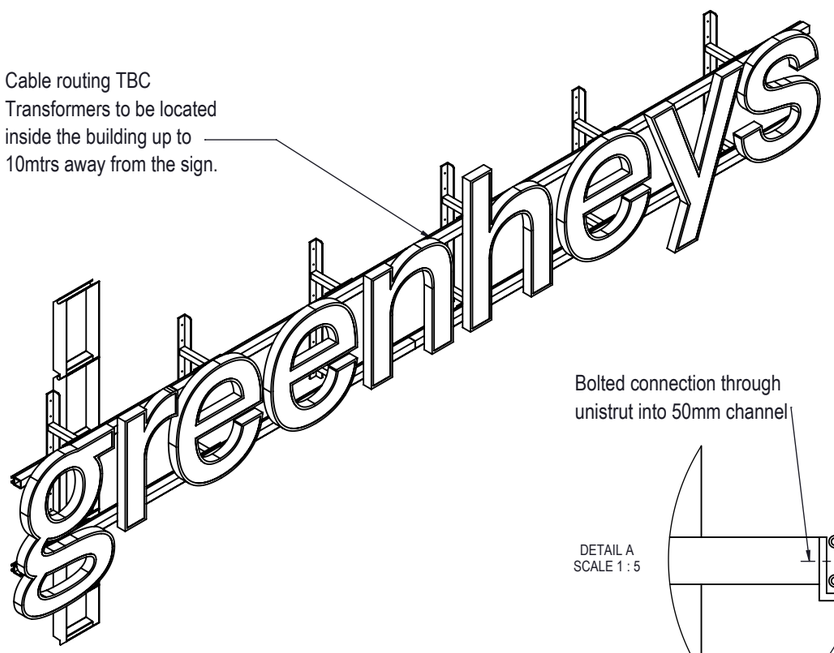
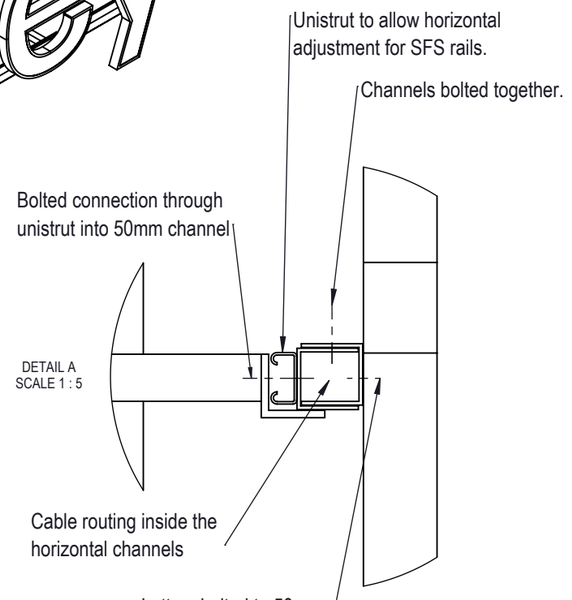
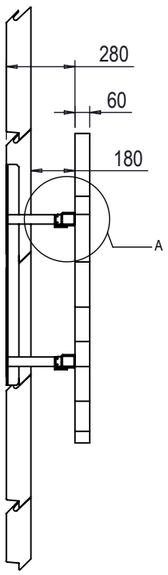
SO5722 - Greenwall sign - Greenheys - Manchester Science Park

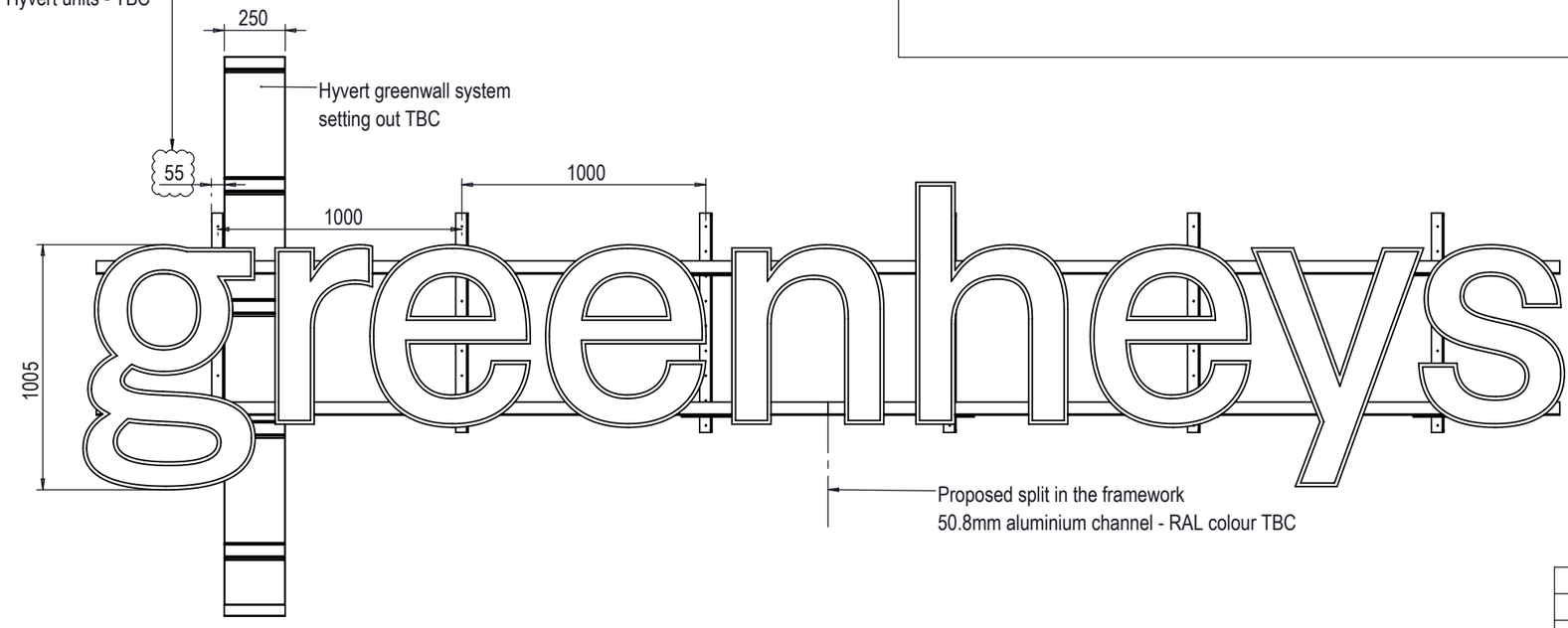


Isometric view



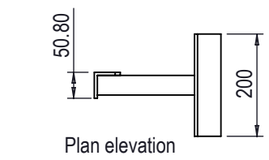


Left side elevation

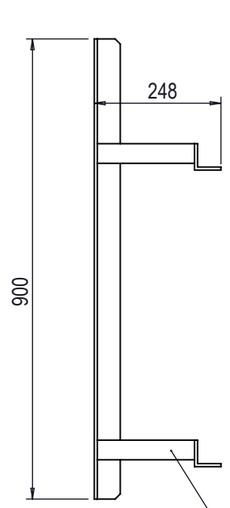


Front elevation

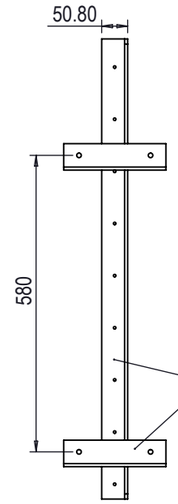
Mounting brackets - Approx 2.2kg each - RAL colour TBC



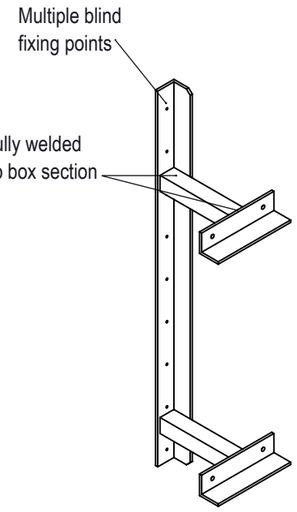
Plan elevation



Side elevation



Front elevation



Isometric view

50.8x50.8x6.3mm aluminium
6063 grade equal angle

38.1x38.1x3.2mm 6063 grade
aluminium box section

JOB CARD-F006

WELD SET No.		
WELDING WIRE LOT/BATCH		
WELDING GAS LOT/BATCH		
ISSUE TO FAB	INITIALS:	
CUT BY	INITIALS:	
BENT BY	INITIALS:	
DIM 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

isGroup
CUTTING EDGE SIGNAGE
Enterprise House, Unit 1
Aber Park Industrial
Estate
Flintshire, CH6 5EX
t: 01352 792000
e:info@is group.co.uk:
www.is-group.co.uk

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

SITE	
TITLE	
SCALE	Do not scale
DATE	07.04.2026
DRAWN	CHECKED
SHEET No.	3 SO No. 5722
DRAWING No.	SO5722-Greenwall

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

DRAWING ISSUE | INFORMATION | REVISION.

NOTE: THIS DRAWING AND ALL DESIGN DETAILS ARE CONFIDENTIAL AND THE EXCLUSIVE PROPERTY OF IS CONSULTANCY LTD WHICH RESERVES ALL PATENT AND OTHER RIGHTS.
ALL DRAWINGS MUST BE RETURNED WHEN REQUESTED AND USED SUBJECT TO ABOVE CONDITIONS ONLY ON AUTHORISED COMPANY WORK. USE FIGURED DIMENSIONS. SCALING OF DRAWINGS IS AT CONTRACTORS RISK.