

Reproduction, dissemination or use of this document or its all contents in any form without the prior written permission of TÜVASAS, is prohibited. Offenders will be liable for the payment of damages. All rights reserved in the event of the grant of a patent, utility model or commercial design registration.

ISO 13920 Welded Construction	<1000	6.0	0.8
	<630	4.0	0.7
	<400	3.0	0.6
	<250	3.0	0.4
ISO 2768 General Tolerances	100	2.0	0.3
	40	1.5	0.2
	L mm	Ham	L
	Nom. Size	Class	
TS 12708 Steel Casting	<4000	2.0	0.4
	<2000	1.2	0.4
	<1000	0.8	0.3
	<400	0.5	0.3
ISO 13920 Welded Construction	30-120	0.3	0.2
	2-30	0.2	0.1
	L mm	m ± K ±	
	Nom. Size	Class	
ISO 13920 Welded Construction	>20000	9.0	8.0
	<20000	8.0	7.0
	<16000	7.0	6.0
	<12000	6.0	5.0
ISO 13920 Welded Construction	<8000	5.0	4.0
	<4000	4.0	3.0
	<2000	3.0	2.0
	<1000	2.0	1.5
ISO 13920 Welded Construction	<400	1.0	1.0
	30-120	1.0	0.5
	2-30	1.0	0.5
	L mm	A ± E ±	
ISO 13920 Welded Construction	>20000	9.0	8.0
	<20000	8.0	7.0
	<16000	7.0	6.0
	<12000	6.0	5.0

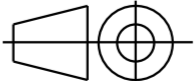
GENERAL WELDING REQUIREMENTS

Welding classification and controlling according to technical specification BLUE_TS_WLD_01

WELDING PERFORMANCE CLASS

C3

Technical Specifications	-					
Technical Document	-					
Fixture/Mould Asset ID.	-					
Coating/Heat Tre./Roughness	-	1	UPDATED WELDING	12/12/18	S.Ponzo	
Paint/Color	-	Modf.No	Modification Description	Date	Sign	

3	Block	1	EM20240320045	S355J2 EN 10025		1.2	
2	Plate	1	EM20040320021	S355J2 EN 10025		2.1	
1	Flange	1	EM20040320020	S355J2 EN 10025		5.9	
						9.2	
No	Parça Adı 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"/> CL3 <input type="checkbox"/> CL4 <input type="checkbox"/>	Weld Pro.	ISO 13920	A <input checked="" type="checkbox"/> B <input type="checkbox"/> E <input checked="" type="checkbox"/> F <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						
		Flange complete			EM20.04.03.20025		
	Date:06/07/2018				Sheet:1/1	Size:A2	Rev:01