



ISO 13920 Welded Construction	<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
ISO 2768 General Tolerance	<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
TS 12708 Steel Casting	<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	
	>20000	9,0	8,0

Technical Specifications				
Technical Document No.	R03	2 poz no'lu parçanın detay resmi güncellenmiştir.		
Fixture/Mould Asset ID.	R02	UPDATED WELDING		
Coating/Heat Tre./Roughness	R01	UPDATED WELDING		
Paint/Color	Mod. No	Modification Description		

GENERAL WELDING REQUIREMENTS

Welding classification and controlling according to technical specification BLUE_TS_WLD_01

WELDING PERFORMANCE CLASS

C1

2	PLATE	1	EM20.24.03.20003	S355J2 EN 10025	--	6.1	
1	PIPE	1	EM20.24.03.20002	S355J2H EN 10210	--	2.5	
Item No	Designation Name of Item	Qty.	Standard Identification No Company	Material Company Code	Dimension	Weight (Kg)	
TYP	ISO 21920-1	ISO 8015	ISO 2553	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 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"/>	Cast Steel	TS 12708	Lm2 <input type="checkbox"/> Lr2 <input type="checkbox"/> Sm2 <input type="checkbox"/> Sr2 <input type="checkbox"/>	
	Approved	P.FARINA		Scale	<div><div>TURASAS</div><div>Turkish Railway Vehicles Industry Inc.</div></div>		
	Checked	M.BORLO		1 : 2			
	Prepared	E.PINTUS					
		Lower Motor Support			EM20.24.03.20001		
	Date:	Parts List No:			Sheet: 1/1	Size:A3	Rev:03