1. Center and position the SFR flange flat to the plate.
2. Tack weld on the front side of the SFR in four places or every 100 mm around the periphery.
3. Continue welding around the front side of the SFR.
4. Complete by seal welding around the rear side of the SFR.

1. Position the S-type sleeve into the plate, maximum allowed root gap is 2 mm.
2. Tack weld in four places or every 100 mm around the sleeve.
3. Weld around the front side of the sleeve.
4. Complete by seal welding around the rear side of the sleeve.