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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	Ypl.	
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		

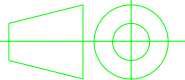
Technical Specifications					
Technical Document					
Fixture/Mould Asset ID.					
Coating/Heat Tre./Roughness					
Paint/Color		Modf. No	Modification Description	Date	Sign

GENERAL WELDING REQUIREMENTS

Welding classification and controlling according to technical specification BLUE_TS_WLD_01

WELDING PERFORMANCE CLASS	CP C2
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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 ◎

3	Welded_Assembly	1	GZ10.21.12.94000	-	-	0,77kg
2	Welded_Assembly	1	GZ10.21.12.91000	-	-	0,77kg
1	Bending_Sheet	1	GZ10.21.12.97001	S355J2 EN10025	-	0,311kg
						1,9
No	Parça Adý Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension	Aðýrlýk Weight (Kg)
TYP	ISO 21920-1	ISO 8015	ISO 2553	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"/>	Weld Pro.	ISO 13920	A <input checked="" type="checkbox"/> B <input type="checkbox"/> E <input checked="" type="checkbox"/> F <input type="checkbox"/>
				Cast Steel	ISO 12708	Lm2 <input type="checkbox"/> Lr2 <input type="checkbox"/> Sm2 <input type="checkbox"/> Sr2 <input type="checkbox"/>
	Approved	L.Giovinazzo	31/01/2023	Scale	<div><div>TURASAS</div><div>Turkish Railway Vehicles Industry Inc.</div></div>	
	Checked	M.Borlo	31/01/2023	1:2		
	Prepared	M.Cojocar	31/01/2023			
	Welded_Assembly			GZ10.21.12.97000		
	-					
Date:31/01/2023				Sheet : 1/1	Size:A3	Rev: 00