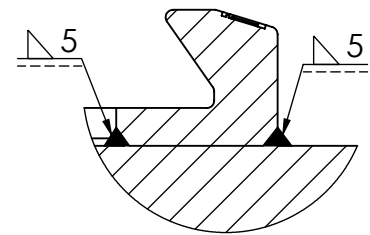


Welding information:



DETAIL A SCALE 1 : 2

Load type	Shear	Tension
Breaking load (BL)	420 kN	500 kN
Safe Working Load (SWL)	210 kN	250 kN

Date: 17-06-2021	Revision no.: 001		Scale: 1:4/1:5
Color/finish: Primed	Weight: 6.2kg		Drawn: K. van Puffelen
Material: Blank Steel	Comment: units in mm		Checked: S. Saeys

Double Dovetail Foundation 55° Lc=203mm

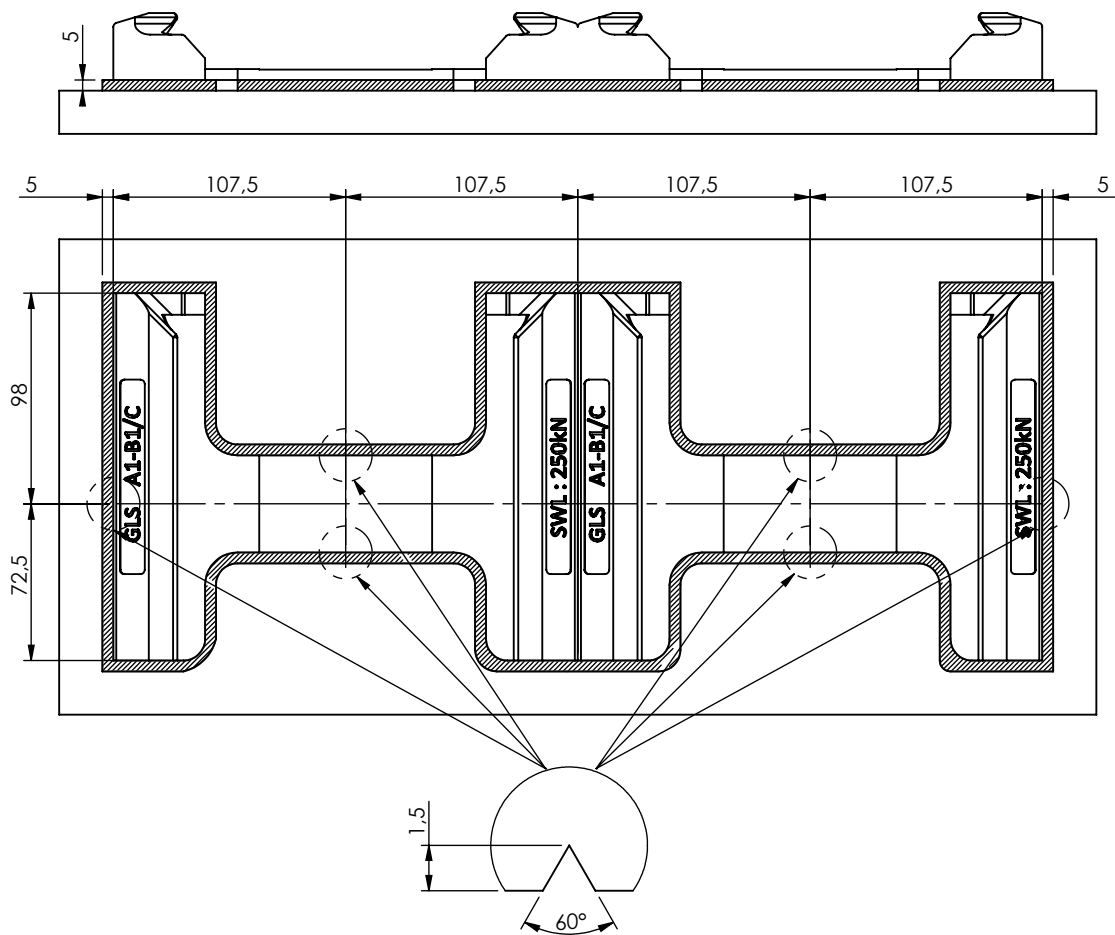


A4

Drawingno.:

AE-B2/C/203

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1. Welding preparation: Clean the locations for the welds on the foundation as well as on the connection area. Clean all the dirt, rust or any residual paint.
2. Position the dovetail plate on the location, then weld the dovetail plate on the connection area with the 4 to 6 indicated welding points. Which will be strengthened when connecting these points with 5mm welding beads.
3. Important: Please weld these beads in a 2 time process, first spot weld the indicated locations, while the second weld is to connect these spot welds with 5mm welding beads.
4. Reference instructions for the indicated spot welds:
 - Reference current: 200-240A
 - Voltage: 20-23V
 The actual value can be adjusted according to practical situation. The homogeneous welding bead should be 5mm, without intermediate gaps or cracks.
5. Reference instructions for the homogenous welding beads to connect the spot welds:
 - Reference current: 200-240A
 - Voltage: 20-23V
 The actual value can be adjusted according to practical situation. The homogeneous welding beads should be 5mm, without intermediate gaps, cracks, undercut and weld misalignment.

Welding Instruction For: Double Dovetail Foundation 55° Lc=203mm



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Drawingno.:

AE-B2/C/203

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