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DEPARTMENT OF THE ARMY TECHNICAL BULLETIN

ARC WELDING ON WATER-BORNE VESSELS

Headquarters. Department of the Army, Washington, D.C.
10 April 1974

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1. Purpose. The intent of this bulletin is to provide information and guidance to personnel involved with the use of arc welding machines when used on watercraft.

2. Scope. This bulletin applies to all active US Army units, installations and activities; reserve units and national guard units involved in the maintenance and repair of watercraft. This bulletin does not apply to Corps of Engineer Units but may be used by them for guidance.

3. Recommendation for Maintenance Publications Improvements.

You can help to improve this manual by calling attention to errors and by recommending improvements. Your letter or DA Form 2028 Recommended Changes to Publications and Blank Forms) should be mailed direct to: Commander, US Army Troop Support Command, ATTN: AMSTS-MPP, 4300 Goodfellow Blvd., St. Louis, MO 63120. A reply will be sent directly to you.

4. Procedure. *a.* This bulletin outlines the procedure for properly grounding the welding leads to avoid serious damage, by electrolysis, to the underwater hull, shafting, propellers and other underwater appurtenances.

b. Welding motor-generator sets or rectifiers shall be so installed that the welding and ground leads from shores to ship or from repair ship to ship or ships alongside shall be connected only to the vessel on which welding is to be done. The welding lead as well as the ground lead shall be thoroughly insulated and at no time shall be allowed to become submerged in the intervening water. Welding shall be done on but one ship from one source of welding current. The ground lead shall not be electrically connected to any object ashore or to the repair ship or other vessel except the one on which welding is being done. The ground cables should have an area of at least one

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* This bulletin supersedes TB TC 11, 10 March 1953