Ship/HULL NO.	Ship/HULL NAME	JON:	ICN:	Rev:	Key Op:
	DIVE BOAT		89ZAA85017		A01

TITLE:

ELM-255042; accomplish

JOB SPECIFICATION

Anticipated Award Date:	Production Completion Date:	PREPARING ACTIVITY:
6/30/2026	10/30/2026	SASEBO
POP Start Date: 7/30/2026	POP End Date: 12/30/2026	

PREPARED BY: Y.HAMABE	CODE H_HA	DATE 3/09/2026
APPROVED BY: S.MURAKAMI	CODE S225	
CONCURRED BY: S.MOROOKA	CODE S231	
ASSIST PLANNER'S NAME:	CODE	
ASSIST PLANNER'S NAME:	CODE	
ASSIST PLANNER'S NAME:	CODE	

WORK TO BE DONE IN DRY-BERTHING

DESCRIPTION:

JSN(S): CASREP #

S/F CONTACT: CWP # CCNS #

Approved by S300/S900 Date: 3/11/26 Avl: 6A1

LWC:

Work Completed

S/Force: Rate: Date:

Ship Supt: Date: SRF CONTROL NO.: 1301370704

WORK CERTIFICATION SIGNATURES

COMPLETION OF WORK REVIEW:	BADGE NO.:	SHOP/CODE:	PHONE:	DATE:

1/10

Ship/HULL NO.	Ship/HULL NAME	JON:	ICN:	Rev:	Key Op:
	DIVE BOAT		89ZAA85017		A01

TITLE:

ELM-255042; accomplish

1. **SCOPE:**

1.1 Title: ELM-255042; accomplish

1.2 Location of Work:

1.2.1 Void Space, 6 Inch AFT of Frame 3 to Frame 9

1.3 Identification:

1.3.1 Listed in 2.2 (Item 1 and 2 Only) for Structural Repair, Located in 1.2.1

1.3.2 A Total of (740 SF) of Entire Surface (Item 3 of 2.2) of Void Space Located in 1.2.1

2. **REFERENCES:**

2.1 Standard Items (FY26)

2.2 ELM-255042, Dive Boat Hull Structure in Void; Repair **(enclosed)**

3. **REQUIREMENTS:**

3.1 Accomplish the requirements of 2.2 for structural repair listed in 1.3.1.

3.1.1 Accomplish the requirements of **009-012** of 2.1, including Table 4, Column A, Lines One through 7 for welding. (See NOTE 4.3).

(V) "REPORT"

3.1.1.1 Ensure to notify which welding standard has been selected to SUPERVISOR.

3.1.1.2 Accomplish nondestructive testing of new welded joint of each primary structure in accordance with Line 9.

3.1.2 Accomplish the requirements of **009-025** of 2.1 for a local air hose test of each welding section of watertight boundary. Allowable leakage: None.

3.2 Accomplish the requirements of **009-032** of 2.1, including Table 3, One system out of Line 9, 10, or 11, Columns A, B and E for each area listed in 1.3.2.

3.2.1 Power tool clean each narrow area to SSPC-SP-3 where power tool in 3.2 cannot reach.

3.2.1.1 Hand tool clean each narrow area to SSPC-SP-2 where power tool in 3.2.1 cannot reach.

3.3 Accomplish the requirements of 009-032 of 2.1 for cleaning and preservation of each new and disturbed surface to match surrounding areas.

4. **NOTES**:

4.1 Initial Condition - Void space (under the gally) is required to repair/preserve under ELM-255042.

4.2 SRF Tool room will issue pressure gauges when required.

4.3 OPTION A) of Table 4 of 009-12 of 2.1 has been allowed to utilize under ELM-255171.

4.4 This work is to be accomplished in conjunction with other ICN 89ZAA85013_A01.

4.5 Marine chemist inspection will be covered by 89ZAA85005_A01.

4.6 Each preservation work of the underwater hull will be covered by ICN 89ZAA85005_A01.

4.7 The contractor is responsible to dispose all waste generated by this work item in accordance with Japanese Environmental Governing Standards (JEGS).

5. **GOVERNMENT FURNISHED MATERIAL (GFM)** :

5.1 Government Furnished Material as follows.

MATERIAL LIST

ITEM NO.	PC NO.	REF NO.	M/C	DESCRIPTION	STOCK NUMBER	HAZ MAT	DOC NO.	QTY REQD/ UNIT	PARA NO.
001			M	PLATE,ME,3/16" THK 60 INCH W X 20 FT L, ABS GR A	9B 9515 002375333	9		1/PM	3.1
002			M	BEAM STRUCTURAL, TEE,SHAPE (CUT FROM S SHAPE) ST3 (IN) X 6.25 (LBS/FT), ASTM A36	9B 9520	9		10/FT	3.1
003			C	BAR,METAL,1/4 INCH THK X 2 INCH ASTM A36	9B 9510 001891558	9		12/FT	

ENGINEERING LIAISON MEMORANDUM

SRF - JRMC SASEBO
JAPAN

Controlled by: DON
Controlled by: SRF-JRMC/S245
CUI Category: CTI
Distribution Statement or LDC: C
POC: C. Hadnot / 315-252-8317

DISTRIBUTION STATEMENT C: Distribution authorized to U.S. Government agencies and their contractors; Critical Technology; (7/16/2024). Other U.S. requests for this document shall be referred to U.S. Naval Ship Repair Facility and Japan Regional Maintenance Center, Yokosuka, Japan.

1. HULL NO. / SHIP NAME / TITLE	2. ELM NO.	3. REV	4. ICN/KO	5. ESR NO.
DIVE BOAT Hull structure in Void; Repair	255042	-	DS-01/FY25 DIVE BOAT OVERHAUL	DIVE BOAT-0011
	6. SCD		7. DFS REQUIRED	
	SCD: N/A		DFS: N/A	
	8. SWBS	9. ADDITIONAL APPLICABILITY:		
	100	N/A		

10. APPROVAL

Originator	Date	Reviewer	Date
M.YOKOISHI YOKOISHI.MITSU KUNI.1386506171	12/18/2024	Y. IIDA IIDA.YOSHIZUMI.1386806724 Date: 2024.12.18 16:08:52 +09'00'	12/18/2024
Project Support Engineer	**Date**		
D. MATSUO MATSUO.DANIE L.T.1232040579	12/19/2024		
S245 Design Branch Head		**Date**	
D. MATSUO (for C. HADNOT) MATSUO.DANIE L.T.1232040579		12/19/2024	
S200A Technical Deputy Approval / LTA		**Date**	
N/A			
S200 Engineering and Planning Dept. Head / LTA		**Date**	
N/A			

11. CORRECTIVE ACTION

1. REFERENCE:
   (a) ESR DIVE BOAT-0011, VOID DAMAGE REPAIR
   (b) TM S9086-CH-STM-010 Rev. 6, Naval Ships' Technical Manual Chapter 074 Volume 1 Welding and Allied Processes, 30 May 2019
   (c) TM 0900-LP-060-4010, W/Changes 1-2, Fabrication, Welding and Inspection of Metal Boat and Craft Hulls, JAN 1971
   (d) TM S9AA0-AB-GOS-010, Rev. 11, General Specifications for Overhaul of Surface Ships, 16 JAN 2024

2. ENCLOSURE:
   (a) Structural Inspection Report for Void Space at 6" AFT of FR 3 to FR 9 aboard DIVE BOAT, dated 3 Dec 2024

3. BACKGROUND:
   a. Reference (a) requested S245 to provide repair plan for damaged structural members in void space.

   b. S245 performed structural inspection in the void space on 3 Dec 2024 and provided permanent repair plan, enclosure (1).

4. GENERAL NOTES:
   a. The purpose of this ELM is to release the Structural Inspection Report, enclosure (1).

5. REQUIRED ACTIONS:
   a. Perform all recommended repair actions identified in the structural inspection report, enclosure (1).

6. TEST NOTES:
   a. Verify that all tightness requirements to the compartment's boundaries are restored with the completion test. Testing shall be in accordance with section 192 in reference (d). The alternative methods specified in paragraph 192f in reference (d) are allowed.

7. MATERIALS:
   a. See enclosure (1).

CUI//SP-CTI/FEDCON

Controlled by: DON
Controlled by: SRF-JRMC/S245
CUI Category: CTI
Distribution Statement or LDC: C
POC: C. Hadnot / 315-252-8317

STRUCTURAL INSPECTION REPORT

SHIP: Dive Boat
COMPARTMENT: Void Space at 6" AFT of FR 3 to FR 9
INSPECTION DATE: 3 Dec 2024 (Avail: N/A)
REPORT ISSUED DATE: 6 Dec 2024
ESR: DIVE BOAT-0011
INSPECTION JCN: DS-01/FY25 DIVE BOAT OVERHAUL
REPAIR JCN: Project Team will assign

INSPECTOR:
- Mitsukuni YOKOISHI, SRF-JRMC Sasebo, Design Branch, Code S245, E-mail: mitsukuni.yokoishi.ln@us.navy.mil

REFERENCES:

NO.	DOCUMENT NO.	REV	TITLE
1	ESR DIVE BOAT-0011	-	Void Damage Repair
2	TM S9086-CH-STM-010, Ch 074	6	NSTM Ch 074 Vol.1 Welding and Allied Processes
3	TM S9086-VD-STM-010, Ch 631	3	NSTM Ch 631 Preservation of Ships in Service - General
4	TM S9000-LP-060-4010, W/Change 1-2	4	Fabrication, Welding and Inspection of Metal Boat and Craft Hulls, Jan 2024
5	S9AA0-AB-GOS-010	11	General Specifications for Overhaul of Surface Ships
6	NAVSEA DWG 145-4777405	E	50 Work Boat, Hull Construction and Details
7	NAVSEA DWG 111-6577273	B	50' Work Boat, Structural Modification for Dive Boat Conversion
8	NAVSEA DWG 117-6627988	B	50 FT Workboat, Transverse Frames, Bulkheads & Midship Section

ENCLOSURE:
A. Photos of defects

NOTE:
1. This structural inspection was performed as requested via reference (1).
2. All pictures are digitally available at the link below for all Flank Speed users.
   https://flankspeed.sharepoint-mil.us/:f:/s/ServiceShips/Ei_rfg7dnzpMtGz50Ts7C6MBl3NIyW4c4Yjqe35zPdL_IA?e=TFfoyr
3. Preserve new materials and surfaces affected by the structural repair, which are recommended for the item in this report, IAW NAVSEA SI 009-32 upon completion of the repair.
4. The repair recommendation in this report is the permanent repair method unless specified otherwise. Although only "web" or "flange" are written in the repair recommendation column, it is permissible to replace both web and flange.

CUI//SP-CTI/FEDCON

STRUCTURAL INSPECTION REPORT

DIVE BOAT, Void Space, Dec 2024

Item	Risk Matrix Level	Repair JCN	Problem Description	Repair Recommendation	NAVSEA Dwg. No. (if applicable)
1	N/A	Project Team will assign	Deformed web in the lower section of Web Frame at FR 6 on shell plate, starting at 1" STBD of Long'l L1P, 1/4" thk x 2" W flat bar, at 15" PORT off centerline keel on bottom shell plate and extending to 1" PORT of Long'l L1S at 15" STBD off centerline keel on bottom shell plate, and starting at the bottom shell plate and extending 10" above. This is caused by overloading from the bottom side (underwater). Coating is partially damaged. The web frame is approx. 20" H web and 2" W flange. 3/16" thk, OSS.	Crop out and replace the web plate of web frame. Template new web plate from the existing. Estimated as 40" W x 15" H.	Ref 6, Sheet 2, Section Frame No. 6, Zone 11-A & Ref 8, Sheet 2, Det 7-A and Det 7-B for CL keel and longitudinal penetrations in web frame, respectively
2	N/A	Project Team will assign	Deformed shell plate, 3/16" thk OSS, located from 7" AFT of FR 5 to 12" AFT of FR 6, and starting at 5" STBD of Long'l L1S and extending to 3" PORT of centerline keel. 1/4" out of plane plate exceeds the fairness criteria of 3/16" IAW Figure 12-5 in Ref 4. This is caused by overloading from the bottom side (underwater). Coating is intact on shell plate but cracked on edge of centerline keel and Long'l L1S flat bar.	1. Crop out and replace the plate. Estimated as 46" LG x 46" W. 2. Visually inspect the centerline Keel, ST 3 x 6.25 OSS, when the above shell plating repair is executed in the drydocking availability. Then, crop out and replace the damaged portion as necessary. Estimated as 55" LG. Note: The GPS Transducer located just FWD of Web Frame at FR 6 is relocated to more AFT side. The relocation is scheduled at same time as the above shell plating repair. Refer to ESR DIVER BOAT-0008.	Ref 6, Sheet 4, Bottom Plating, Zone 26-A & Ref 6, Sheet 4, Section 24-A, Zone 24-A for centerline keel
3	N/A	Project Team will assign	Scattered corrosion in the void space, located from watertight BHD at 6" AFT of FR 3 to watertight BHD at FR 9, entirely.	Preserve the structural surfaces in the void space entirely.	N/A

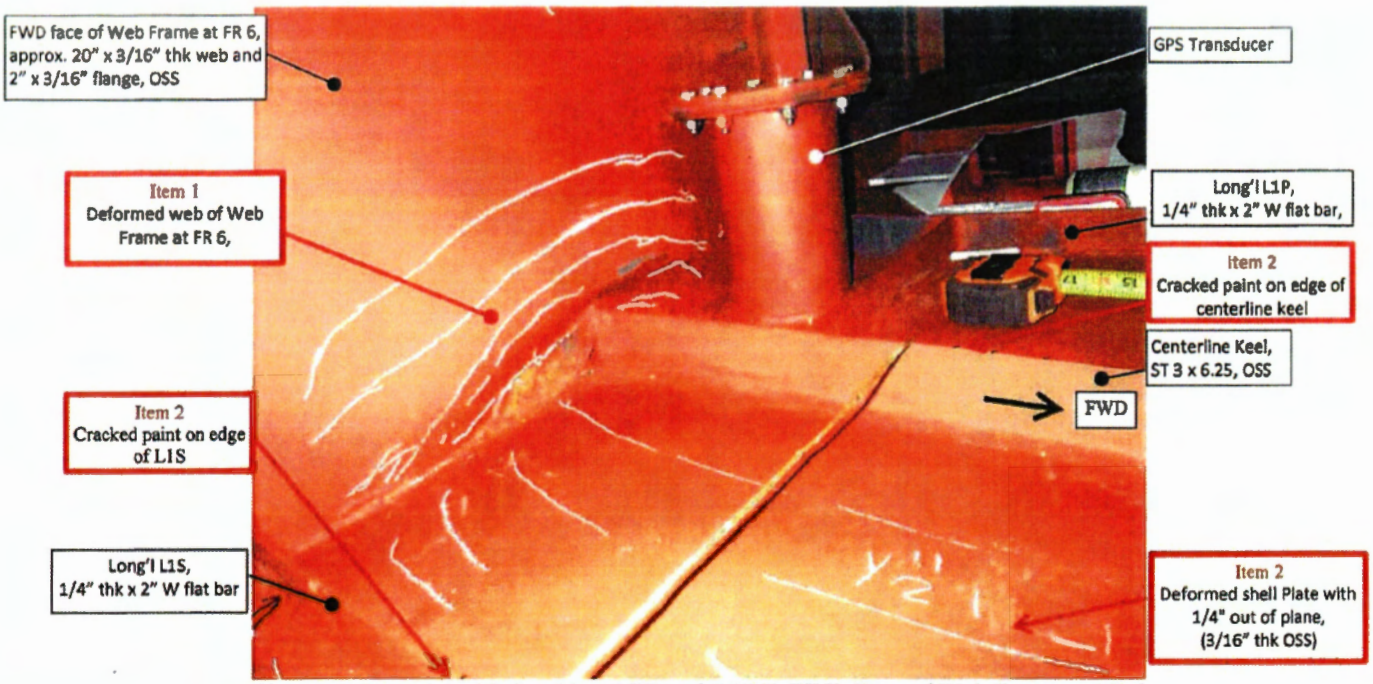
89ZAA85017_A01

4/10

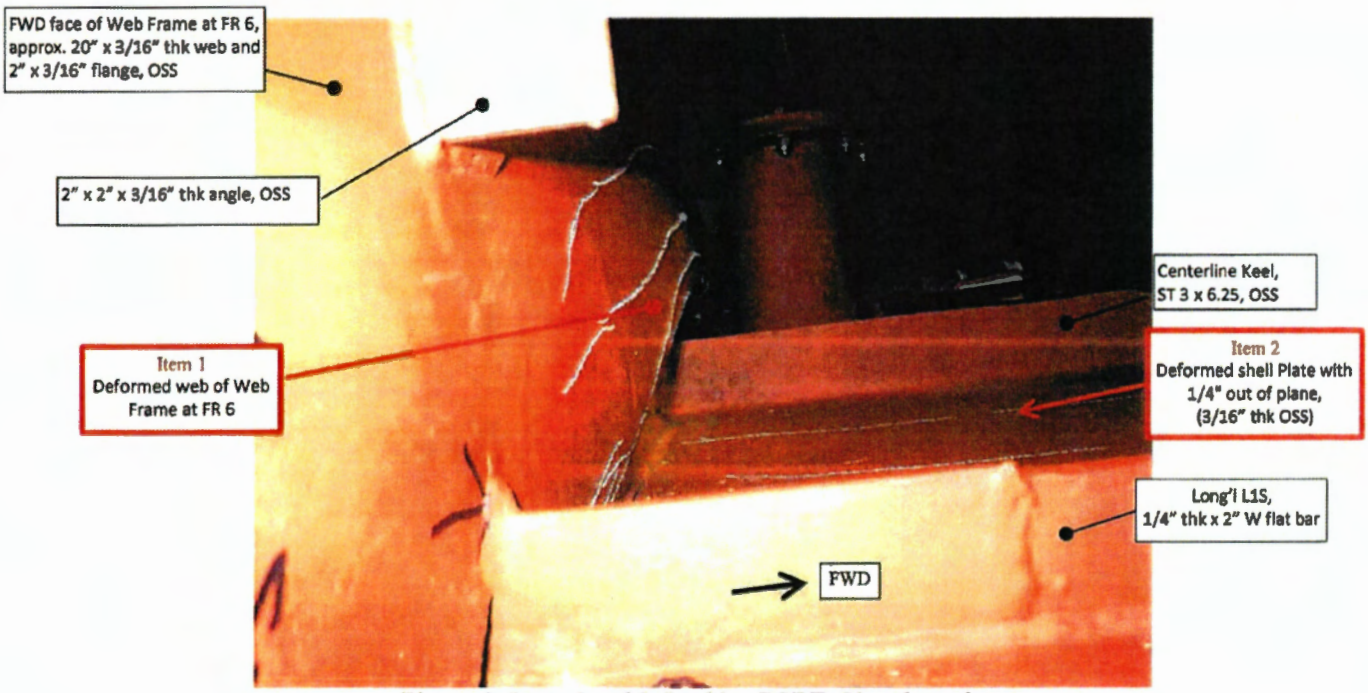
STRUCTURAL INSPECTION REPORT

DIVE BOAT, Void Space, Dec 2024

ENCLOSURE A



Picture 1, Items 1 and 2, Looking AFT and PORT, FWD Face of Web Frame at FR 6

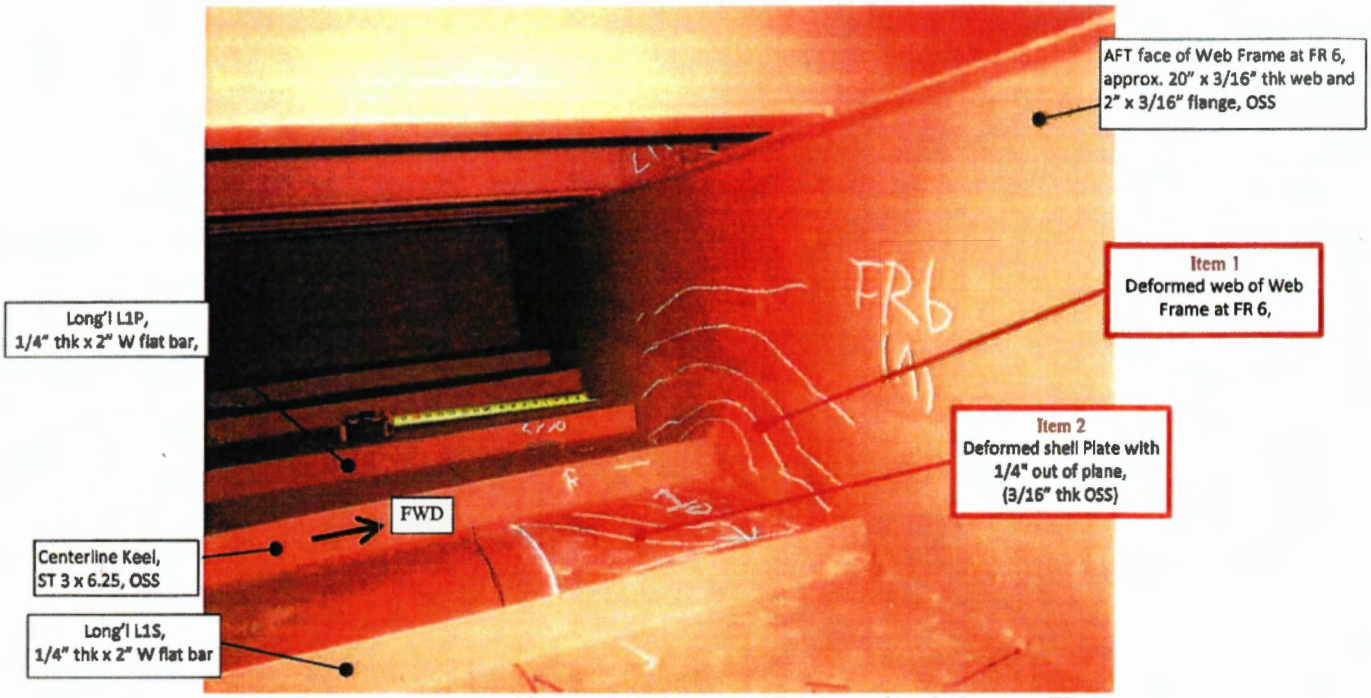


Picture 2, Items 1 and 2, Looking PORT, Closed-up view

STRUCTURAL INSPECTION REPORT

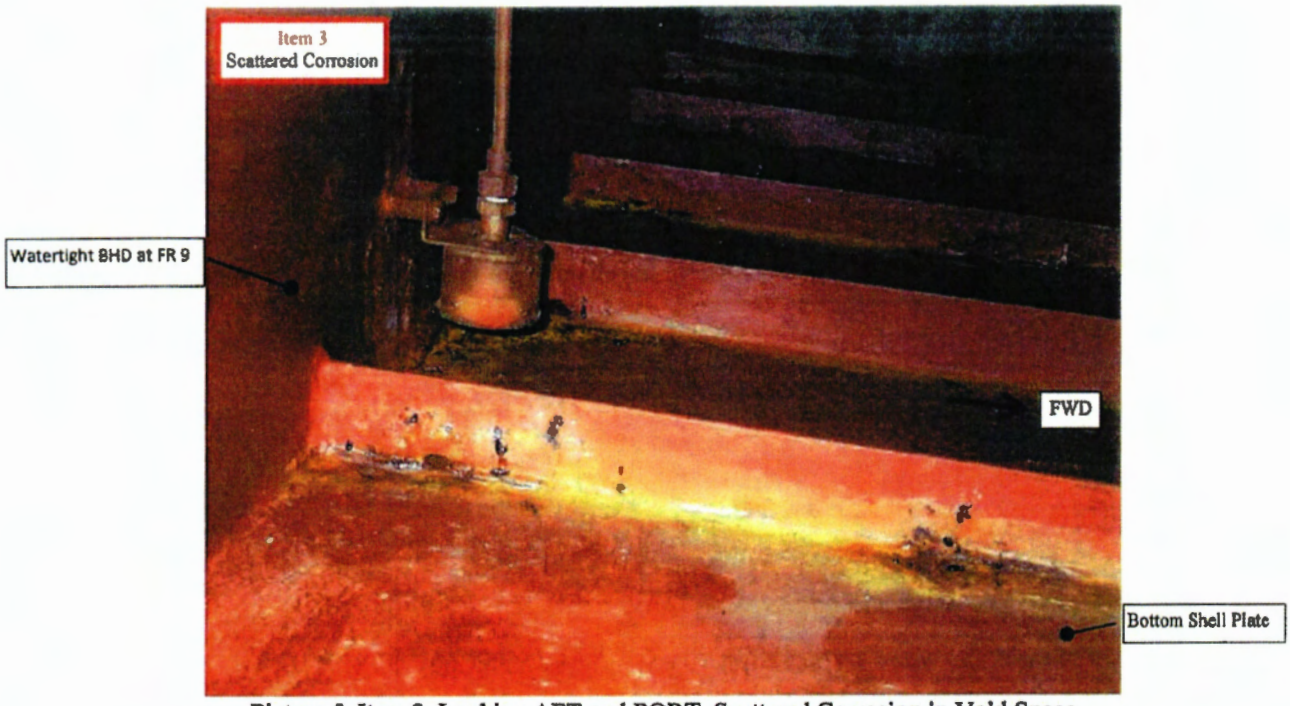
DIVE BOAT, Void Space, Dec 2024

ENCLOSURE A

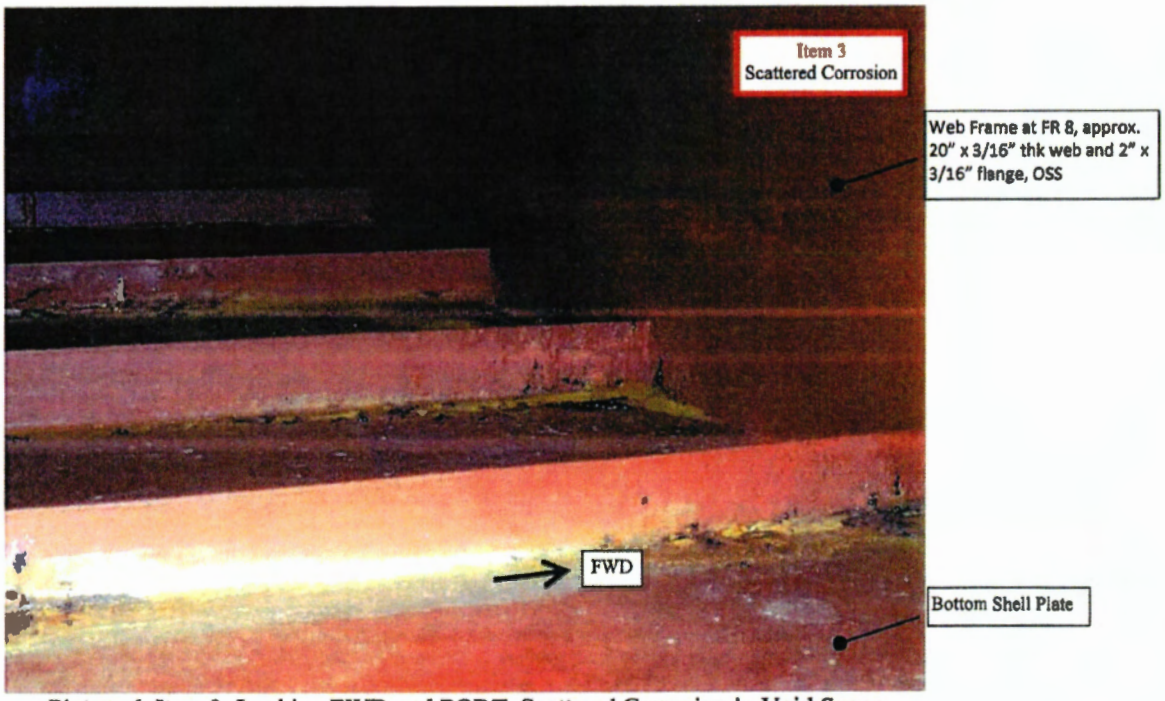


Picture 3, Item 1 and 2, Looking FWD and PORT, AFT Face of Web Frame at FR 6

Picture 4, Item 3, Looking PORT, Scattered Corrosion in Void Space



Picture 5, Item 3, Looking AFT and PORT, Scattered Corrosion in Void Space



Picture 6, Item 3, Looking FWD and PORT, Scattered Corrosion in Void Space