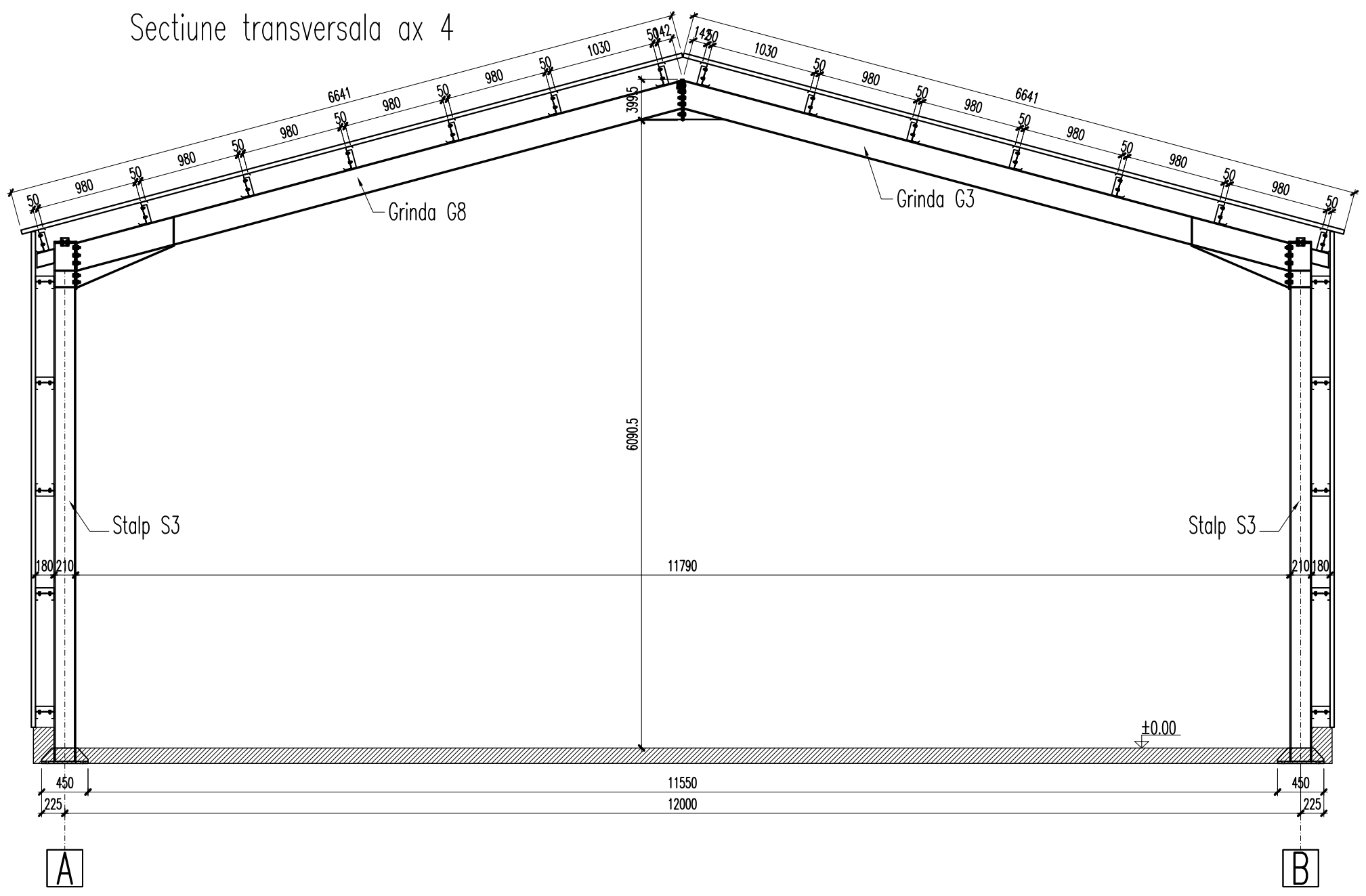
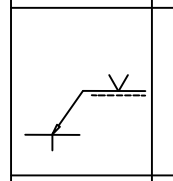
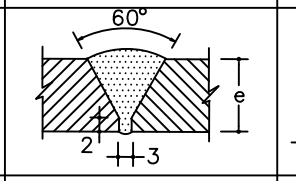
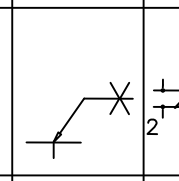
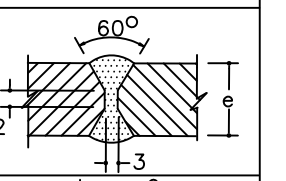
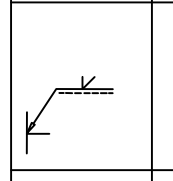
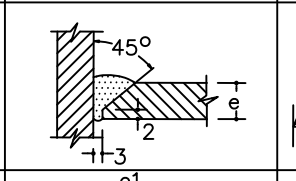
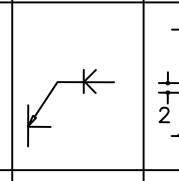
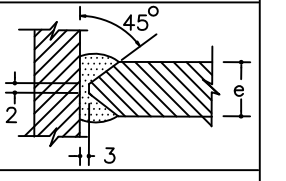
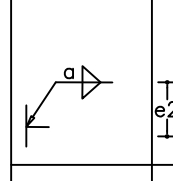
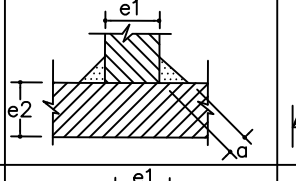
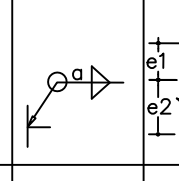
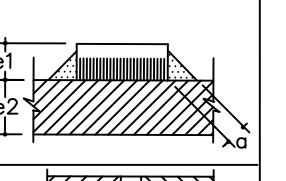
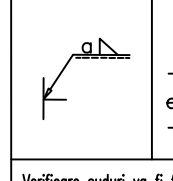
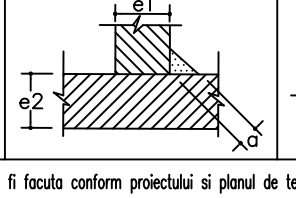
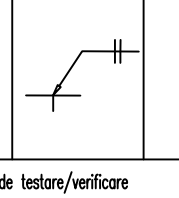
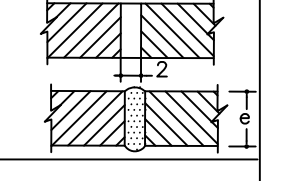
Sectiune transversala ax 4



DETALII GENARALE DE SUDURA
GENERAL WELDING DETAILS

Fabrica Factory	Detaliu Detail	Fabrica Factory	Detaliu Detail
			
			
			
			

Verificare suduri va fi facuta conform proiectului si planul de testare/verificare

Simbolurile de sudura sunt in conformitate cu standardele EN ISO 2553

Design-ul, pregatirea, executia si controlul sunt definite in functie de referintele normative definite in standardele europene

Sodurile care nu sunt specificate a=0,7xemin EN 1090-1 e EN1090-2.

a – Grossime sudurii emin – Grosimea minima a sudrii

Nota:

1. Note generale:
   - Conform H.G. 799/97, anexa 3 si a regulamentului publicat in B.C.4/96, constructia se incadreaza in categoria "C" de importanta.
   - Operatiile de debitare a pieselor, precum si cele de prelucrare a marginilor libere si a rostruilor pentru sudare trebuie sa respecte conditiile prevazute in tabelul 3, diferentiate pe nivelurile de acceptare a imbinarilor sudate conform C150-99.
   - Clasa de abateri limita la dimensiunile imbinarilor sudate este "B" conform SR EN ISO-13920/98.
   - Toate cordoanele de sudura se vor executa in uzina, in mediu de gaz protector, dupa o tehnologie agrementata.
   - Conditiile tehnice de calitate vor respecta prevederile STAS 767/0-88.
   - Gradul de pregatire a suprafetelor metalice inaintea vopsirii este Sa2.5 conform GP111-04.
2. Se vor utiliza urmatoarele materiale:
   - Tabla groasa cu grosimi mai mari de 3mm conform SR EN 10025-2 : 2006, otel S235
   - Profile tubulare otel 235 conform SR EN 10219-1-2006.
3. Profile laminate conform SR EN 10025-2 : 2006, otel S235
4. Elemente de asamblare conform SR-EN 14399-4: Suruburi IP gr. 10.9; Piulite IP gr.10; Saibe – SR-EN 14399-5;
5. Pe langa prevederile privind prescriptiile de executie ale constructiilor din otel sudate se vor avea in vedere urmatoarele:
   - Cordoanele de sudura se vor executa continue si omogene;
   - Se vor utiliza electrozi subtiri 3,25 – 4,00 mm pentru ca sudurile sa se execute in mai multe straturi;
   - Grosimea cordoanelor de sudura utilizate in diferite cazuri este tmin=0.7 din grosimea elementelor care se sudeaza;
   - Cordoanele de sudura se vor executa continue pe toata lungimea suprafetelor pieselor aflate in contact.
   - Sudurile de adancime se vor realiza cu grosimea sudurii a=tmin.
   - Nivelul de acceptare al imbinarilor sudate: B.
   - Suduri conform C150-99.
   - Imbinarile sudate vor fi executate numai de sudori de inalta calificare, la fiecare imbinare sudorul isi va aplica poansonul;
6. Se interzice executatrea sudurilor la temperaturi sub +5°C;
7. Protectia anticoroziva va fi formata din :
   -un strat grund poliuretanic grosime 60 microni
   -doua straturi vopsea poliuretanica grosime totala 80 microni

EXPERT				
VERIFICATOR				
Calitate	Nume	Semnătură	CERINȚĂ	REFERAT, Număr, Dată

Proiectant general:

SC AXICON INVEST SRL
Baia Mare, str.Granicerilor 93/43 , jud. Maramureş
tel: 0743-980296,
e-mail: axiconinvest@gmail.com

Beneficiar: **COMUNA SACALASENI**
cu sedlul în: jud.Maramures, com.Sacalaseni , str.Unirii nr.87

Denumire proiect:
HANGAR SI ANEXA ZONA EUROPA

Proiect nr. 4/2021

Calitate	Nume	Semnătură
ŞEF PROIECT	ing. BALAN ALIN	
PROIECTANT ARHITECTURA	arh. TIPLEA CRISTINA	
PROIECTANT REZISTENTA	ing. BALAN ALIN	
DESENAT	ing. BALAN ALIN	

Scara 1:25

Amplasament:
Jud.Maramures, comuna Sacalaseni
str. Europei , nr.38-40 , nr.cad.52872

Faza P.T.

Rev.0

Data 04.2021

SECTIUNE TRANSVERSALA AX 4

Planşa nr. RM_06