

ISO 13920 Welded Construction	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	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		

Painting in accordance with TD-GZ.10.0055

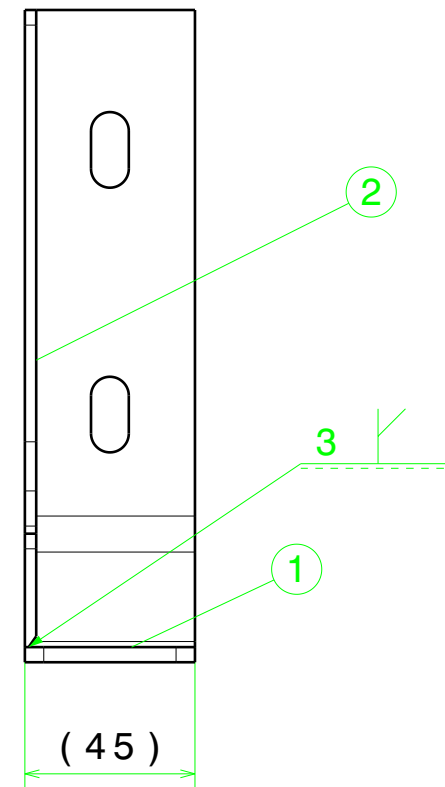
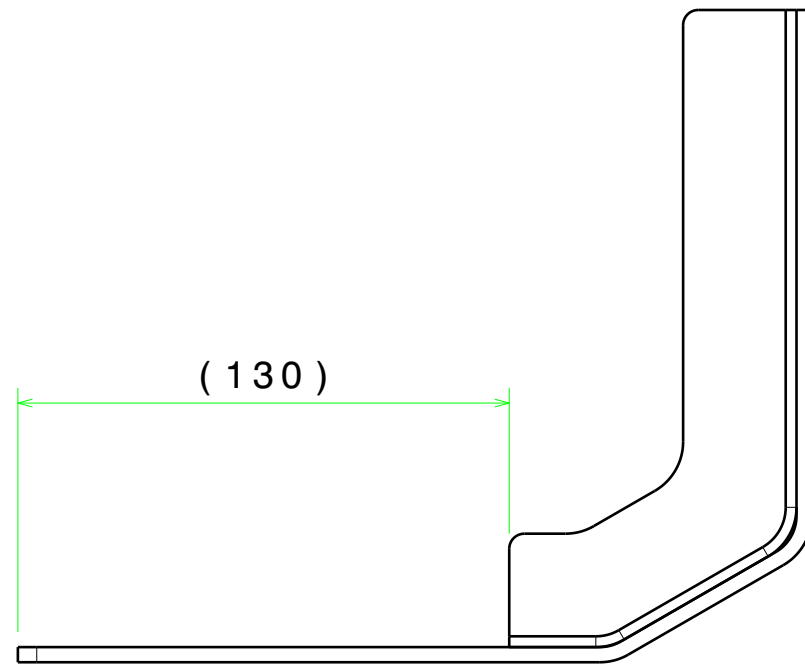
- Protect from painting all threaded holes and machined surfaces marked with ○
- Protect only with primer all surfaces marked

## GENERAL WELDING REQUIREMENTS

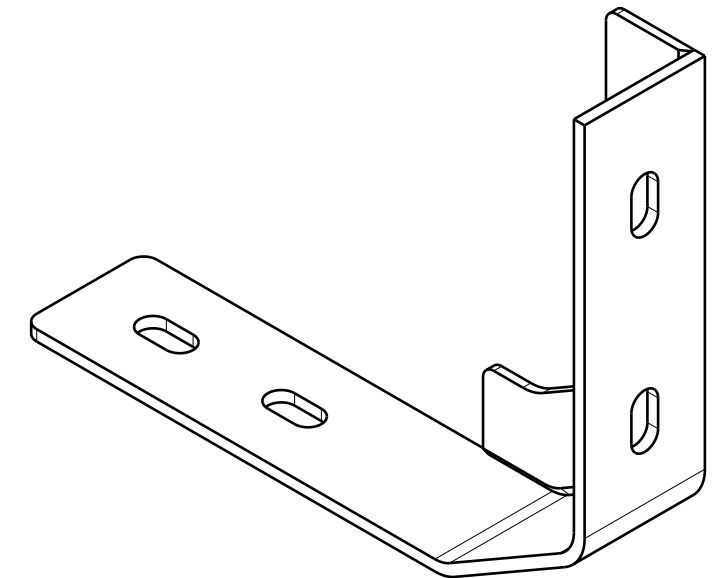
Welding classification and controlling according  
to technical specification BLUE\_TS\_WLD\_01


## WELDING PERFORMANCE CLASS


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





Isometric view



2	Plate	1	GZ10.21.12.96002	S355J2 EN10025	-	0,135 kg
1	Bending_Sheet	1	GZ10.21.12.96001	S355J2 EN10025	-	0,481 kg
						0,6
No	Parça Adý Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension	Aðýrlyk 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	25/01/2023	Scale	<div>TURASAS</div> <div>Turkish Railway Vehicles Industry Inc.</div>	
	Checked	M.Borlo	25/01/2023	1:2		
	Prepared	M.Cojocar	25/01/2023			
			Welded_Assembly		GZ10.21.12.98000	
		-				
Date:25/01/2023				Sheet : 1/1	Size:A3	Rev: 00

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