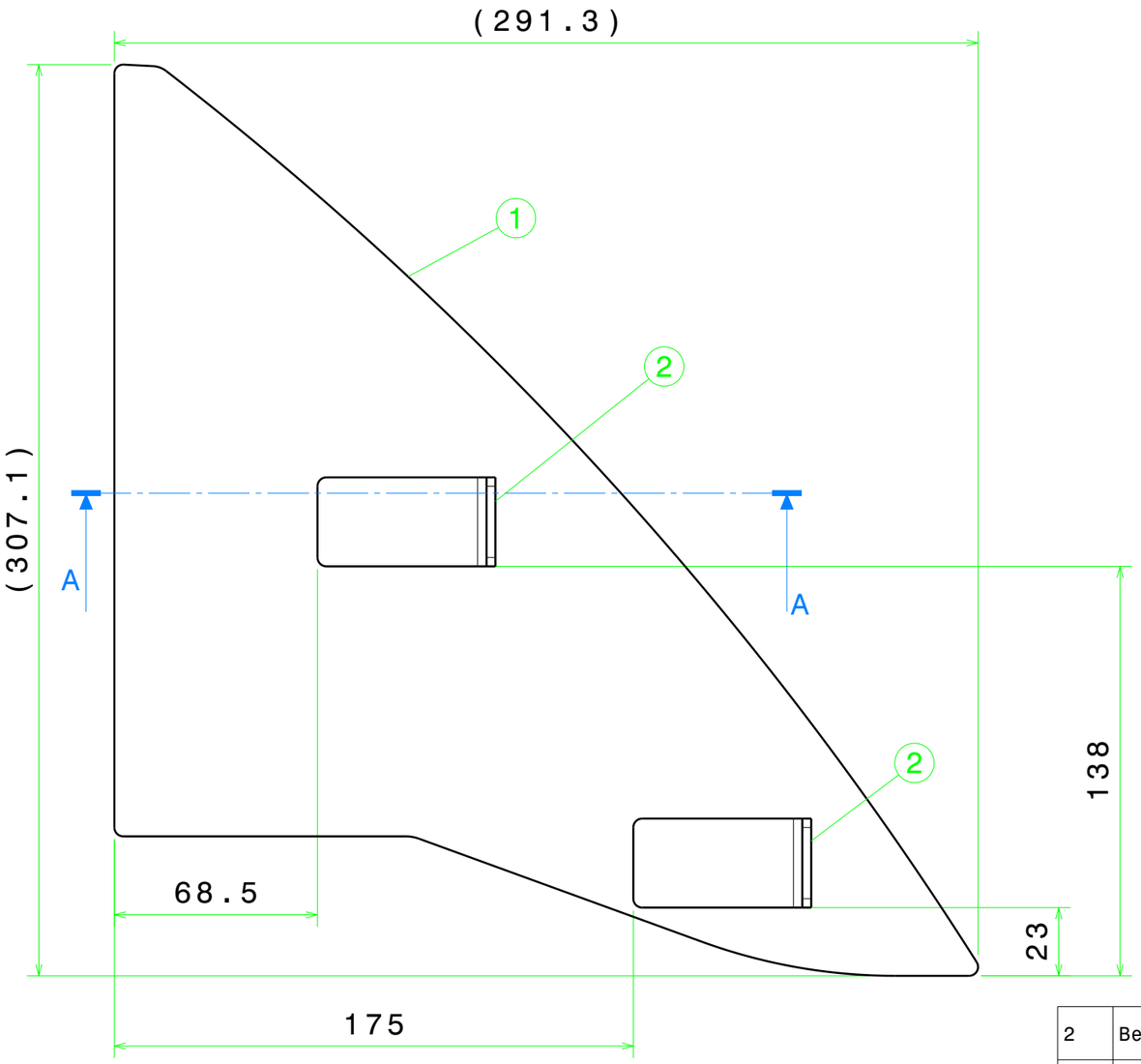
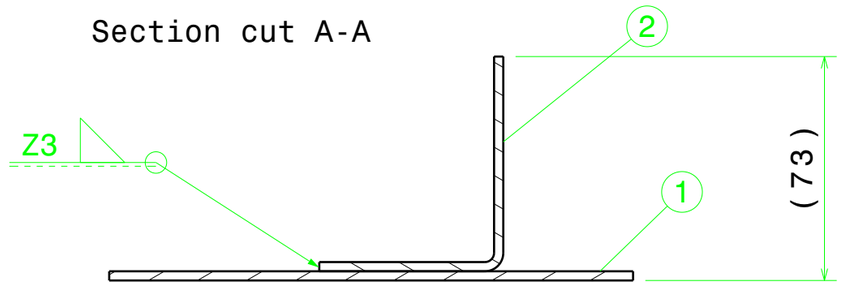
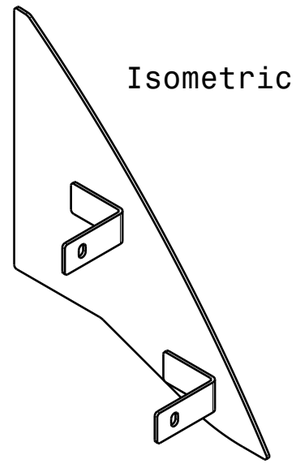


Section cut A-A



Isometric view



Painting in accordance with TD-GZ.10.0055
-Protect from painting all threaded holes and machined surfaces marked with ◯
-Protect only with primer all surfaces marked with ◎

No	Parça Adý Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension	Aðýrlýk Weight (Kg)
2	Bending_Sheet	2	GZ10.21.11.31002	S355J2 EN10025	-	0,086 kg
1	Plate	1	GZ10.21.11.31001	S355J2 EN10025	-	1,054 kg
						1,2

GENERAL WELDING REQUIREMENTS

Welding classification and controlling according to technical specification BLUE_TS_WLD_01

WELDING PERFORMANCE CLASS	CP C2

ISO 21920-1	ISO 8015	ISO 2553	General Tol.	ISO 2768	f ☐	m[X]	H☐	K[X]
EN 15085-2 Certification Level	CL1[X] CL2☐ CL3☐		Weld Pro.	ISO 13920	A[X]	B☐	E[X]	F☐
			Cast Steel	ISO 12708	Lm2☐	Lr2☐	Sm2☐	Sr2☐

Approved	L.Giovinazzo	18/01/2023	Scale 1:2
Checked	M.Borlo	18/01/2023	
Prepared	M.Cojocaru	18/01/2023	

TÜRASAŞ
Turkish Railway Vehicles Industry Inc.

Welded Assembly

-

GZ10.21.11.31000

TYP

Date: 18/01/2023 | Sheet : 1/1 | Size:A3 | Rev: 00

Technical Specifications					
Technical Document					
Fixture/Mould Asset ID.					
Coating/Heat Tre./Roughness					
Paint/Color		Modf. No	Modification Description	Date	Sign

ISO 13920 Welded Construction	<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	Ýpl.
	Nom. Size	Class	

ISO 2768 General Tolerances TS 12708 Steel Casting	<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	

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