



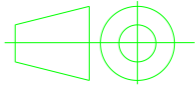
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ISO 13920 Welder Construction		
Nom. Size	Class	
<1000	6,0	0,8
<630	4,0	0,7
<400	3,0	0,6
<250	3,0	0,4
100	2,0	0,3
40	1,5	0,2
L mm	Ham	Ypl.
ISO 2768 General Tolerances		
Nom. Size	Class	
<4000	2,0	0,4
<2000	1,2	0,4
<1000	0,8	0,3
<400	0,5	0,3
30-120	0,3	0,2
2-30	0,2	0,1
L mm	m	K ±
ISO 13920 Welder Construction		
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					
Modif. 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

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 

6	Block	3	GZ10.07.07.10005	X5CrNi 18-10 EN10088	-	0,05kg			
5	Tube	2	GZ10.07.07.10004	S355J2H EN10210	-	0,17kg			
4	Tube	3	GZ10.07.07.10003	S355J2H EN10210	-	1,66kg			
3	Tube	6	GZ10.07.07.10002	S355J2H EN10210	-	1,91kg			
2	Tube	12	GZ10.07.07.10001	S355J2H EN10210	-	0,81kg			
1	Subframe	1	GZ10.07.07.11000	-	-	22,09kg			
						48,7			
No	Parça Adı Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension	Ağırlık Weight (Kg)			
	ISO 21920-1	ISO 8015	ISO 2553	General Tol.	ISO 2768	f	mX	H	KX
	EN 15085-2 Certification Level	CL1X	CL2	Weld Pro.	ISO 13920	A	B	E	F
		CL3		Cast Steel	ISO 12708	Ln2	Lr2	Sm2	Sr2
	Approved	L.Giovinazzo	23/05/2023	Scale	<div>TURASAS</div> <div>Turkish Railway Vehicles Industry Inc.</div>				
	Checked	M.Borio	23/05/2023	1:5					
	Prepared	E.Croce	23/05/2023						
		AntennaS_(TCMS_PAPIS_ETCS)_Frame							
TYP	Date: 23/05/2023	-			Sheet: 1/1	Size: A1	Rev: 00		