

### GENERAL WELDING REQUIREMENTS

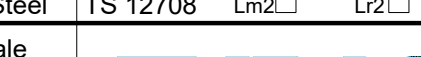
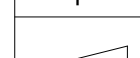
Welding classification and controlling according to technical specification BLUE\_TS\_WLD\_01

WELDING PERFORMANCE CLASS

C3

Technical Specifications					
Technical Document					
Fixture/Mould Asset ID.		R02	Resim güncellenmiştir.	22/07/2024	T.ŞABA
Coating/Heat Tre./Roughness		R01	UPDATED WELDING	02/07/2018	S.Ponzo
Paint/Color		Modif. No	Modification Description	Date	Sign

5	Plate	1	EM20.24.03.20012	S355J2 EN 10025		1.5
4	Plate	1	EM20.24.03.20011	S355J2 EN 10025		2.6
3	Plate	2	EM20.24.03.20010	S355J2 EN 10025		0.3
2	Plate	1	EM20.24.03.20009	S355J2 EN 10025		1.5
1	Plate	1	EM20.24.03.20008	S355J2 EN 10025		5.3
						11.4

Item No	Designation Name of Item		Qty.	Standard Identification No Company	Material Company Code	Dimension		Weight ( Kg )	
	ISO 21920-1	ISO 8015	ISO 2553	General Tol.	ISO 2768	f <input type="checkbox"/>	m(X) <input type="checkbox"/>	H <input type="checkbox"/>	K(X) <input type="checkbox"/>
	EN 15085-2 Certification Level			CL1 <input type="checkbox"/> CL2 <input type="checkbox"/>	Weld Pro.	ISO 13920	A(X) <input checked="" type="checkbox"/>	B <input type="checkbox"/>	E(X) <input 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><b>TURASAS</b> Turkish Railway Vehicles Industry Inc.</div>			
	Checked	M.Borlo		1 : 2					
	Prepared	Marco Eid							
		Shock Absorber Support			EM20.24.03.20007				
TYP	Date:	Parts List No:			Sheet: 1/1		Size: A1	Rev: 02	

Nom. Size	Class
<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	Ham. Isp.
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