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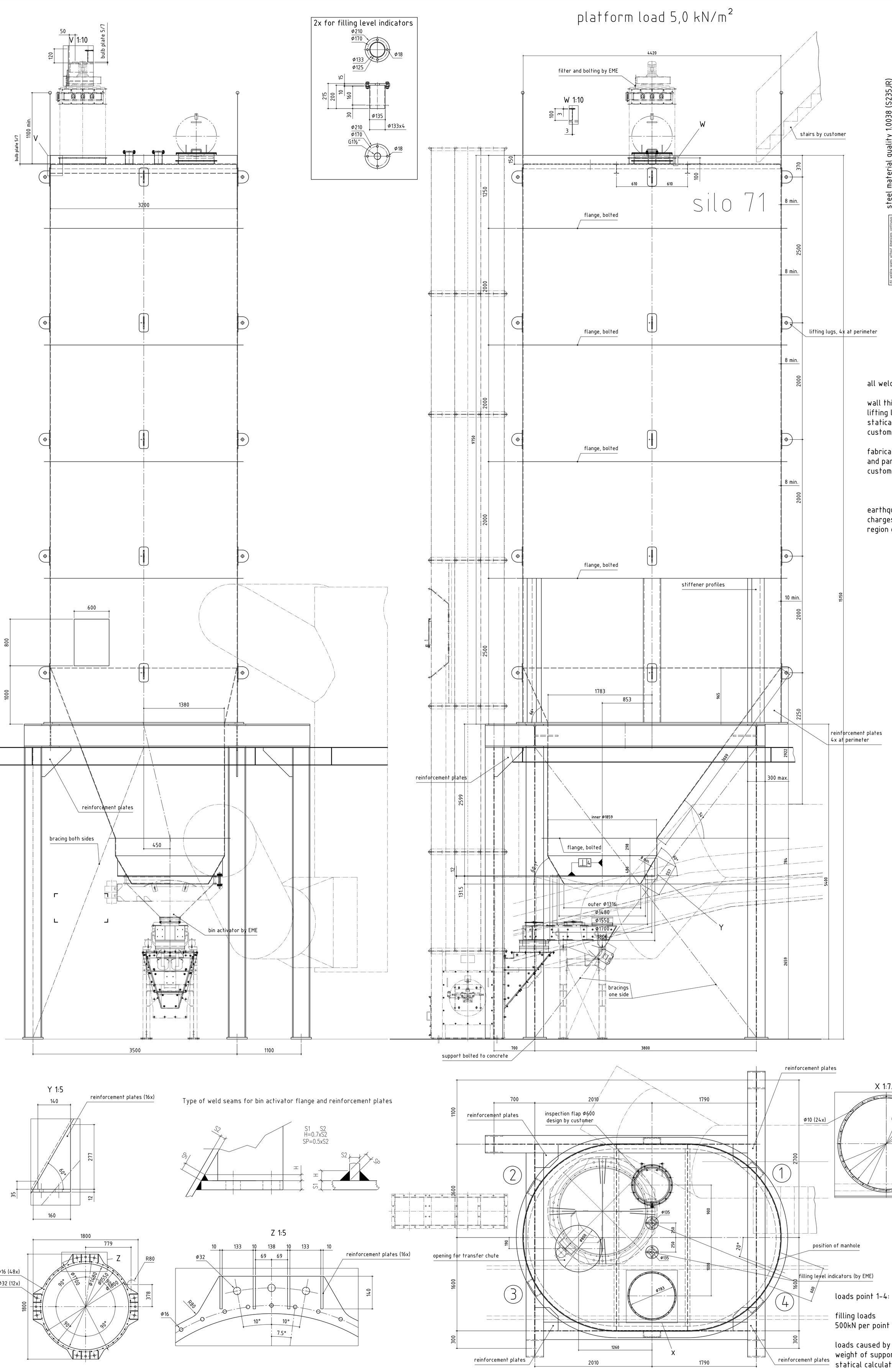

steel material quality 1.0038 (S235JR)

a	26.10.2018	Schmitz	steel quality and recommended steel thickness added		BP18024 01
Index	Datum	Name	Art der Änderung		Projekt-Nr.

projection notice for restricting the use of documents DIN ISO 16016 — break all corners and edges — general tolerance: DIN ISO 2768-mK, DIN EN ISO 13920-B

projection: scale: 1:20 — project: BP18024 01 — drawing: 204 640-00a — paper size: A0

	date	name
drawn	12.10.2018	Schmitz
check	12.10.2018	Schmitz
approv.		

batch and cullet silo

Member of SORG Group

All welding seams without dimensions continuous

Butt weld — Fillet weld

Welding process: 135 acc. to ISO 4063

Base material: S235 acc. to DIN EN 10025-2

Additional material: DIN EN 499, DIN EN 440

Welding position: PA, PB, PC, PD, PE, PF, PG

Quality demands: ISO 5817 C

Preparation of welds: ISO 9692-1

Additional welding: DIN EN ISO 14175, DIN EN ISO 14341

Position of welds: PA, PB, PC

General tolerances: DIN EN ISO 13920 - B

Preheating:

EME Pos. E09.01

all weldings dust tight

wall thickness, profiles lifting lugs etc. acc. to statical calculation by customer

fabrication drawings and partlists by customer

earthquake extra charges according the region of silo placement

loads point 1-4:

filling loads 500kN per point

loads caused by weight of silo and weight of support according to statical calculation (by customer)

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