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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 2768 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	Nom. Size	Class	

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	

2	Block	1	EM20240320045	S355J2 EN 10025		1.2
1	Plate	1	EM20240320044	S355J2 EN 10025		2.2
						3.4
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"/>
	Approved	P.FARINA		Scale	ISO 12708	Lm2 <input type="checkbox"/> Lr2 <input type="checkbox"/> Sm2 <input type="checkbox"/> Sr2 <input type="checkbox"/>
	Checked	M.BORLO		1:1		
	Prepared	E.PINTUS				
	Tie Rod Seat					
	Date:01/06/2018				Sheet:1/1	Size:A2 Rev:01

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Turkish Wagon Industry

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