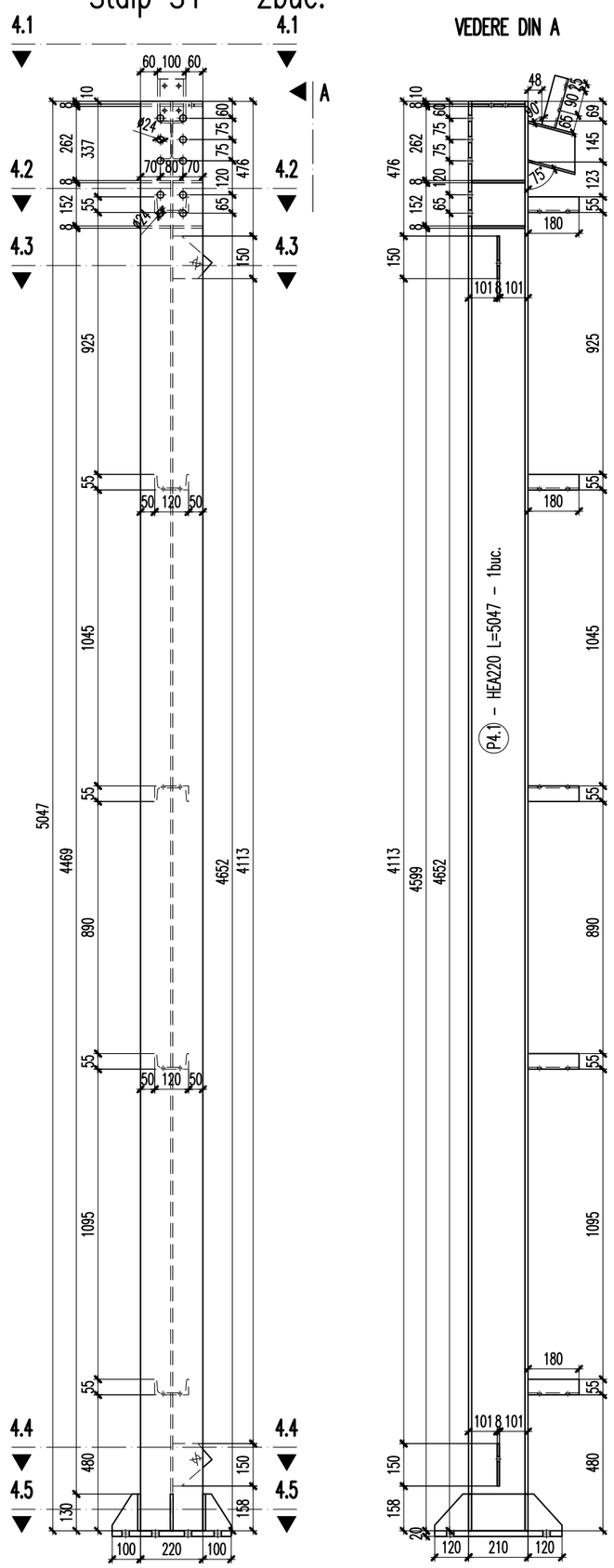
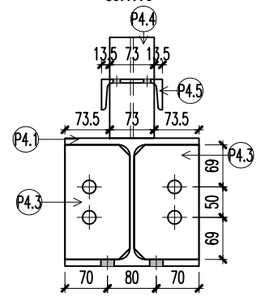
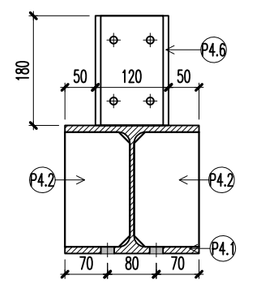
Stalp S4 – 2buc.



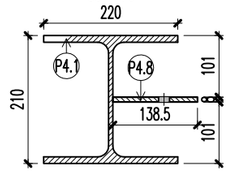
Sectiuneq 4.1–4.1
sc.1:10



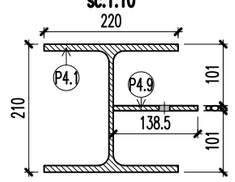
Sectiuneq 4.2–4.2
sc.1:10



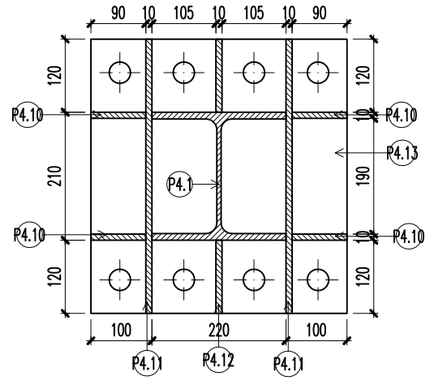
Sectiuneq 4.3–4.3
sc.1:10



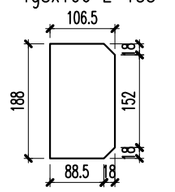
Sectiuneq 4.4–4.4
sc.1:10



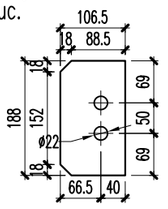
Sectiuneq 4.5–4.5
sc.1:10



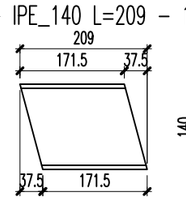
(P4.2) – Tg8x106 L=188 – 4buc.



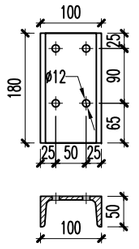
(P4.3) – Tg8x106 L=188 – 2buc.



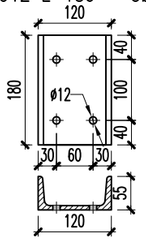
(P4.4) – IPE_140 L=209 – 1buc.



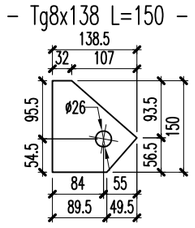
(P4.5) – U10 L=180 – 1buc.



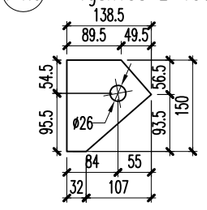
(P4.6) – U12 L=180 – 5buc.



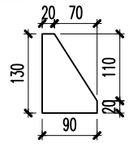
(P4.8) – Tg8x138 L=150 – 1buc.



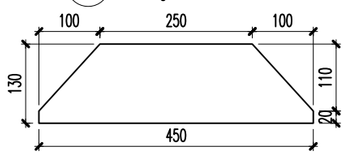
(P4.9) – Tg8x138 L=150 – 1buc.



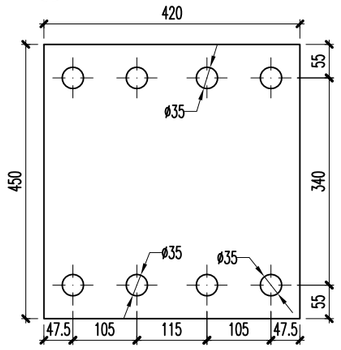
(P4.10) – Tg10x90 L=130 – 4buc.



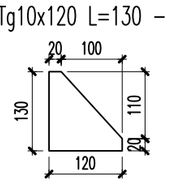
(P4.11) – Tg10x130 L=450 – 2buc.



(P4.13) – Tg20x420 L=450 – 1buc.



(P4.12) – Tg10x120 L=130 – 2buc.



SUBANS	NR. BUC.	POZ.	DENUMIRE ELEMENT	LUNGIME [mm]	BUC./ SUBANS.	TOTAL BUC.	GREUTATE [kg] /ml	/buc.	total
S4	2	P4.1	HEA220	5047	1	2	50.500	254.874	509.748
		P4.10	Tg10x90	130	4	8	7.065	0.918	7.344
		P4.11	Tg10x130	450	2	4	10.205	4.592	18.368
		P4.12	Tg10x120	130	2	4	9.420	1.225	4.900
		P4.13	Tg20x420	450	1	2	65.940	29.673	59.346
		P4.2	Tg8x106	188	4	8	6.657	1.251	10.008
		P4.3	Tg8x106	188	2	4	6.657	1.251	5.004
		P4.4	IPE_140	209	1	2	12.900	2.696	5.392
		P4.5	U10	180	1	2	10.600	1.908	3.816
		P4.6	U12	180	5	10	13.400	2.412	24.120
		P4.8	Tg8x138	150	1	2	8.666	1.300	2.600
		P4.9	Tg8x138	150	1	2	8.666	1.300	2.600
						Greutate totala [kg]			653.25
						Sudura+grund 3% [kg]			19.60
						TOTAL GENERAL [kg]			672.85

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

DETALII GENARALE DE SUDURA
GENERAL WELDING DETAILS

Fabrica Factory	Detaliu Detail	Fabrica Factory	Detaliu Detail
	60°, e, 2, 3		60°, e, 2, 3
	45°, e, 2, 3		45°, e, 2, 3
	e1, e2, a		e1, e2, a
	e1, e2, a		2, e

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

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 sediul in: 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

DETALII STALP S4

Planşa nr. RM_10