



BELPAIRE FORMED PLATE

14 5/8"

2 3/8"

1/4"

BURN OUT TOP HALF OF PIPE AND COMPLETELY WELD BELPAIRE FORMED PLATE INCLUDING FILLER PIECES IN FRONT TOP CORNERS FIRST

1 13/16"

7/16" APPROX

NOTE: LIGHTLY TACK WELD A BRACE ACROSS BACK OF PIPE BEFORE ANY BURNING OUT

2. THEN BURN OUT LOWER SECTION AND TACK WELD SIDE PLATES AND THROAT SHEET TO PIPE. TACK WELD TWO 6" LONG SPACERS AS SHOWN BEFORE FINISH WELDING THESE PARTS

FIREBOX SIDE PLATES

BOILER BARREL 7 1/2"OD, 1/4 WALL TUBING

25 1/8"

BOILRE BARELL CUTOUT  
1 1/2 LIGHT MOGUL  
SHEET- B2