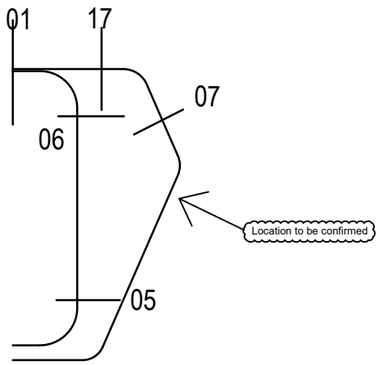
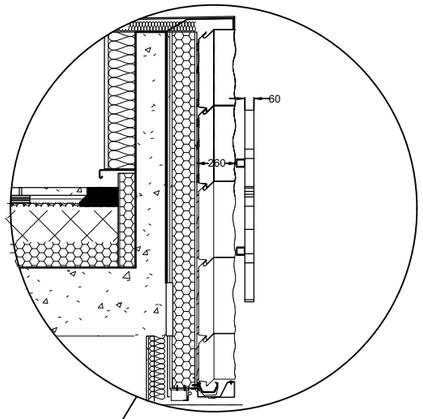
SO5722 - Greenwall sign - Greenheys - Manchester Science Park

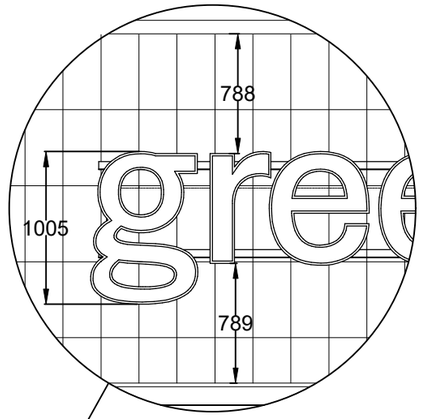


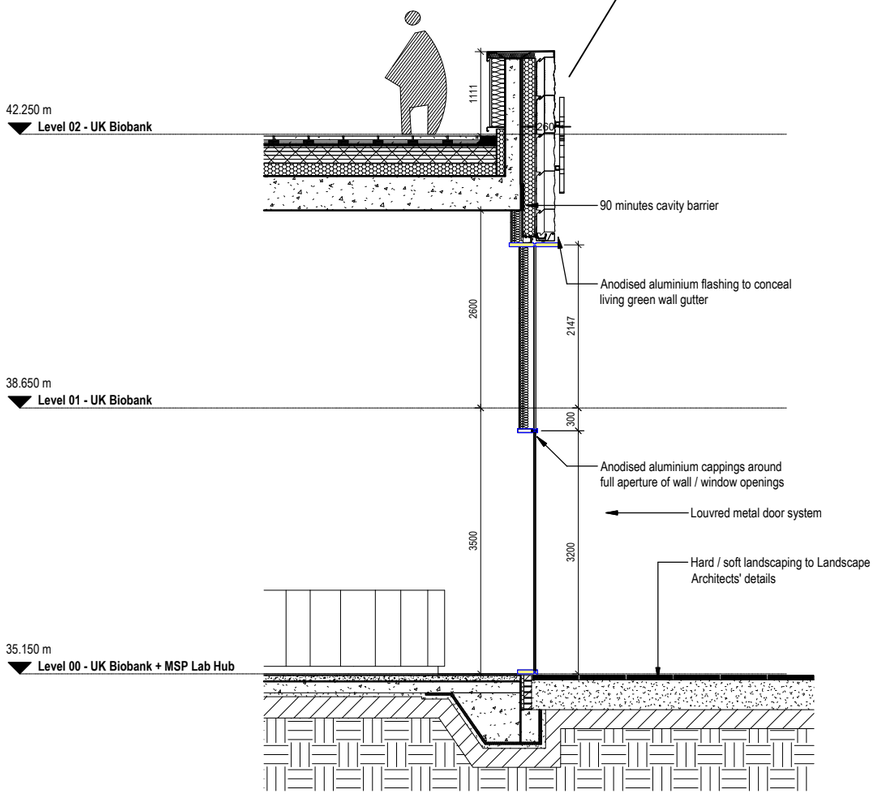


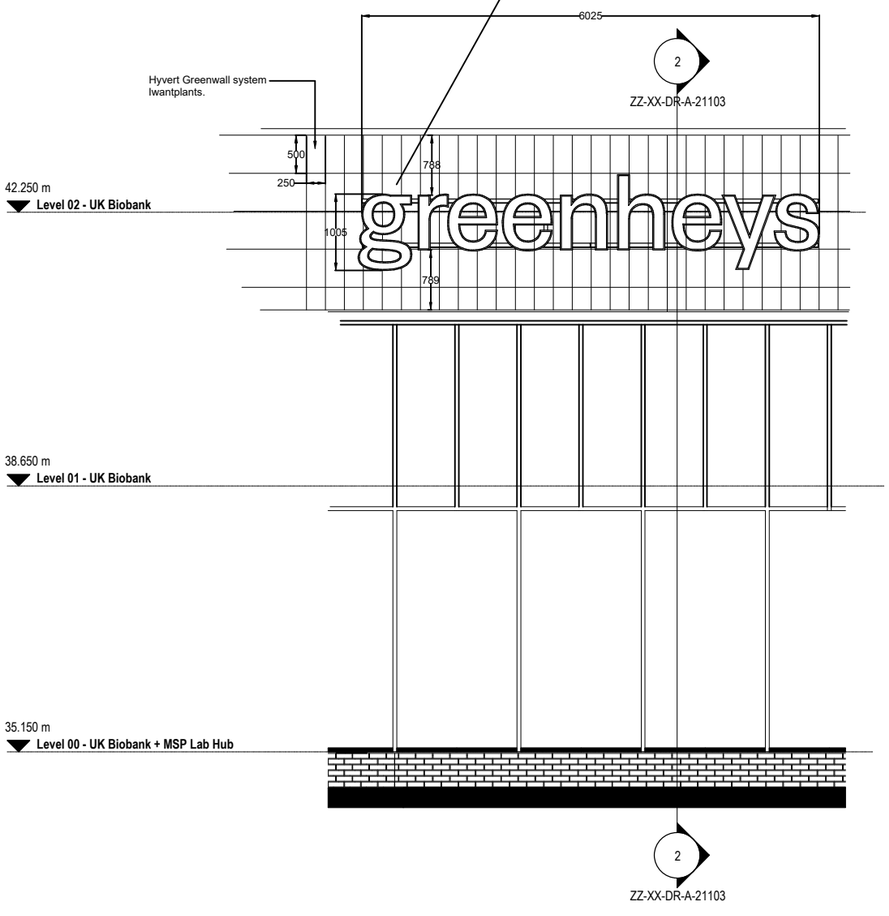
Sign will weigh circa 100kg excluding any projecting framework/brackets back to the SFS system.

Built up rim and return letters (not rimless due to letter size and mounting height).
Internally face illuminated with LED modules and acrylic opal faces.
Letter rims and sides including the backs painted to RAL 9011 matt black.

Horizontal 'U' channel rails behind the letters painted to a RAL Green TBC.







JOB CARD-F006

WELD SET No.		
WELDING WIRE LOT/BATCH		
WELDING GAS LOT/BATCH		
ISSUE TO FAB	INITIALS:	
CUT BY	INITIALS:	
BENT BY	INITIALS:	
DIMENSIONAL CHECKS	INITIALS:	
FABRICATED BY	INITIALS:	
WELDED BY	INITIALS:	
WELD INSPECTION DURING MULTIRUN	INITIALS:	
COMPLETION OF MANUFACTURE	DATE:	
CHECKED BY RWC YES NO	DATE:	
REWORK YES NO	DATE: / NCR No.	

ANY REWORK MUST RELATE TO NCR AND FOLLOW NDT PROCEDURE WELD DEFECT TO BE COMPLETELY REMOVED AND REWELDED TO THE ORIGINAL PROCEDURE.

GAS FLOW CHECK		
VISUAL INSPECTION	100%	PASS / FAIL
MPI	%	
DPI	%	
PRE GALV CHECK		
POST GALV CHECK		

ON COMPLETION THIS DRAWING MUST BE SIGNED AND GIVEN TO THE QA/RWC
SIGNATURE AND DATE:

WELDING PLAN-F014

-ALL WELDS 6mm LEG LENGTH FILLET UNO
-ALL STEELWORK TO EXC2
-ALL TOLERANCES TO MEET BS 1090-2
-MAKE SURE SURFACE IS FREE FROM GREASE & MILL SCALE
-ACCEPTABLE CRITERIA TO BS EN 5817 (QUALITY LEVEL C)
-LAMELLA TEARING TO BE AVOIDED BY GOOD JOINT DESIGN
-CORRECT MATERIALS, WELDING SEQUENCE AND TECHNIQUE
-RESTRAINTS APPLIED , CLAMPS AND BRACES (IF REQUIRED)
-TURNING OF COMPONENTS BY O/H CRANE AND 'a' FRAMES
-MEASURES TO AVOID DISTORTION PRE-HEAT POST-HEAT

WPS 01 SL FW(135) z <8.5mm
WPS 02 ML FW(135) Z >8.5mm
WPS 06 SL FW(141) ALU
WPS 09 BW(135)
WPS 03 SL FW(135)
PIPE TO PLATE
WPS 05 SL FW(141)
STAINLESS
WPS 08 SL FW(141)
SS PIPE-PLATE

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Enterprise House, Unit
1 Aber Park Industrial Estate
Flintshire, CH6 5EX
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e: info@is-group.co.uk
w: www.is-group.co.uk

QTY	AS DETAILED
MATERIAL GRADE	AS DETAILED
SURFACE FINISH AND BS No.	

	SITE		
	TITLE		
	SCALE		
	DATE	25.03.2026	
	DRAWN	RH	CHECKED
	SHEET No.	1	SO No. 5722
	DRAWING No.	SO5722-Greenwall	

STRUCTURAL ENGINEERS JOB No. 000000 COLUMN TO BASEPLATE 00mm FILLET WELD

DRAWING ISSUE: INFORMATION

REVISION.

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