

GENERAL REQUIREMENTS ON WELDING TIME

Visible quality criteria must be met, as in EN ISO 5817, Part 3:

- (a) all butt and joints according to EN ISO 5817, Part 3
- (b) all fillet welds according to EN ISO 5817, Part 3
- (c) all butt welds for complete penetration in EN ISO 5817, Part 3
- (d) all butt welds for complete penetration in EN ISO 5817, Part 3

The certificate issued by the shop must contain the requirements that are specified.

GENERAL REQUIREMENTS ON MATERIAL QUALITY

Materials with mechanical properties greater than 500 MPa must be checked to ensure that the required properties are maintained throughout the welding process.

Requirements for steel fabrication and welding materials are given in EN ISO 5817, Part 3.

GENERAL REQUIREMENTS ON PARTICULATE EMISSION

(a) all visible signs of dust must be removed from the time of grinding or grinding.

(b) the welding time category procedure must ensure that the dust emission is reduced to the required level.

(c) if the grinding process is used in a shop, the grinding must be done in a way that ensures that the dust emission is reduced to the required level.

(d) all welding materials must be stored in a way that ensures that the dust emission is reduced to the required level.

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(k) all welding materials must be stored in a way that ensures that the dust emission is reduced to the required level.

(l) all welding materials must be stored in a way that ensures that the dust emission is reduced to the required level.

(m) all welding materials must be stored in a way that ensures that the dust emission is reduced to the required level.

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(r) all welding materials must be stored in a way that ensures that the dust emission is reduced to the required level.

(s) all welding materials must be stored in a way that ensures that the dust emission is reduced to the required level.

(t) all welding materials must be stored in a way that ensures that the dust emission is reduced to the required level.

(u) all welding materials must be stored in a way that ensures that the dust emission is reduced to the required level.

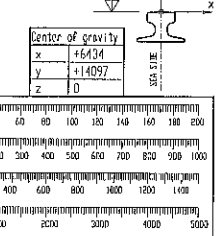
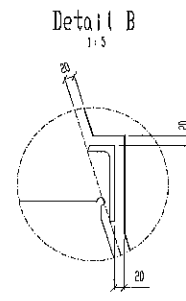
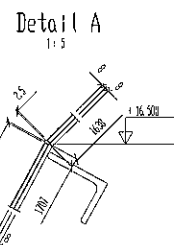
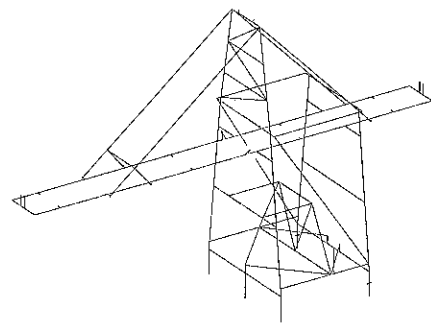
(v) all welding materials must be stored in a way that ensures that the dust emission is reduced to the required level.


(w) all welding materials must be stored in a way that ensures that the dust emission is reduced to the required level.

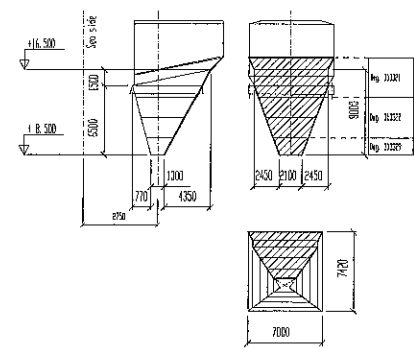
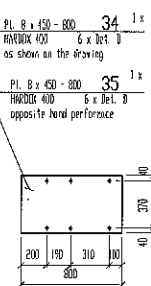
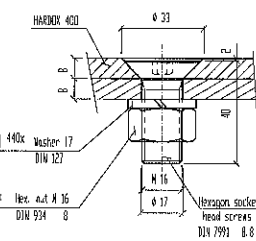
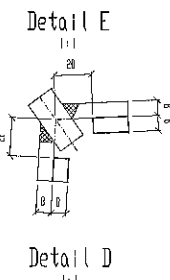
(x) all welding materials must be stored in a way that ensures that the dust emission is reduced to the required level.

(y) all welding materials must be stored in a way that ensures that the dust emission is reduced to the required level.

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DIMENSIONAL TOLERANCES unless otherwise specified												Surfaces in in.	
Max. d. minimum in.	0.1 to 0.2	over 0.2 to 0.5	over 0.5 to 1.0	over 1.0 to 2.0	over 2.0 to 4.0	over 4.0 to 10	over 10 to 16	over 16 to 32	over 32 to 64	over 64 to 128	over 128 to 256	over 256 to 512	over 512 to 1024
Applicable		Free tolerance	±.005	±.003	±.002	±.0015	±.001	±.0007	±.0005	±.0003	±.0002	±.0001	±.00005
		Free tolerance	±.001	±.0005	±.0003	±.0002	±.0001	±.00005	±.00003	±.00002	±.00001	±.000005	±.000002
Not applicable			±.002	±.001	±.0005	±.0003	±.0002	±.0001	±.00005	±.00003	±.00002	±.00001	±.000005



RELEASED FOR MANUFACTURING			
Date			
Signed			
Released for detail design			
Date	-		
Signed	-		
Dr	Size	Scale	1:25, 100x150
S	BIP	Material	4800C: 403
S	BIP	Ways	3507.7 kg
Sheet 1 of 1			Size
31 326 800			A 0