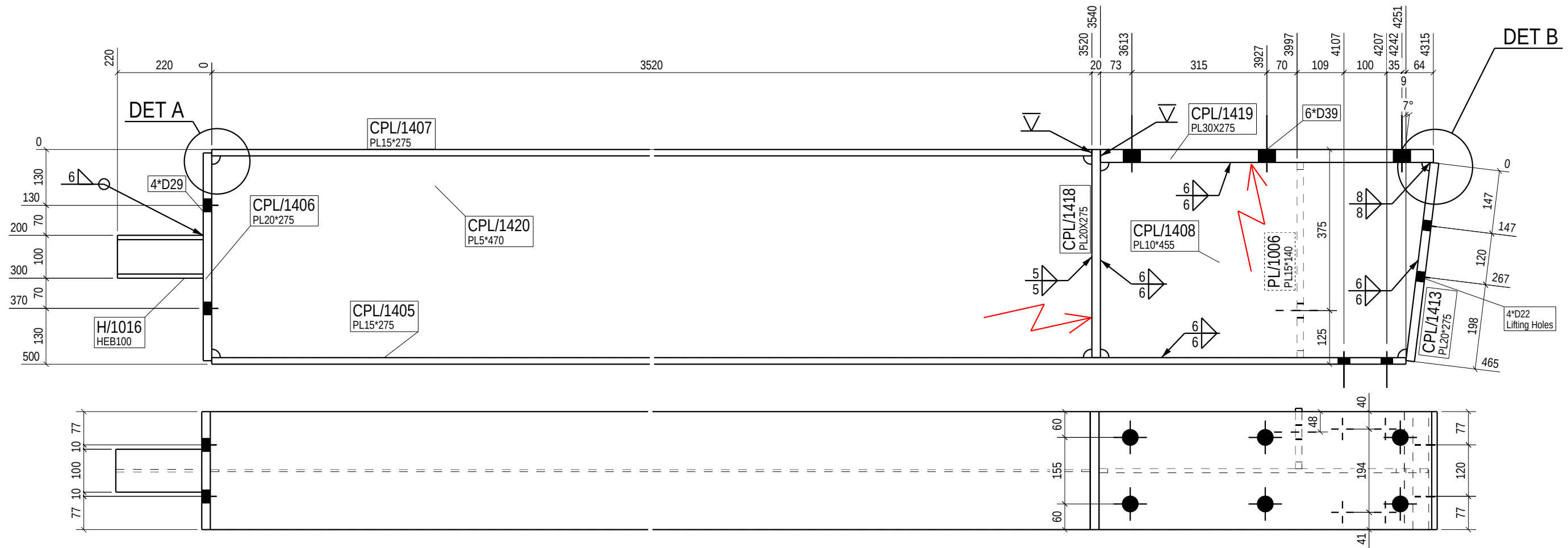


WELDING CONTROL
1. If sulfur content in steel is $S > 0.005\%$ then there must be 100% UTL test performed
2. If sulfur content in steel is $S \leq 0.005\%$ then there must be only 5-10% of UTL test performed

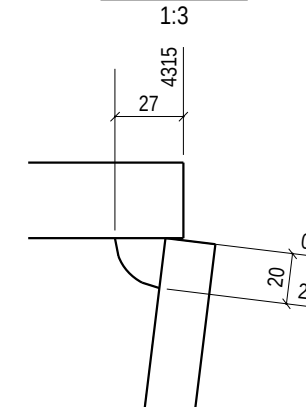
GENERAL NOTE:

ALL robot welds FW a=3.5
ALL non-marked welds FW = 4

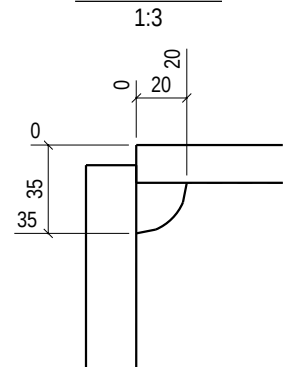
Material list for welding drawing

		CW/103			1 Qty.	
Part no.	Profile	Material	Qty.	Length	Area	Weight
CPL/1405	PL15*275	S355J2	1	4251	2.5	137.7
CPL/1406	PL20*275	S355J2	1	484	0.3	20.9
CPL/1407	PL15*275	S355J2	1	3520	2.0	113.9
CPL/1408	PL10*455	S355J2	1	766	0.7	26.3
CPL/1413	PL20*275	S355J2	1	465	0.3	20.1
CPL/1418	PL20X275	S355J2-Z35	1	485	0.3	20.9
CPL/1419	PL30X275	S355J2-Z35	1	775	0.5	49.8
CPL/1420	PL5*470	S355J2	1	3520	3.3	64.9
H/1016	HEB100	S355J2	1	200	0.1	4.1
PL/1006	PL15*140	S355J2	1	453	0.1	7.4
				Total	10.2	466.0

DETAIL B



DETAIL A



No	REV	MARK	REVISION DESCRIPTION	CREATED	APPROVED	REV. DATE
Surface treatment						
PROJECT				DESIGNER:		
Send to production				EXC		
Name				SIZE		
BEAM				A3		
				ORDER NO.		
				ASSEMBLY NO.		
				[CW.103 - 1]		

Production	
Assembly	Line
CW/103	101