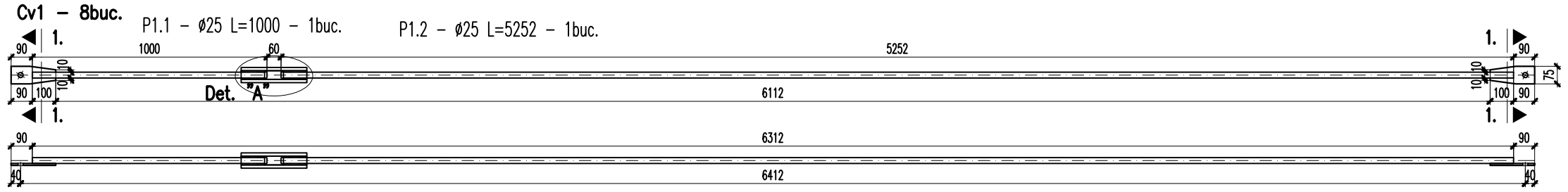
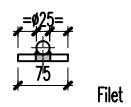
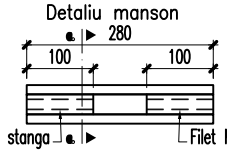
Cv1 – 8buc. P1.1 – ø25 L=1000 – 1buc. P1.2 – ø25 L=5252 – 1buc.



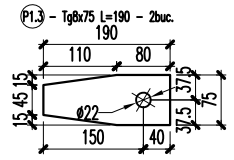
Sectiunea 1.–1.
sc. 1:10



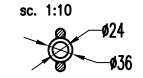
Detaliul "A"
Detaliu manson



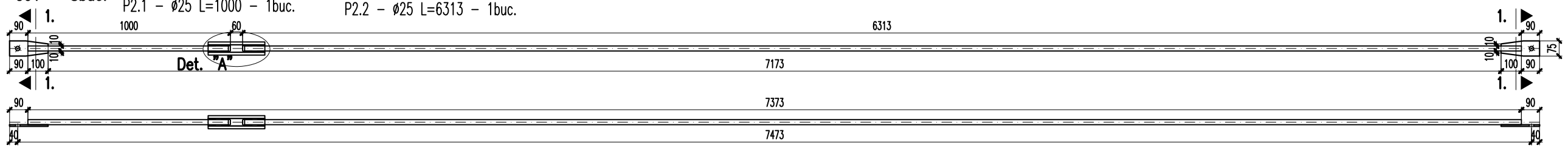
P1.3 – Tg8x75 L=190 – 2buc.



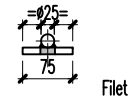
Sectiunea a.–a.
sc. 1:10



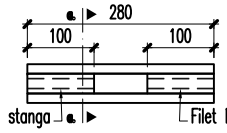
Co1 – 8buc. P2.1 – ø25 L=1000 – 1buc. P2.2 – ø25 L=6313 – 1buc.



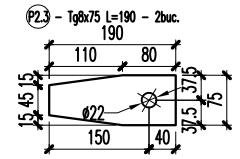
Sectiunea 1.–1.
sc. 1:10



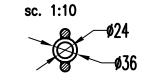
Detaliul "A"
Detaliu manson



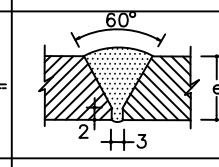
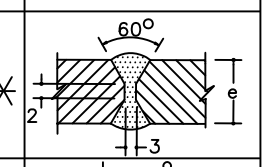
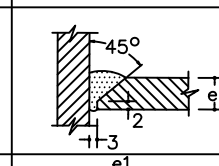
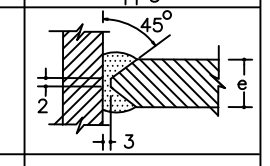
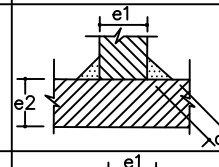
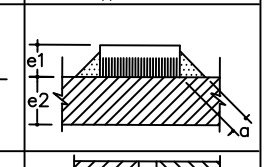
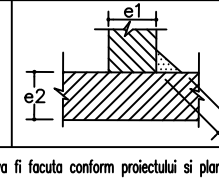
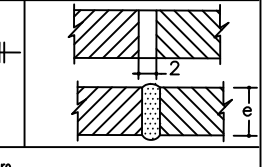
P2.3 – Tg8x75 L=190 – 2buc.



Sectiunea a.–a.
sc. 1:10



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

SUBANS	NR. BUC.	POZ.	DENUMIRE ELEMENT	LUNGIME [mm]	BUC./ SUBANS.	TOTAL BUC.	GREUTATE [kg] /ml	/buc.	total
CV1	8	P1.1	ø25	1000	1	8	3.853	3.853	30.824
		P1.2	ø25	5252	1	8	3.853	20.236	161.888
		P1.3	Tg8x75	190	2	16	4.710	0.895	14.320
CO1	8	P2.1	ø25	1000	1	8	3.853	3.853	30.824
		P2.2	ø25	6313	1	8	3.853	24.324	194.592
		P2.3	Tg8x75	190	2	16	4.710	0.895	14.320
Greutate totala [kg]									446.77
Sudura+grund 3% [kg]									13.40
TOTAL GENERAL [kg]									460.17

EXPERT				
VERIFICATOR				
Calitate	Nume	Semnătură	CERINȚĂ	REFERAT, Număr, Dată

Proiectant general:
SC AXICON INVEST SRL
Baia Mare, str.Granicerilor 93/43 , jud. Maramureș
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 1:20

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

Faza P.T.

Rev.0

Data 04.2021

DETALII CONTRAVANTUIRI

Planșa nr. RM_28