



GENERAL WELDING REQUIREMENTS

Welding classification and controlling according to technical specification BLUE_TS_WLD_01

WELDING PERFORMANCE CLASS

C1

2	Block	1	EM20040320014	S355J2 EN 10025	3.3		
1	Support	1	EM20040320013	S355J2 EN 10025	4.5		
					7.7		
No	Parça Ad Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension	Ağırlık Weight (Kg)	
TYP	ISO 1302 ISO 8015 EN 22553			General Tol.	ISO 2768	f <input type="checkbox"/> m <input checked="" type="checkbox"/> H <input type="checkbox"/> K <input checked="" type="checkbox"/>	
	EN 15085-2 Certification Level			CL1 <input checked="" type="checkbox"/> CL2 <input type="checkbox"/>	Weld Prod.	ISO 13920	A <input checked="" type="checkbox"/> B <input type="checkbox"/> E <input checked="" type="checkbox"/> F <input type="checkbox"/>
				CL3 <input type="checkbox"/> CL4 <input type="checkbox"/>	Cast Steel	ISO 12708	Lm2 <input type="checkbox"/> Lr2 <input type="checkbox"/> Sm2 <input type="checkbox"/> Sr2 <input type="checkbox"/>
	Approved	P.FARINA		Scale	<div>TUVASAS</div> <div>Turkish Wagon Industry</div>		
	Checked	M.BORLO		1:2			
	Prepared	E.PINTUS					
		Support			EM20.04.03.20.010		
Date:08/06/2018				Sheet:1/1	Size:A3	Rev:00	

TS 12708 Steel Casting		
<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
40	1,5	0,2
L mm	Raw	Form
Nom. Size	Class	
<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	m ±	K ±
Nom. Size	Class	
>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
<2000	3,0	2,0
<1000	2,0	1,5
<400	1,0	1,0
30-120	1,0	0,5
2-30	1,0	0,5
L mm	A ±	E ±
Nom. Size	Class	

Technical Specifications	-				
Technical Document	-				
Fixture/Mould Asset ID.	-				
Coating/Heat Tre./Roughness	-				
Paint/Color	-	Modf.No	Modification Description	Date	Sign