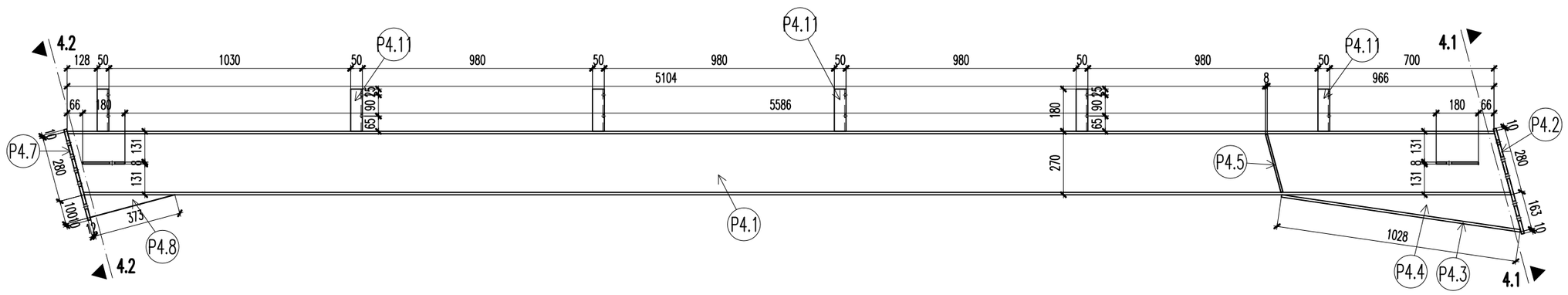
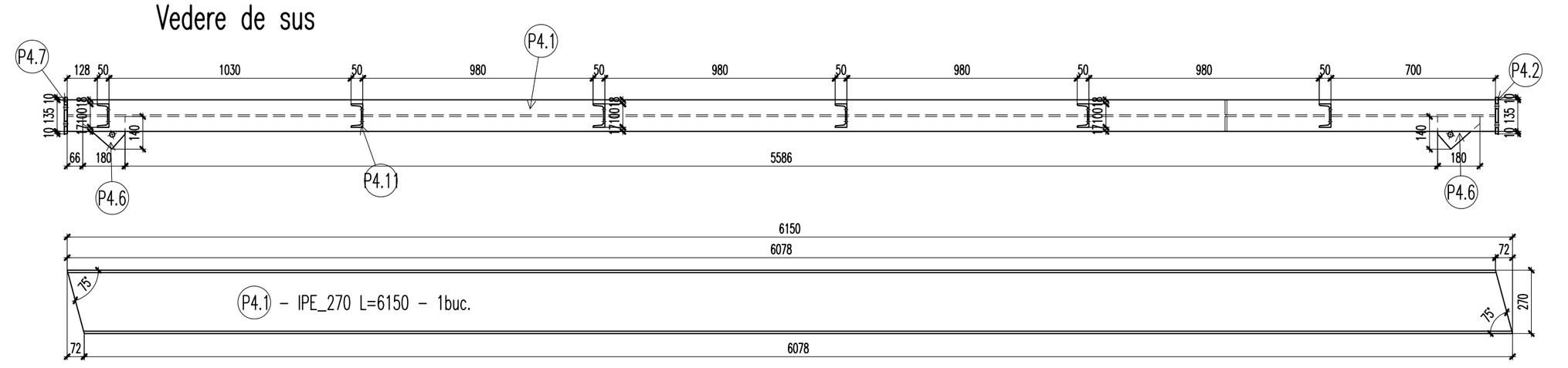
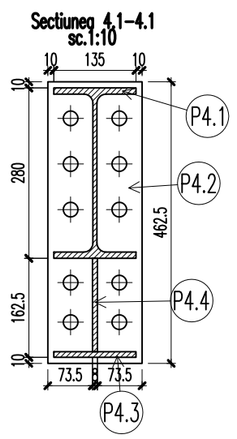
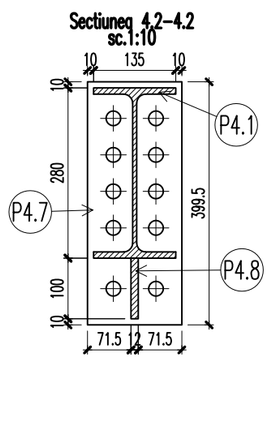
Grinda G4 – 1buc.
Vedere laterala



Vedere de sus

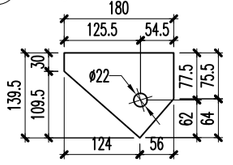




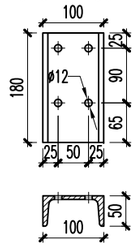


P4.5 – Tg8x64 L=256 – 2buc.

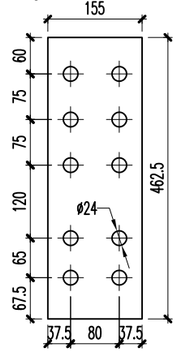
P4.6 – Tg8x139 L=180 – 2buc.



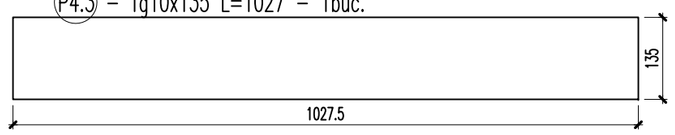
P4.11 – U10 L=180 – 6buc.



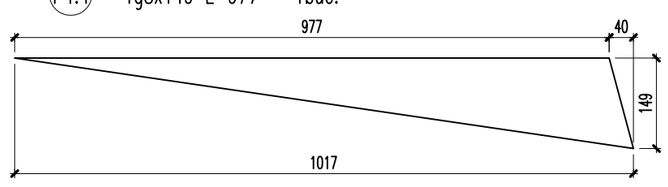
P4.2 – Tg12x155 L=462 – 1buc.



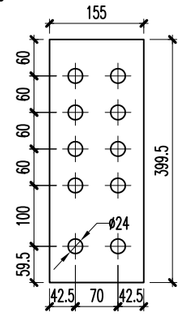
P4.3 – Tg10x135 L=1027 – 1buc.



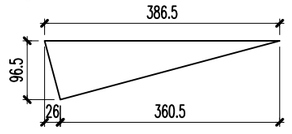
P4.4 – Tg8x149 L=977 – 1buc.



P4.7 – Tg12x155 L=399 – 1buc.



P4.8 – Tg12x96 L=386 – 1buc.



SUBANS.	NR. BUC.	POZ.	DENUMIRE ELEMENT	LUNGIME [mm]	BUC./ SUBANS.	TOTAL BUC.	GREUTATE [kg] /ml	/buc.	total
G4	1	P4.1	IPE_270	6150	1	1	36.100	222.015	222.015
		P4.11	U10	180	6	6	10.600	1.908	11.448
		P4.2	Tg12x155	462	1	1	14.601	6.746	6.746
		P4.3	Tg10x135	1027	1	1	10.598	10.884	10.884
		P4.4	Tg8x149	977	1	1	9.357	9.142	9.142
		P4.5	Tg8x64	256	2	2	4.019	1.029	2.058
		P4.6	Tg8x139	180	2	2	8.729	1.571	3.142
		P4.7	Tg12x155	399	1	1	14.601	5.826	5.826
		P4.8	Tg12x96	386	1	1	9.043	3.491	3.491
					Greutate totala [kg]				274.75
					Sudura+grund 3% [kg]				8.24
					TOTAL GENERAL [kg]				282.99

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

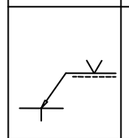
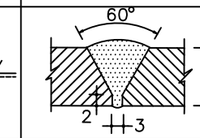
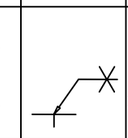
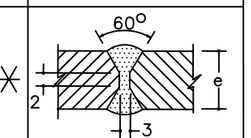
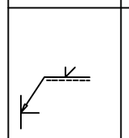
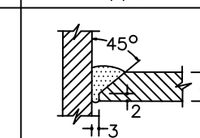
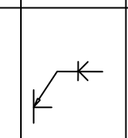
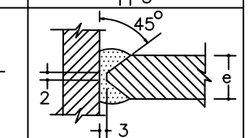
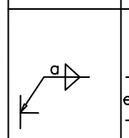
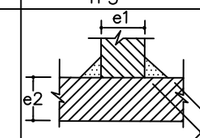
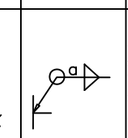
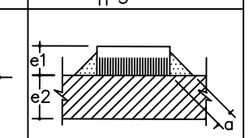
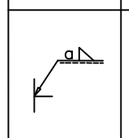
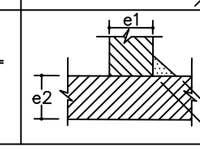
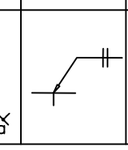
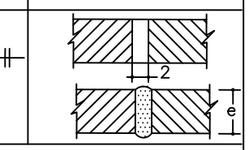
4. Elemente de asamblare conform SR–EN 14399–4: Suruburi IP gr. 10.9; Piulite IP gr.10; Saibe – SR–EN 14399–5;

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
			
			
			
			

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	CERINŢĂ	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

Proiect nr. 4/2021

Denumire proiect:
HANGAR SI ANEXA ZONA EUROPA

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 GRINDA G4

Planşa nr. RM_18