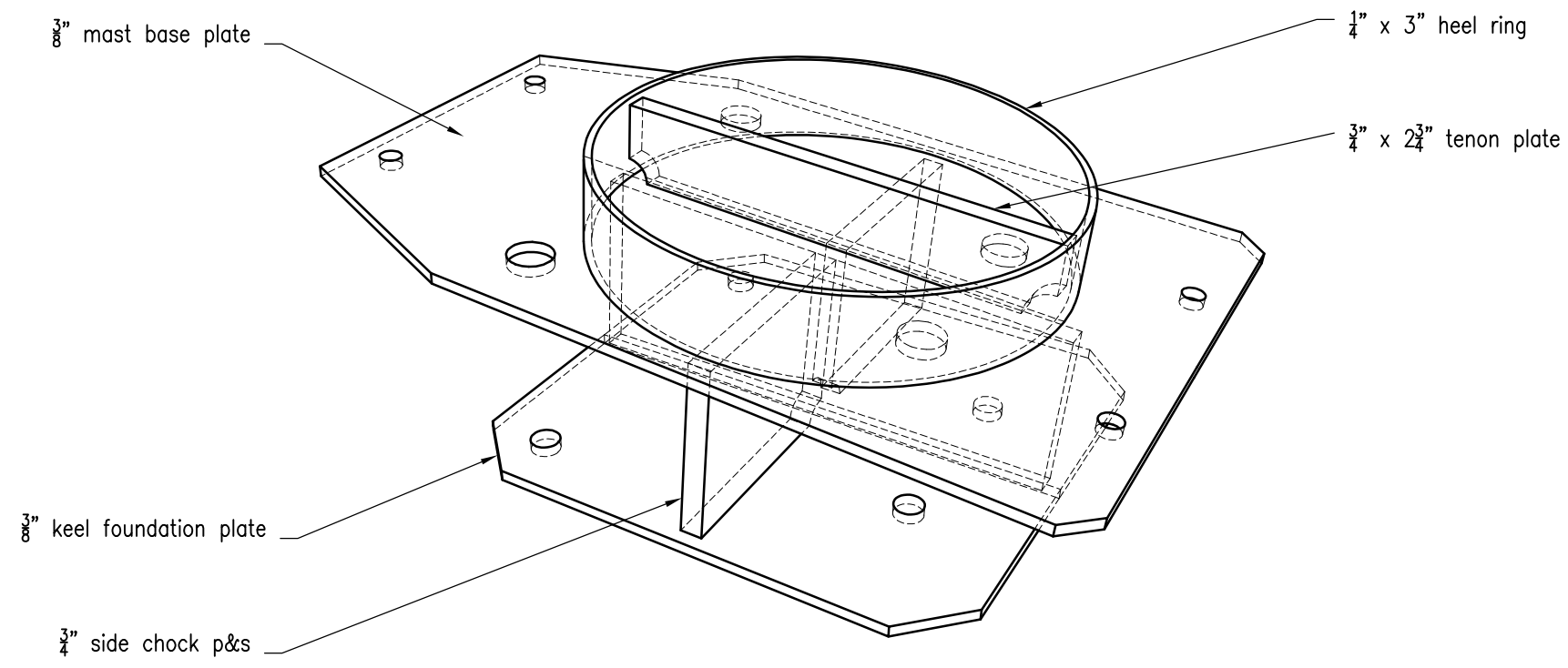


Main mast step plan view

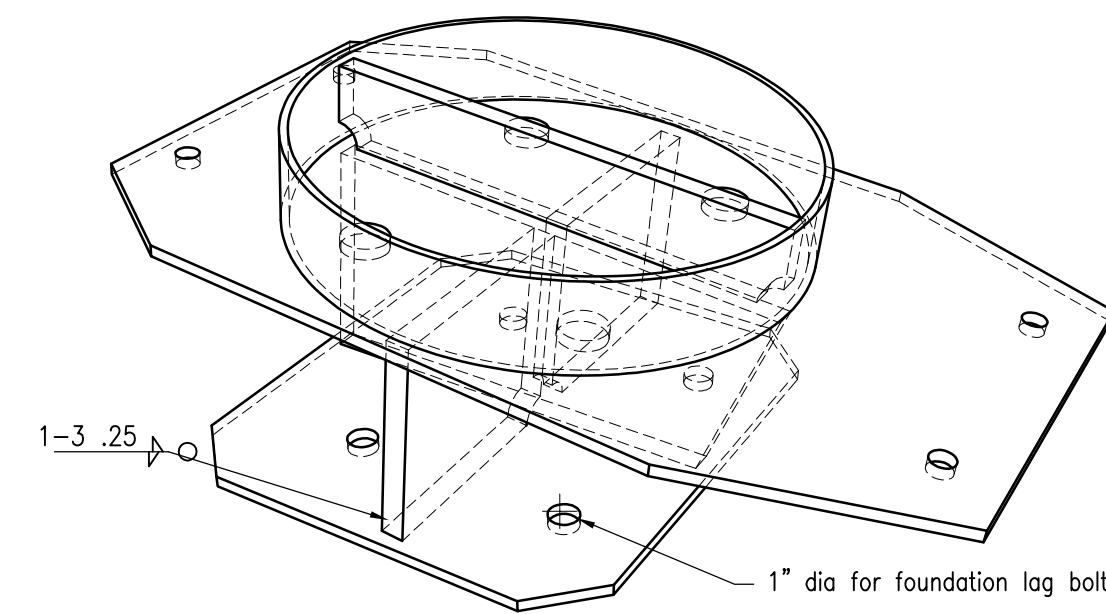


Fore mast step plan view

scale: 1-1/2" = 1'

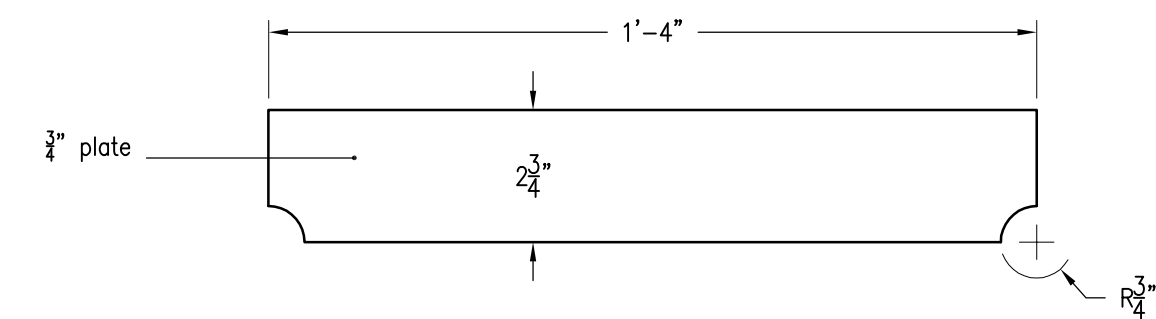


Fore mast step port perspective



Main mast step port perspective

Not to a scale



Tenon plate side elevation

scale: 3" = 1'

#### Notes:

- 1) All plate to be CA655 ASTM B96 bronze unless otherwise indicated.
- 2) Fabrications are based on good welding practice with gas-shielded arc welding techniques. It is assumed that all equipment is in full working order, that working conditions are carefully controlled and that approved standard practices are followed at all times.
- 3) Material is not to be placed under excessive restraint during the weld cycle. A root gap of 1.5 mm is recommended to ensure satisfactory weld metal penetration.
- 4)The area within and around the weld must be scrupulously clean and free from grease, dirt and visible oxide.
- 5) Inter-run temperatures should be kept below 200C, if necessary by allowing the work to cool between further runs. The use of the scratch brush to remove oxide between runs is recommended to reduce the risk of weld porosity.
- 6) PWHT: May not be required.
- 7) Bolted connections to be silicon bronze, hex head, UC threads unless otherwise indicated.



TRI-COASTAL MARINE

SCALE: as shown	DRAWN BY: ad
DATE: July 20, 2012	CHECKED BY:
TITLE:	

**M.Turner Brigantine**  
**Mast steps**

PLAN: 512400	REV:
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