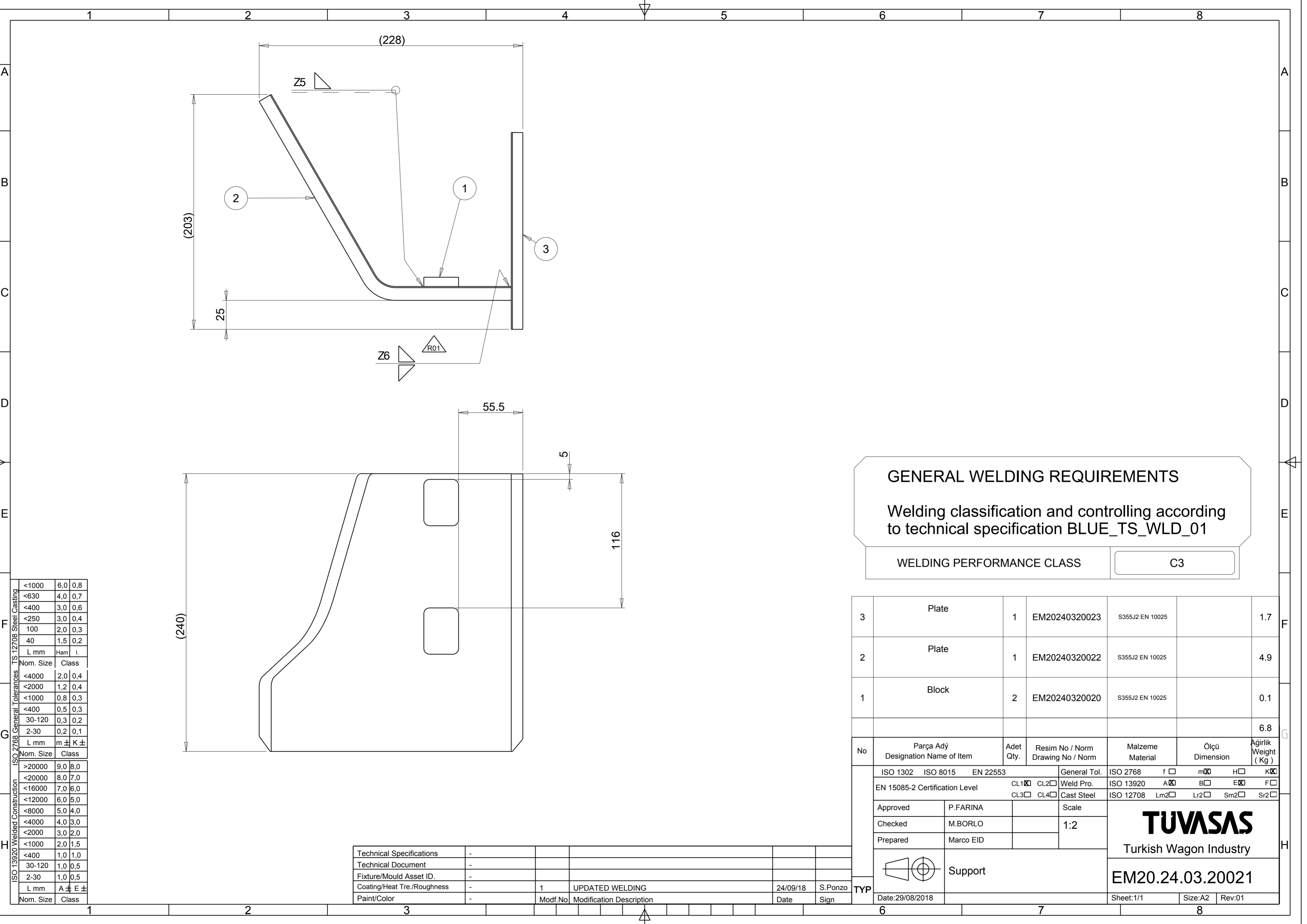


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ISO 12708 Steel Casting	<1000	6.0	0.8
	<630	4.0	0.7
	<400	3.0	0.6
	<250	3.0	0.4
ISO 2708 General Tolerances	100	2.0	0.3
	40	1.5	0.2
	L mm	Ham	L
	Nom. Size	Class	
ISO 13920 Welded Construction	<4000	2.0	0.4
	<2000	1.2	0.4
	<1000	0.8	0.3
	<400	0.5	0.3
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

Technical Specifications	-				
Technical Document	-				
Fixture/Mould Asset ID.	-				
Coating/Heat Tre./Roughness	-	1	UPDATED WELDING	24/09/18	S.Ponzo
Paint/Color	-	Modf.No	Modification Description	Date	Sign

GENERAL WELDING REQUIREMENTS

Welding classification and controlling according to technical specification BLUE_TS_WLD_01

WELDING PERFORMANCE CLASS

C3

3	Plate	1	EM20240320023	S355J2 EN 10025		1.7
2	Plate	1	EM20240320022	S355J2 EN 10025		4.9
1	Block	2	EM20240320020	S355J2 EN 10025		0.1
						6.8

No	Parça Ady 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			Weld Pro.	ISO 13920 A <input checked="" type="checkbox"/> B <input type="checkbox"/> E <input checked="" type="checkbox"/> F <input type="checkbox"/>	
	CL1 <input checked="" type="checkbox"/> CL2 <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> <div>EM20.24.03.20021</div>	
Checked		M.BORLO		1:2		
Prepared		Marco EID				
		Support				
Date:29/08/2018				Sheet:1/1	Size:A2	Rev:01