



A technical drawing showing a cross-section of a reinforcing ring joint. A vertical section of the ring meets a horizontal section. The joint is welded with a double fillet weld on both sides. The top section has a V-shaped cutout (V out) at the center of the joint. The angle of the V out is labeled as 45 degrees, with a note that it is not less than that. The weld metal is shown as a shaded area between the two sections of the ring.

CONTINUOUS DOUBLE FILLET
WELD, BOTH SIDES.

V OUT, LEAVING $\frac{1}{8}$ " OF
BASE METAL AT CENTER
OF REINFORCING RING.

45°—NOT LESS THAN.

NOTE: REINFORCING RING TO BE PUT ON IN NOT MORE THAN THREE SECTIONS, AND WHERE THE SECTIONS BUTT THEY ARE TO BE DOUBLE-V WELDED. WIDTH OF RING TO BE NOT LESS THAN 3" AND THICKNESS NOT TO EXCEED THAT OF THE FURNACE SHELL. WELDING TO END FLUSH WITH THE SURFACE OF THE RING AND TO BE DONE BY A WELDING OPERATOR DULY QUALIFIED.

