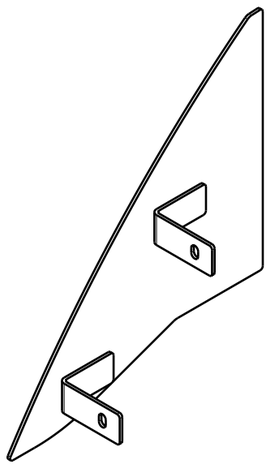
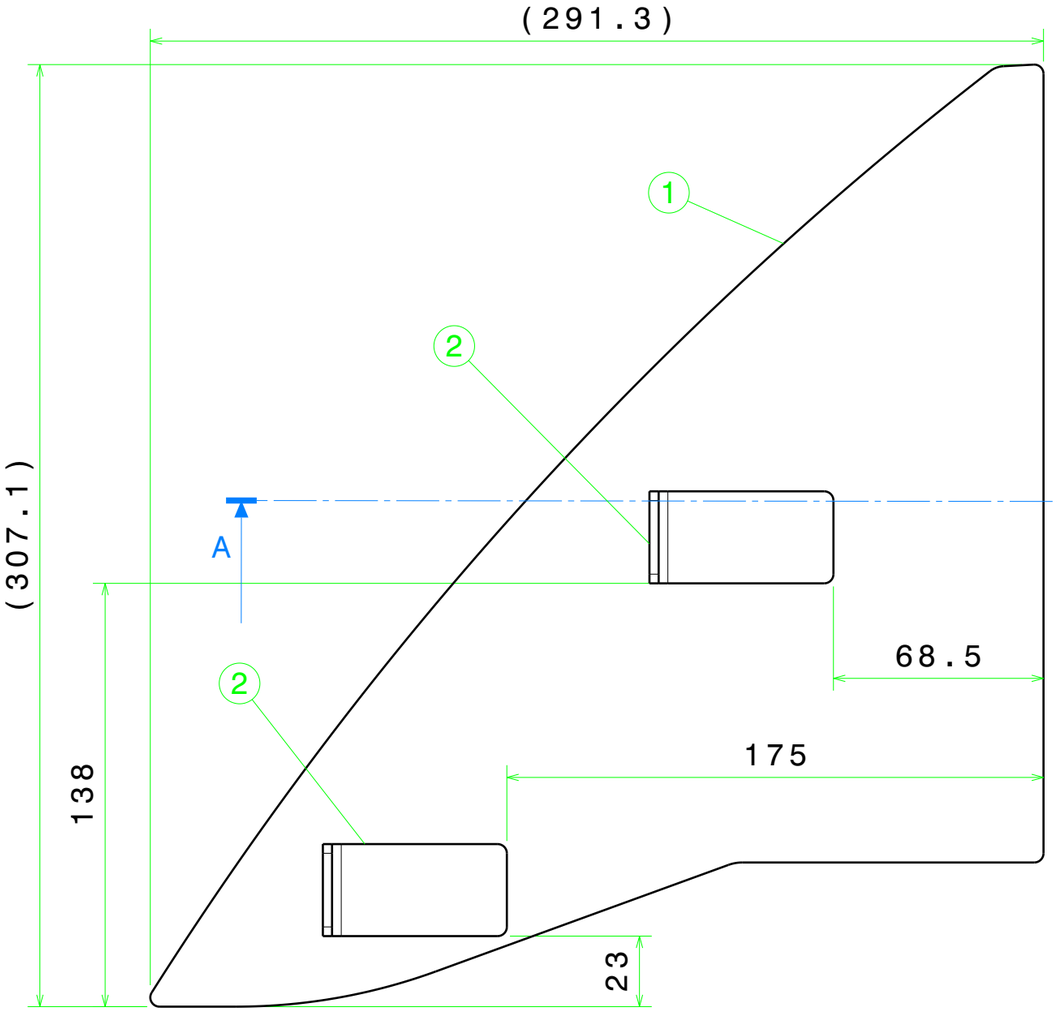
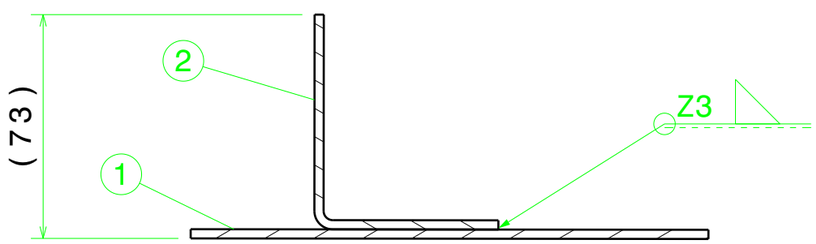
Isometric view





Section cut A-A



ISO 13920 Welded Construction ISO 2768 General Tolerances TS 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	Ýpl.
	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	

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	TÜRASAS Turkish Railway Vehicles Industry Inc.						
Checked	M.Borlo	18/01/2023	1:2							
Prepared	M.Cojocaru	18/01/2023								
TYP	Welded_Assembly -			GZ10.21.11.36000						
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

Reproduction, dissemination or use of this document or its all contents in any form without the prior written permission of TUVASAS, is prohibited. Offenders will be liable for the payment of damages. All rights reserved in the event of the grant of a patent, utility model or ornamental design registration.