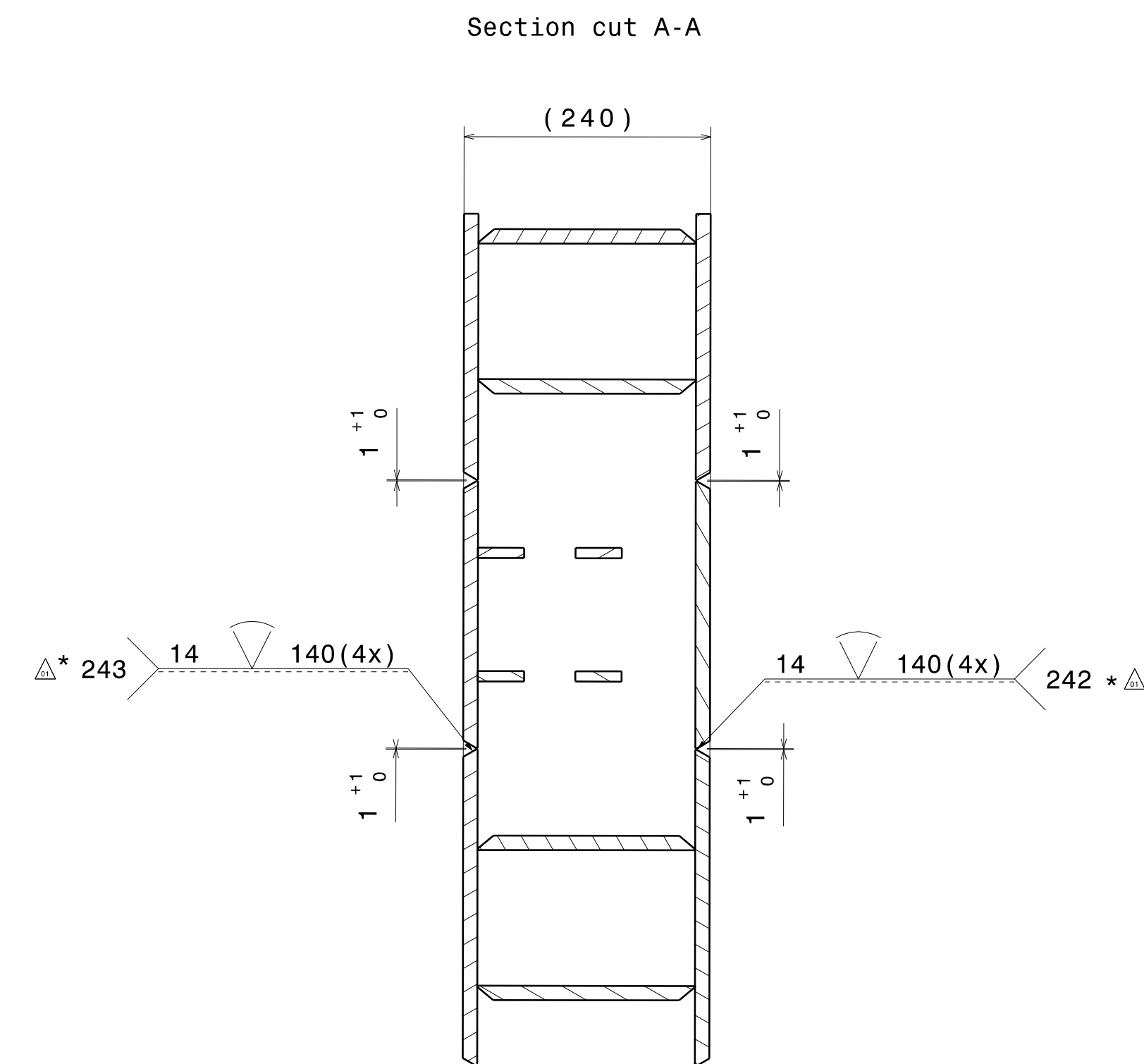
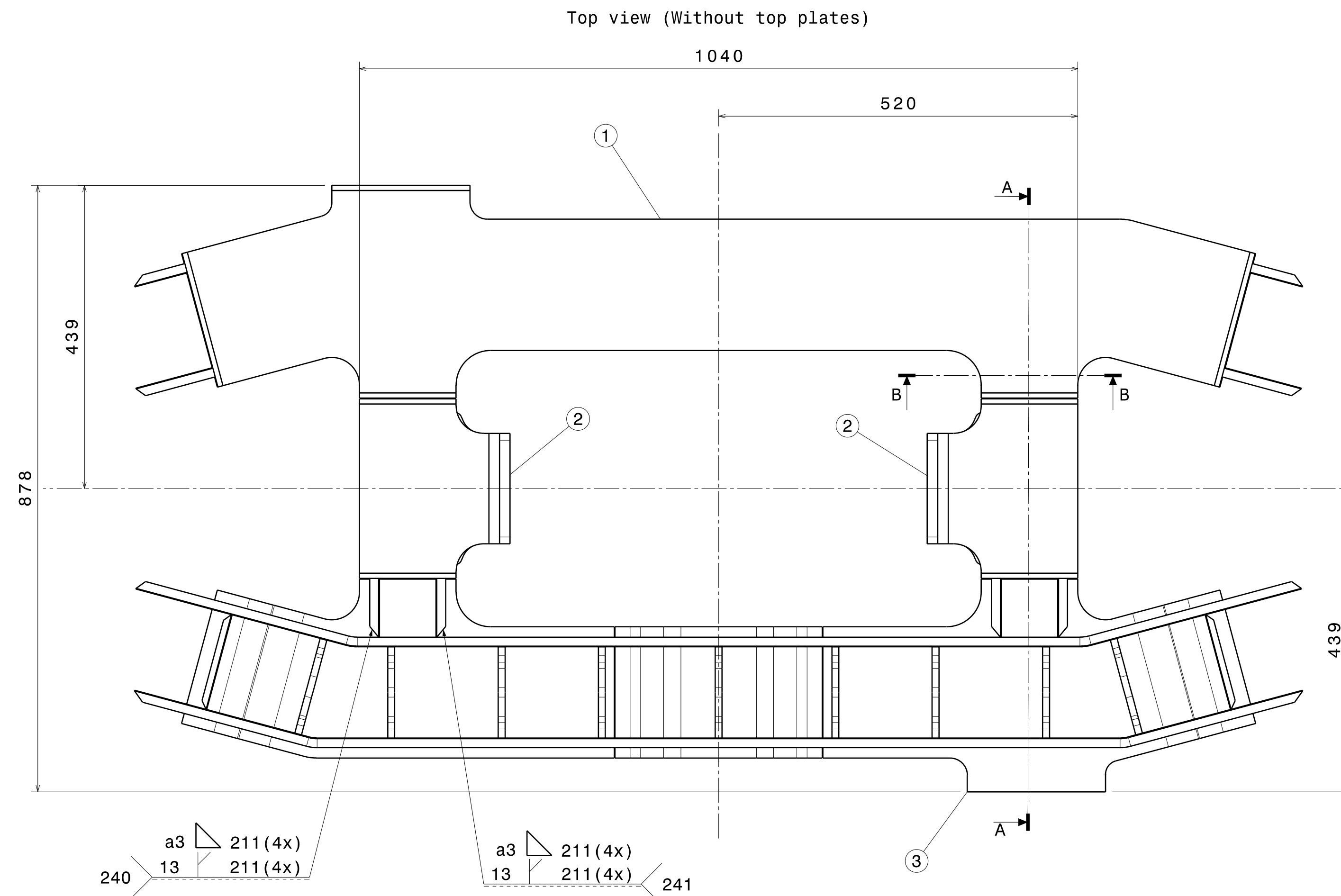
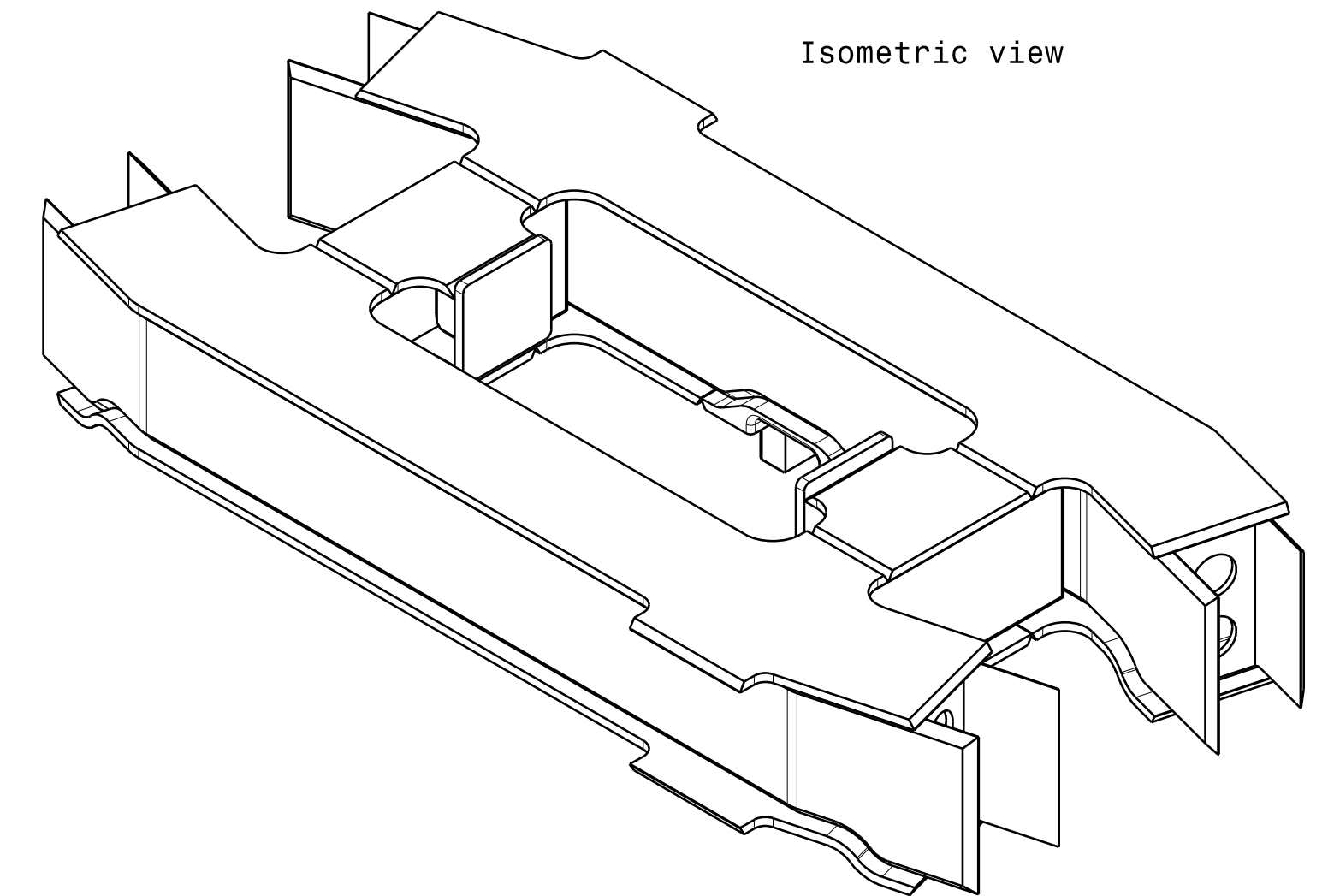
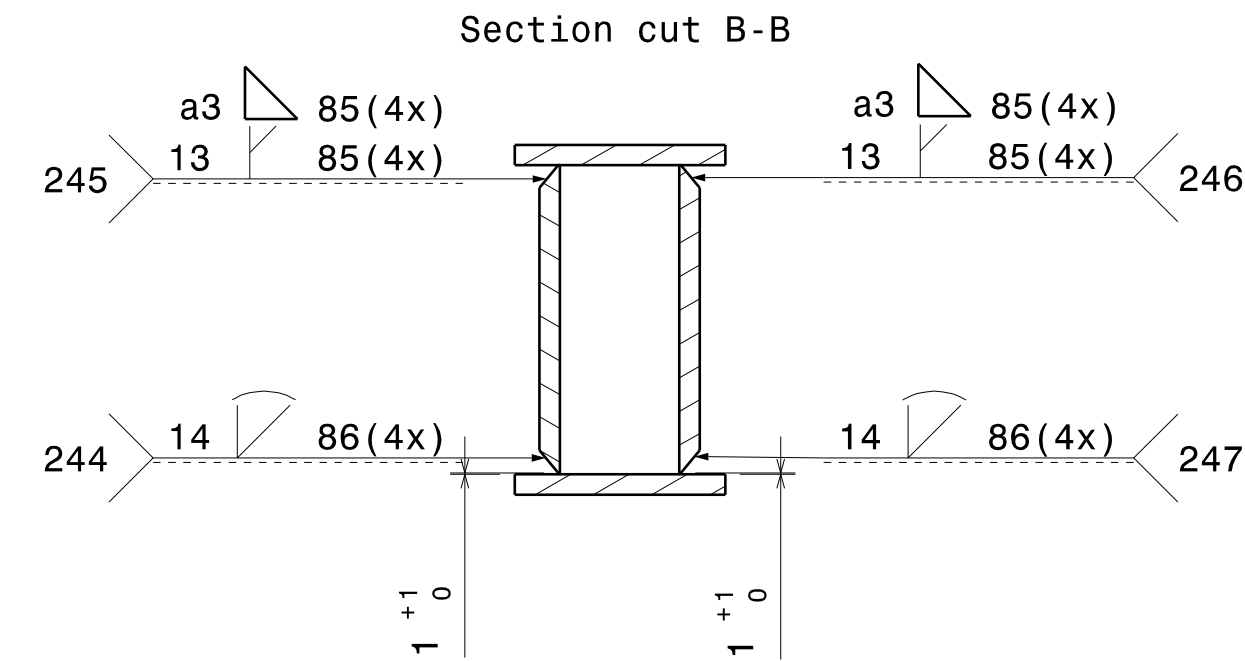




ISO 13920 Welded Construction	ISO 2768 General	ISO 12708 Steel Casting	G		H	
			mm	mm	mm	mm
<1000	6.0/0.8					
<630	4.0/0.7					
<400	3.0/0.6					
<250	3.0/0.4					
100	2.0/0.3					
L mm			mm	mm	mm	mm
			mm	mm	mm	mm
<4000	2.0/0.4					
<2000	1.2/0.4					
<1000	0.8/0.3					
<400	0.5/0.3					
30-120	0.3/0.2					
2-30	0.2/0.1					
L mm			mm	mm	mm	mm
			mm	mm	mm	mm
>20000	9.0/8.0					
>20000	8.0/7.0					
>16000	7.0/6.0					
>12000	6.0/5.0					
>8000	5.0/4.0					
>4000	4.0/3.0					
<1000	2.0/1.5					
<400	1.0/1.0					
30-120	1.0/0.5					
2-30	1.0/0.5					
L mm			mm	mm	mm	mm
			mm	mm	mm	mm

"*" For butt weld joint it's possible use backing plate at discretion of manufacturer.

GENERAL WELDING REQUIREMENTS

Welding classification and controlling according
to technical document TD-GZ.B00.303.0001

WELDING PERFORMANCE CLASS

CP C2

Technical Specifications					
Technical Document					
Fixture/Mould Asset ID.					
Coating/Heat Tre./Roughness	1	Added notes		05/12/2022	D. Carlin
Paint/Color	Modf. No	Modification Description		Date	Sign

3	Motor bogie frame - rear transversal beam wid -	1	6Z10.04.03.70300	-	-	172.8 24kg	H
2	Bogie frame - Lateral buffer wid -	2	6Z10.04.03.70200	-	-	33.53 1kg	
1	Motor bogie frame - front transversal beam wid -	1	6Z10.04.03.70100	-	-	163.8 81kg	
						403.6	
No	Parça Adı Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension	Ağırlık Weight (Kg)	
	ISO 21920-1 ISO 8015	ISO 2553	General Tol.	ISO 2768	f □ m□X H □	K□X	
	EN 15085-2 Certification Level	CL1□X CL□□ CL□□	Weld Pro.	ISO 13920	A□X B□ EX□	F □	
	Approved	L. Giovinnazzo	05/12/2022	Cast Steel	ISO 12708	Lm2□ Lr2□ Sm2□ Sr2□	
	Checked	M.Borio	05/12/2022	1:5	 Turkish Railway Vehicles Industry Inc.		H
	Prepared	H.Belhaj	05/12/2022				
	Transversal beam assembly			6Z10.04.03.70000			
	-						
TYP	Date:19/10/2022			Sheet : 1/1	Size:A1	Rev: 01	

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