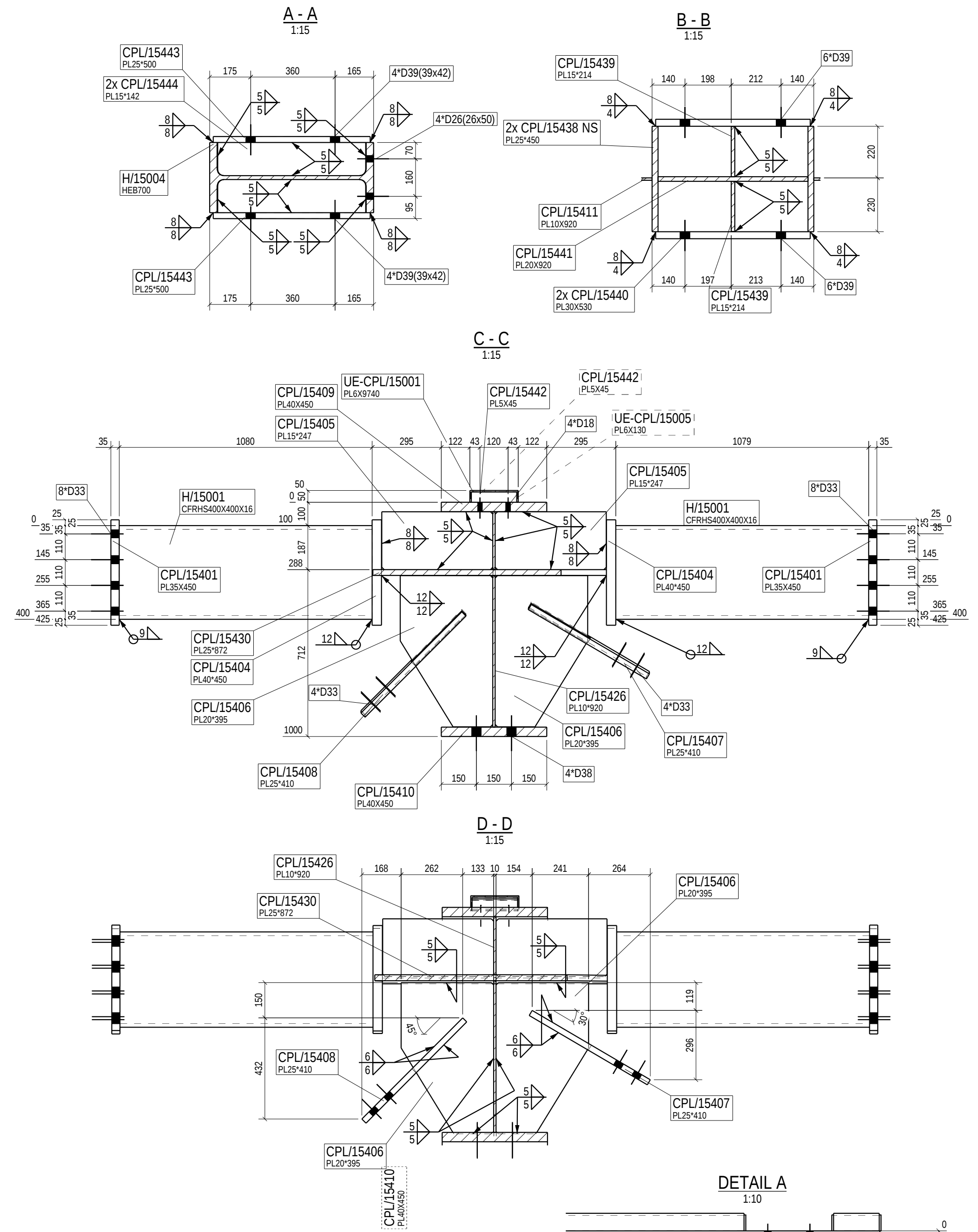
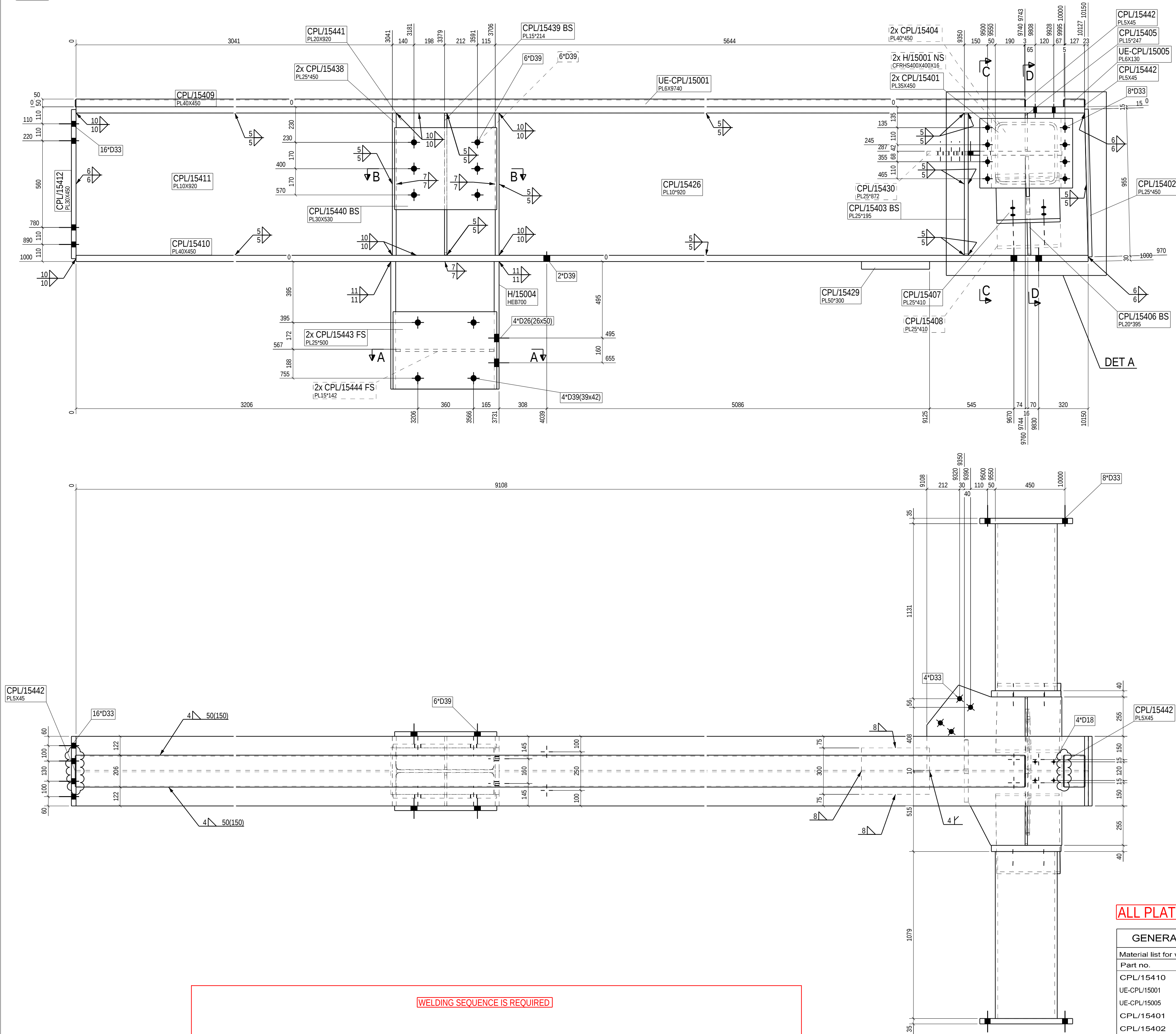
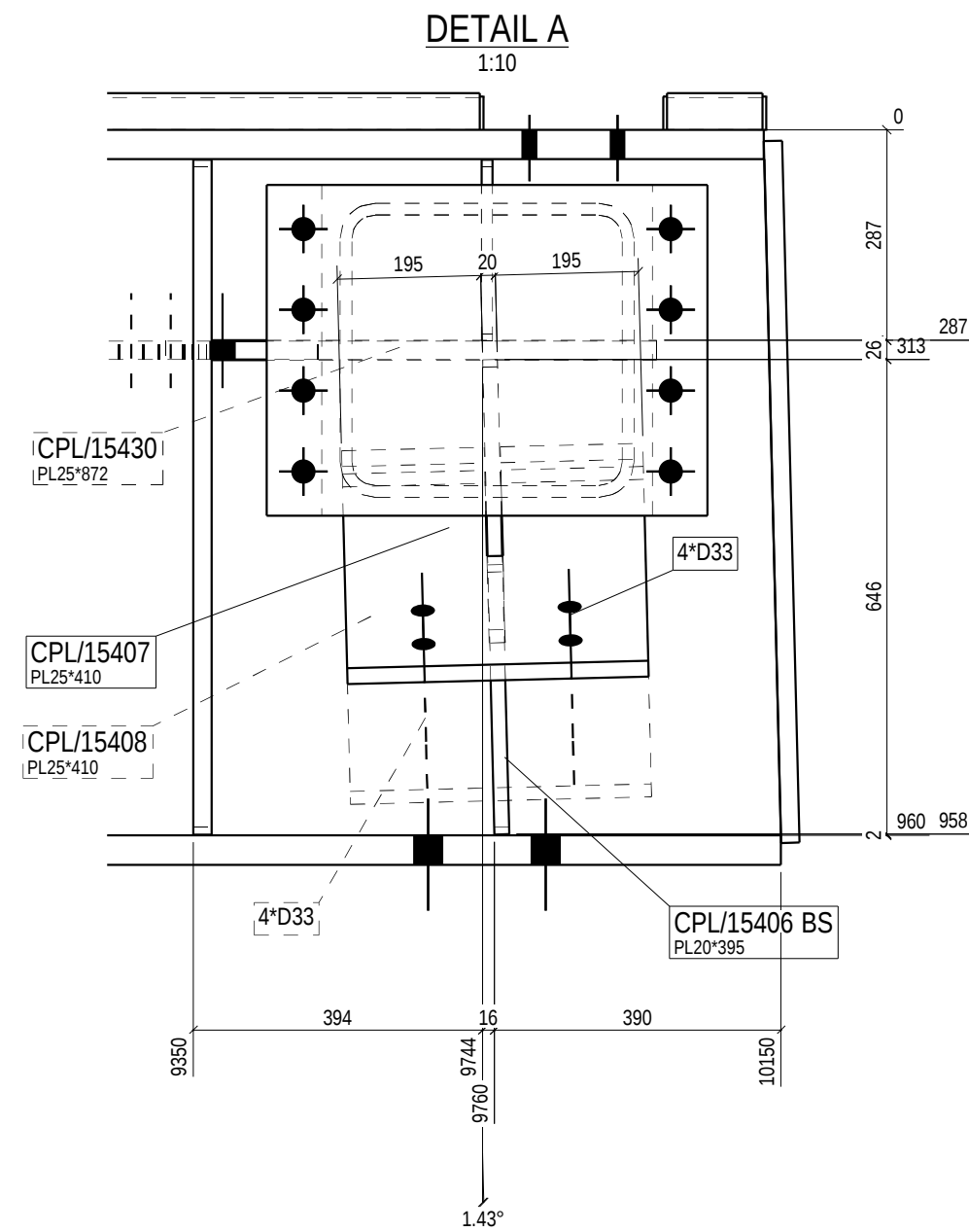




ADJUST FIRST CPL/15406,
NEXT ADJUST CPL/15407 & CPL/15408 ACCORDING TO CPL/15406

ALL PLATES $\geq 40\text{mm}$ - PREHEAT 100°C

GENERAL NOTE:		ALL robot welds FW a=3.5 ALL non-marked welds FW = 4				
Material list for welding drawing		CW1/1504			1 Qty.	
Part no.	Profile	Material	Qty.	Length	Area	Weight
CPL1/15410	PL40X450	S355J2	1	10150	10.0	1434.2
UE-CPL15001	PL6X9740	S355J2	1	293	5.8	134.9
UE-CPL15005	PL6X130	S355J2	1	293	0.1	1.8
CPL1/15401	PL35X450	S355J2	2	600	0.6	74.2
CPL1/15402	PL25*450	S355J2	1	955	0.9	84.3
CPL1/15403	PL25*195	S355J2	2	918	0.4	35.1
CPL1/15404	PL40*450	S355J2	2	450	0.5	63.6
CPL1/15405	PL15*247	S355J2	2	474	0.3	13.7
CPL1/15406	PL20*395	S355J2	2	646	0.5	33.6
CPL1/15407	PL25*410	S355J2	1	585	0.5	45.8
CPL1/15408	PL25*410	S355J2	1	610	0.6	47.7
CPL1/15409	PL40X450	S355J2	1	10127	10.0	1430.9
CPL1/15411	PL10X920	S355J2	1	3041	5.7	219.6
CPL1/15412	PL30X450	S355J2	1	964	1.0	102.2
CPL1/15426	PL10*920	S355J2	1	6419	11.9	461.5
CPL1/15429	PL50*300	S355J2	1	440	0.3	51.8
CPL1/15430	PL25*872	S355J2	1	1037	1.5	133.2
CPL1/15438	PL25*450	S355J2	2	920	0.9	81.2
CPL1/15439	PL15*214	S355J2	2	918	0.4	23.1
CPL1/15440	PL30X530	S355J2	2	660	0.8	82.4
CPL1/15441	PL20X920	S355J2	1	640	1.2	92.4
CPL1/15442	PL5X45	S275JR	4	200	0.0	0.4
CPL1/15443	PL25*500	S355J2	2	670	0.7	65.7
CPL1/15444	PL15*142	S355J2	2	632	0.2	10.5
H/15001	CFRHS400X400X16	S355J2H	2	1079	1.6	198.6
H/15004	HEB700	S355J2SALCOS	1	825	2.1	198.8
				Total	65.4	5804.3



No	REV MARK	REVISION DESCRIPTION	CREATED/ APPROVED	REV. DATE
Surface treatment			DESIGNER:	
			EXC _____ SIZE _____ A1 _____	
			ORDER NO. _____	
PROJECT			ASSEMBLY NO.	
Send to production		Name	COLUMN WELDED	
[CW.1504 - 1]				

Production	
Assembly	Line
CW/1504	101