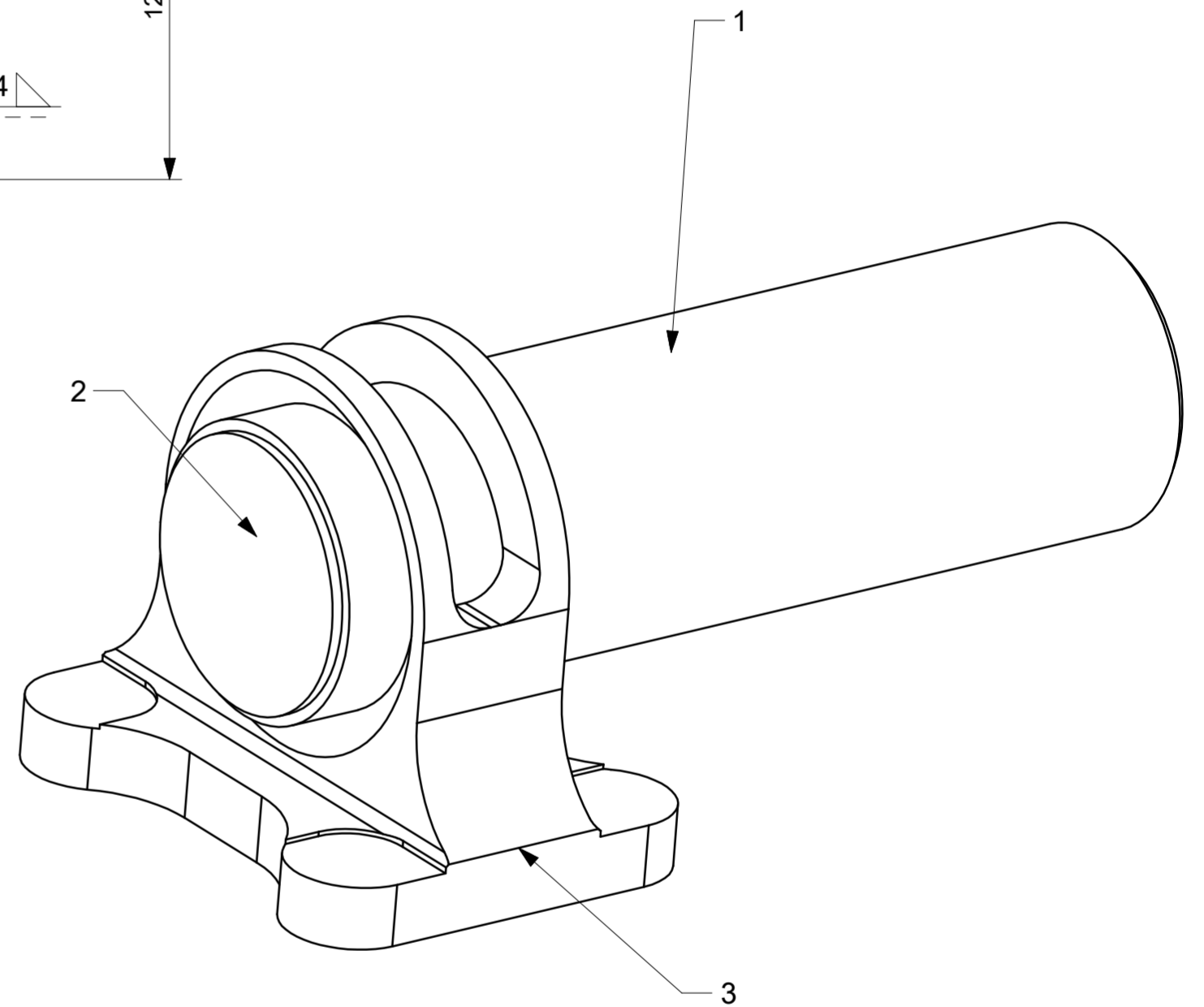
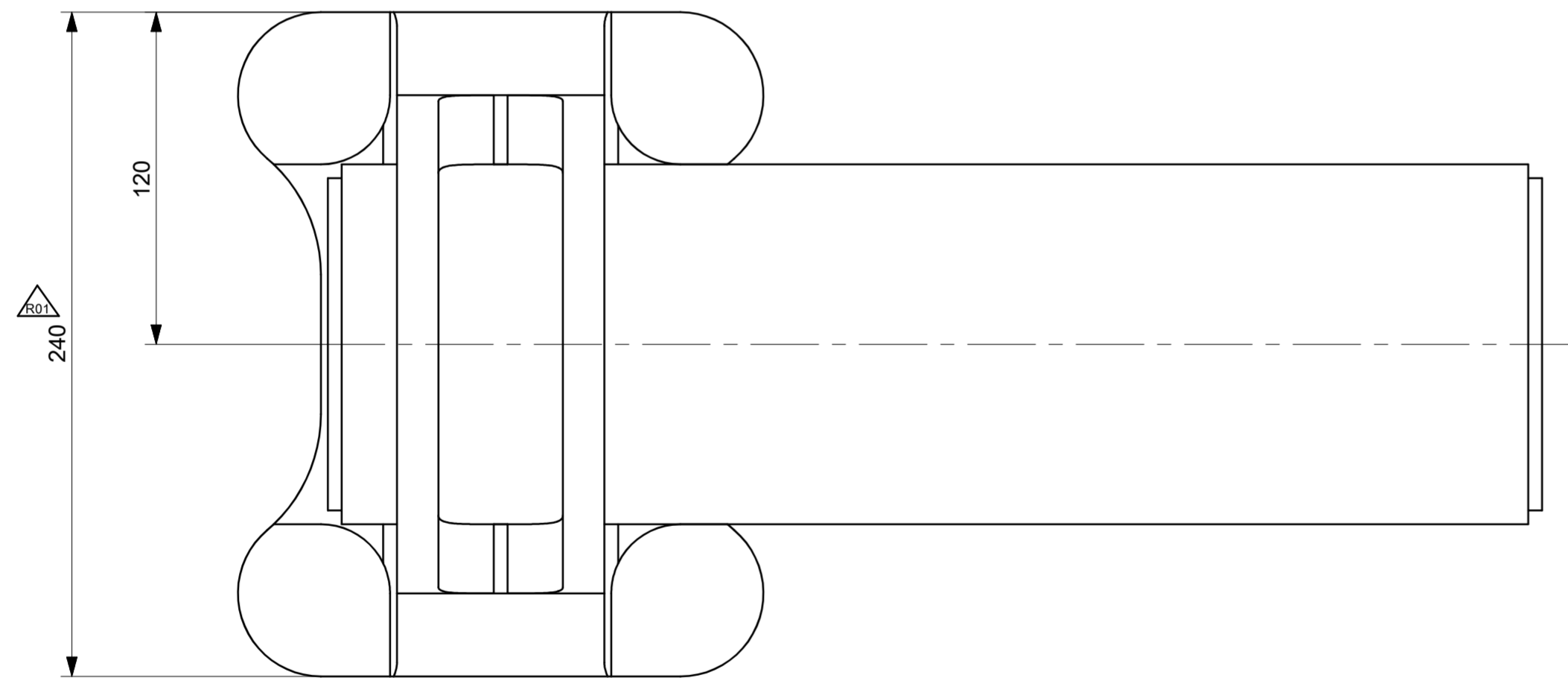
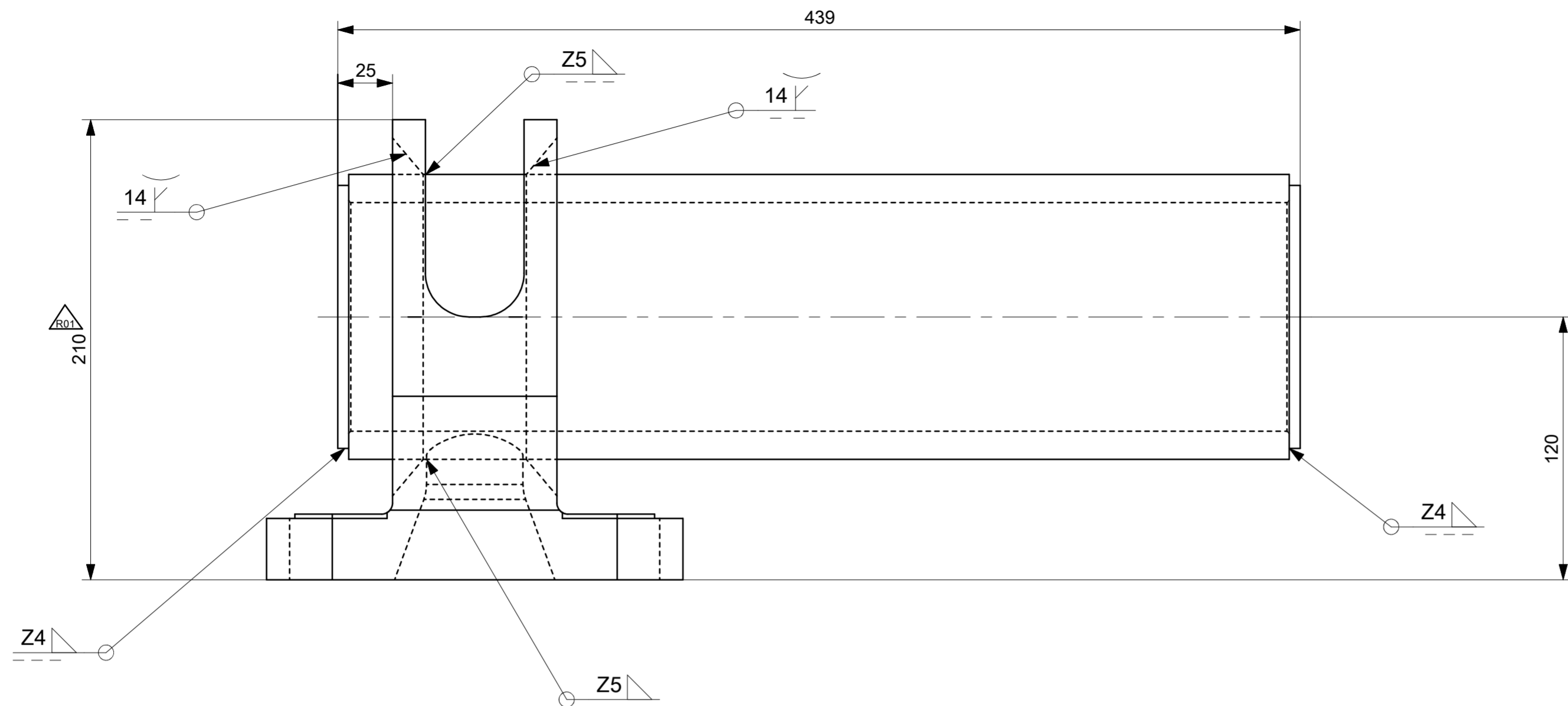


ISO 13920 Welded Construction	ISO 2768 General Tolerances	S 12708 Steel Casting
<1000	6.0	0.8
<630	4.0	0.7
<400	3.0	0.6
<250	3.0	0.4
100	2.0	0.3
40	1.5	0.2
L mm	Ham	Isl
Nom. Size	Class	
<4000	2.0	0.4
<2000	1.2	0.4
<1000	0.8	0.3
<400	0.5	0.3
30-120	0.3	0.2
2-30	0.2	0.1
L mm	m ±	K ±
Nom. Size	Class	
>20000	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	




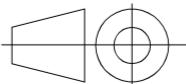
GENERAL WELDING REQUIREMENTS

Welding classification and controlling according to technical specification BLUE_TS_WLD_01

WELDING PERFORMANCE CLASS

C1

Technical Specifications					
Technical Document					
Fixture/Mould Asset ID.					
Coating/Heat Tre./Roughness		R01	Resim güncellenmiştir.	22/07/2024	T.ŞABA
Paint/Color		Modf. No	Modification Description	Date	Sign

3	Brake calliper support	1	EM20.24.03.20032	S355J2 EN 10025		12.3
2	Plug	2	EM20.24.03.20031	S355J2 EN 10025		0.4
1	Pipe	1	EM20.24.03.20029	S355J2H EN 10210		16.0
						29.2
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 <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 Pro.	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><p>TURASAS</p><p>Turkish Railway Vehicles Industry Inc.</p></div>		
	Checked	M.BORLO	1 : 2			
	Prepared	E.PINTUS				
		Brake Support				
TYP	Date:	Parts List No:		Sheet: 1/1	Size: A2	Rev: 01