

A

B

C

D

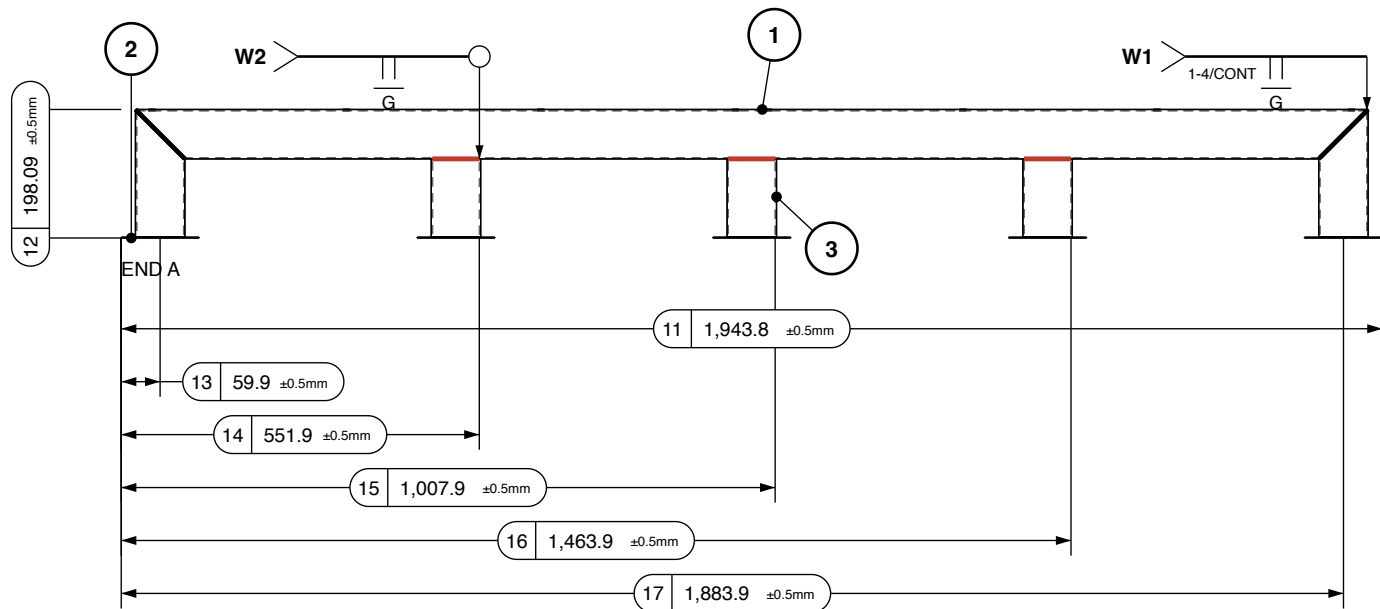
E

F

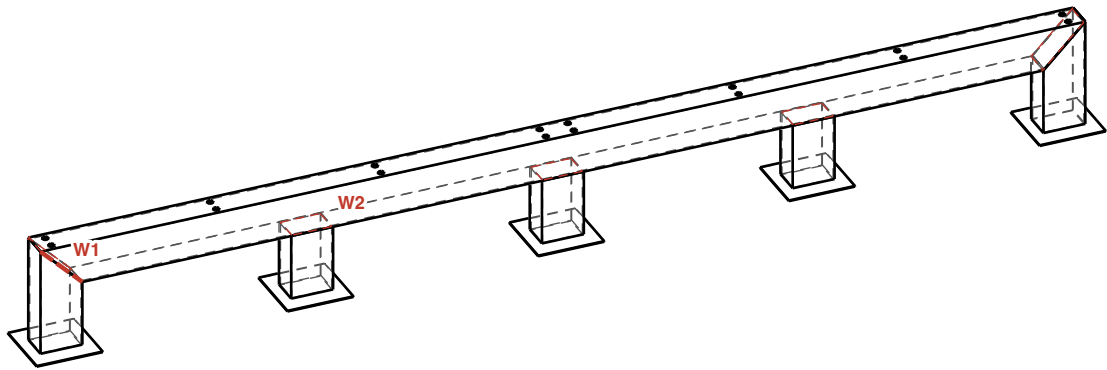
Weld Schedule							
Joint	Members	Type	Size	Qty	Each (in)	Total (in)	Weld spec
W1	Exterior Support Tube / Internal Vertical Tube	butt	CONT + 1-4	2	12.49"	19.08" (76%)	NOT REVIEWED
W2	Interior Support Tube / Internal Vertical Tube	butt	—	3	10.00"	30.00"	NOT REVIEWED

WELDING	Weld length (in)
This step	49.08
Per weldment, all steps	99.08
× 9 in the assembly	891.71

Parts List			
Item	Qty	Part Name	Material
1	1	Internal Vertical Tube	ASTM A500 Gr B
2	2	Base + Exterior Support Tube	Step 1
3	3	Base + Interior Support Tube	Step 2



SIDE VIEW



ISOMETRIC

STEP 3 OF 3 — WELD TO Internal Vertical Tube: 2 x (Base + Exterior Support Tube) from step 1; 3 x (Base + Interior Support Tube) from step 2. Repeat for each of the 9 weldments.

1. WELD SIZES AND FILLER ARE DESIGN INPUT, NOT THE SHOP'S CHOICE.
 2. WELD SIZES AND LENGTHS IN INCHES; PART DIMENSIONS IN MM.
 3. NUMBERED CHARACTERISTICS ARE THE INSPECTION CONTRACT.
- W1: CONTINUOUS on the seen perimeter (0.4 m), ground FLUSH and POLISHED; STITCH 1-4 inside (0.2 m).
W2 SEEN IN SERVICE: CONTINUOUS weld, ground FLUSH and POLISHED so the corner reads as one part (0.5 m seen).

WELD SYMBOLS (AWS A2.4)

- fillet
- square groove (butt)
- weld all around
- flush, ground (G) and polished
- seen

arrow points at the joint; tag = row in the table

PENDING APPROVAL — review it: [SIGNAL > WELD > Welding drawings review](#)

Dept. QA	Technical reference +/- 0.5mm	Created by AG 8/10/26	Weight 21.81 lb	Thickness
		Document type Inspection - Welding	Material ASTM A500 Gr B	
		Title Tube Frame Internal Support Frame Step 3 of 3	DWG No. TF-ISF-W3	
		Rev. 1	Date of issue 08/10/2026	Sheet 3/7