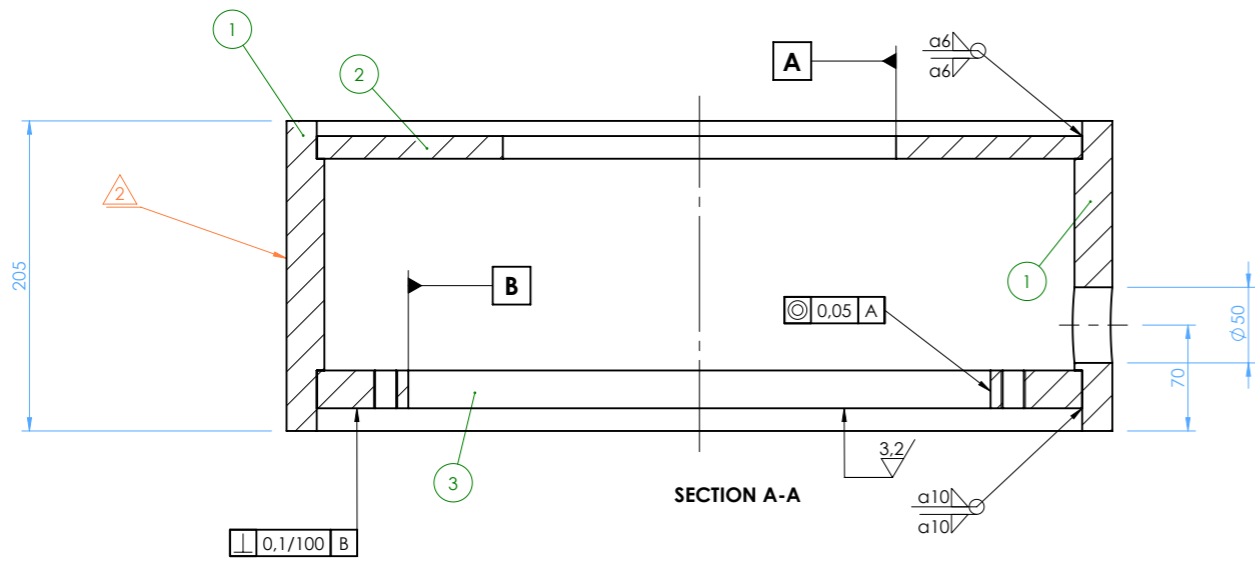


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GENERAL TOLERANCES:
 FOR DIMENSIONS WITHOUT TOLERANCES, TOLERANCE CLASS-
 LASER CUTTING: DIN EN ISO 9013-1
 ANGULAR DIMENSIONS: DIN EN ISO 2768 m
 RADIUS OF FILLETS, HEIGHT OF CHAMFERS: DIN EN ISO 2768 m
 STRAIGHTNESS, PLANARITY: DIN EN ISO 2768 m
 FORM & POSITION: DIN EN ISO 2768 m

FOR WELDMENTS, TOLERANCE CLASS-
 LENGTHS AND ANGULAR DIMENSIONS: DIN ISO 13920 B

WELDING INSTRUCTION FOR THE INTERCONNECTION OF S235JR TO S235JR OR S275JR/S355J2G3
 WELDING METHOD MAG M
 -WIRE ELECTRODE DIN EN 440-G3 SI 1
 -INERT GAS DIN EN 439 - M2

WELDING METHOD E
 -STICK ELECTRODE DIN EN 499 - E 38 2 B12 H10

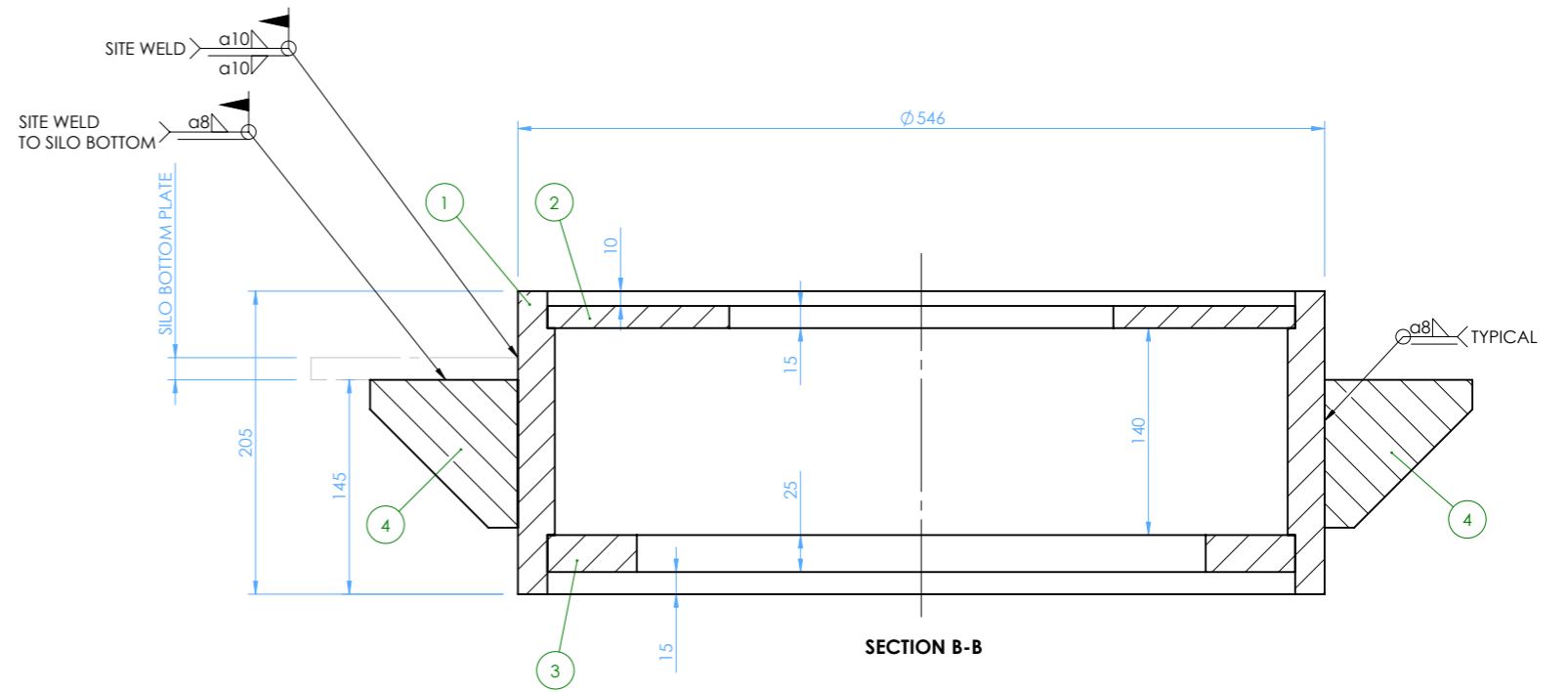
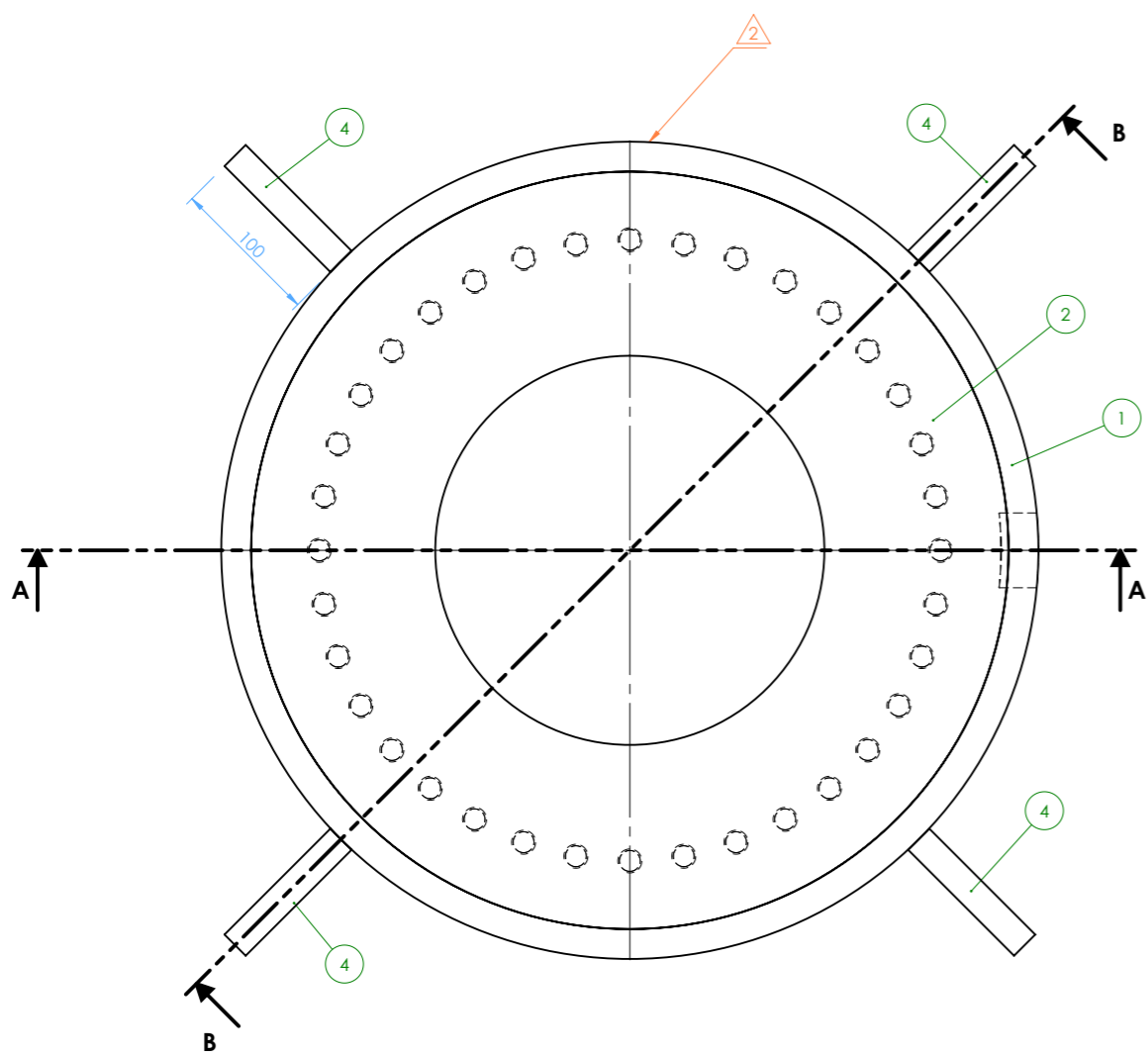
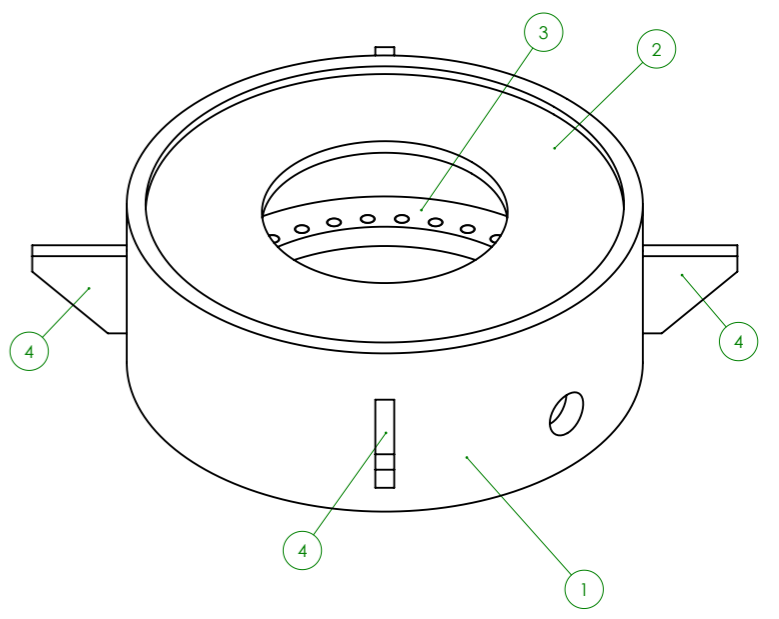
EVALUATION GROUP C IN ACC. WITH ISO 5817 (DIN EN 25817)
 INCLUDING THE FOLLOWING RESTRICTIONS:
 - RETURN LAP H < 0,1 X T MIN (MAX 2mm)
 - PENETRATION NOTCH H < 0,5 mm

ALL WELDED CONNECTIONS WITHOUT WELDING INFORMATION
 -FILLET SEAM 0,7 X T MIN
 -DOUBLE FILLET SEAM 0,5 X T MIN

EXECUT OF COATING AS SPECIFIED IN ACC. WITH DIN 28053

PREPARATION OF WELDED SEAMS IN ACC. WITH ISO 9682 (DIN EN 29692)
 NO CROSS SEAMS ON THE BEAMS!

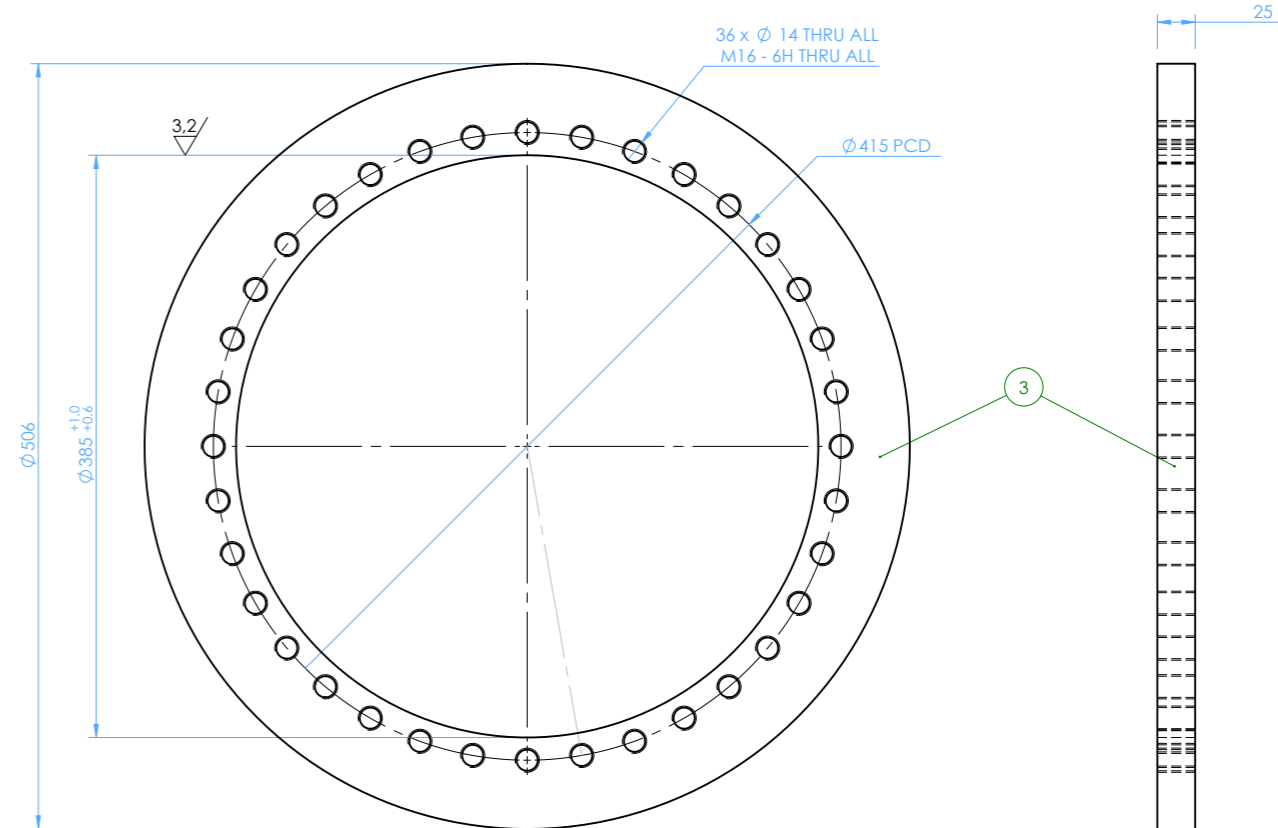
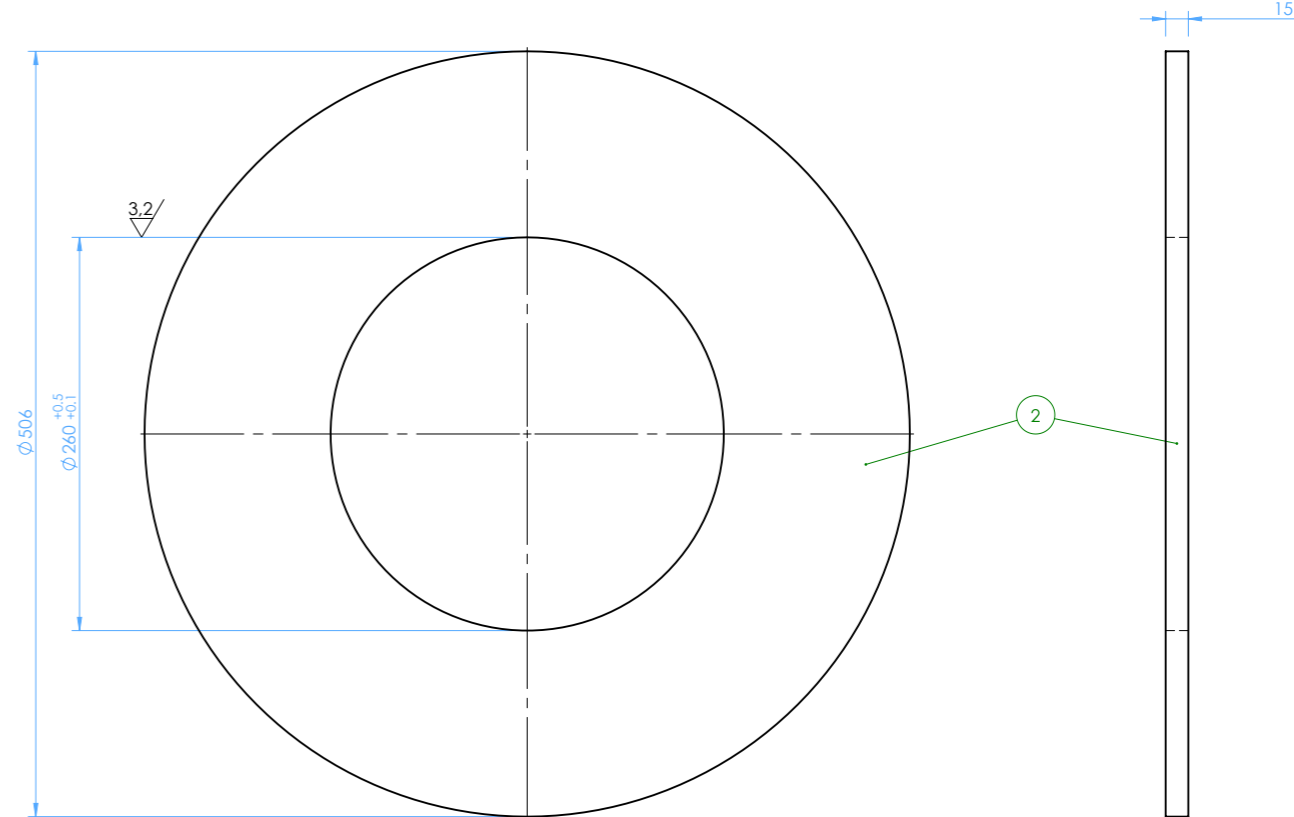
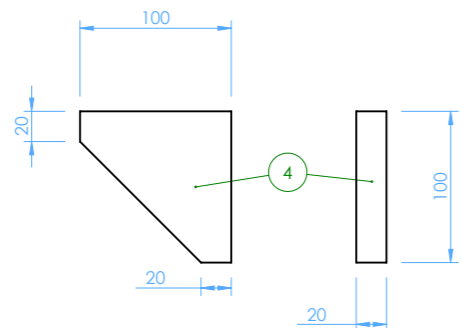
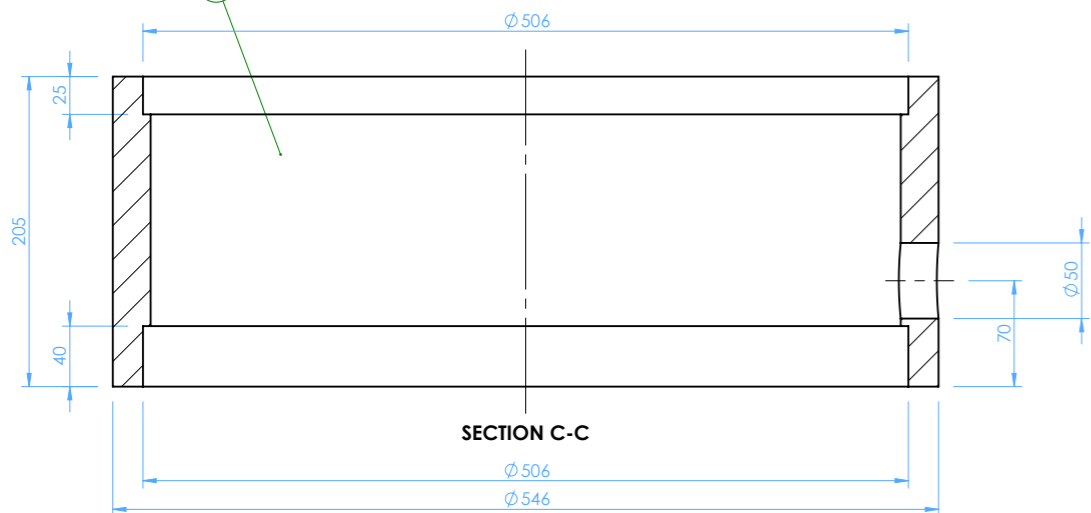
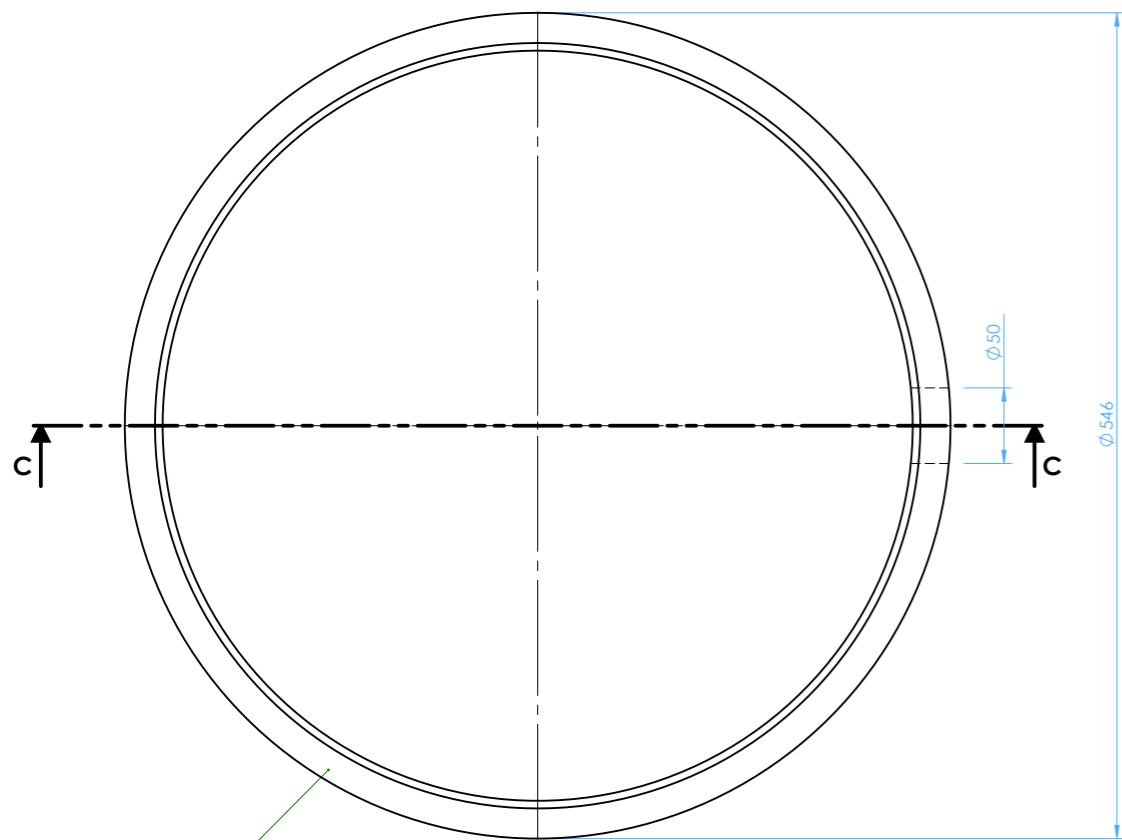
POS.	QTY.	DESCRIPTION	WEIGHT	PART NO.	MATERIAL	COMMENT
1	1	ROHR Ø546 x 25, 205 LG	61		1.0037 (S235JR)	
2	1	PLATE 15 x Ø506	17		1.0037 (S235JR)	
3	1	PLATE 25 x Ø506	15		1.0037 (S235JR)	
4	4	PLATE 20 X 100 X 100	1		1.0037 (S235JR)	



PAINTING:
 REFER TO PROJECT SPEC SHEET OR ORDER FOR PAINTING INFORMATION AND COLOUR

Status	Preparation	Material	Weight	Number	Rev	Modification	Date	By	A3 SHEET
<input type="checkbox"/> Preliminary	<input checked="" type="checkbox"/> Final	1.0037 (S235JR)	98 Kg	SX-STD-438	2	SMALL GUSSETS REMOVED	27/10/2021	BC	1 OF 2
<input type="checkbox"/> As-built	<input type="checkbox"/> For Information				1	LUGS MOVED - NG & BC	30/04/2020	BC	
<input type="checkbox"/> For Quotation	<input type="checkbox"/> Released for Structural Calculation				0	FIRST RELEASED.	24/01/2019	BC	
<input type="checkbox"/> Released for Detail Design	<input type="checkbox"/> Released for Civil Design								
<input checked="" type="checkbox"/> Released for Construction									

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 FORM & POSITION: DIN EN ISO 2768 m

FOR WELDMENTS, TOLERANCE CLASS-
 LENGTHS AND ANGULAR DIMENSIONS: DIN ISO 13920 B

REFER TO SHEET 1 FOR BOM

<input type="checkbox"/> Preliminary <input checked="" type="checkbox"/> Final <input type="checkbox"/> As-built				undimensioned tolerances for welded constructions i.a.w. EN ISO 13920 - BF		SCALE: 1:5 @ A3		Sellhoner Weg 28 29646 Bispingen Tel. 05194 4180901 www.saxwerk.de			
Purpose <input type="checkbox"/> For Information <input type="checkbox"/> For Quotation <input type="checkbox"/> Released for Structural Calculation <input type="checkbox"/> Released for Detail Design <input type="checkbox"/> Released for Civil Design <input checked="" type="checkbox"/> Released for Construction		2 SMALL GUSSETS REMOVED 1 LUGS MOVED SH1 - NG & BC 0 FIRST RELEASED.		27/10/2021 BC 30/04/2020 BC 24/01/2019 BC		2018 date name draw. 24/01/2019 BC contr. 24/01/2019 CG Material: 1.0037 (S235JR) Weight: 98 Kg Number: SX-STD-438		CLIENT: SAXWERK PROJECT: HYD ROTOR Description: GEARBOX MOUNT 313 WELDMENT		A3 SHEET: 2 OF 2	