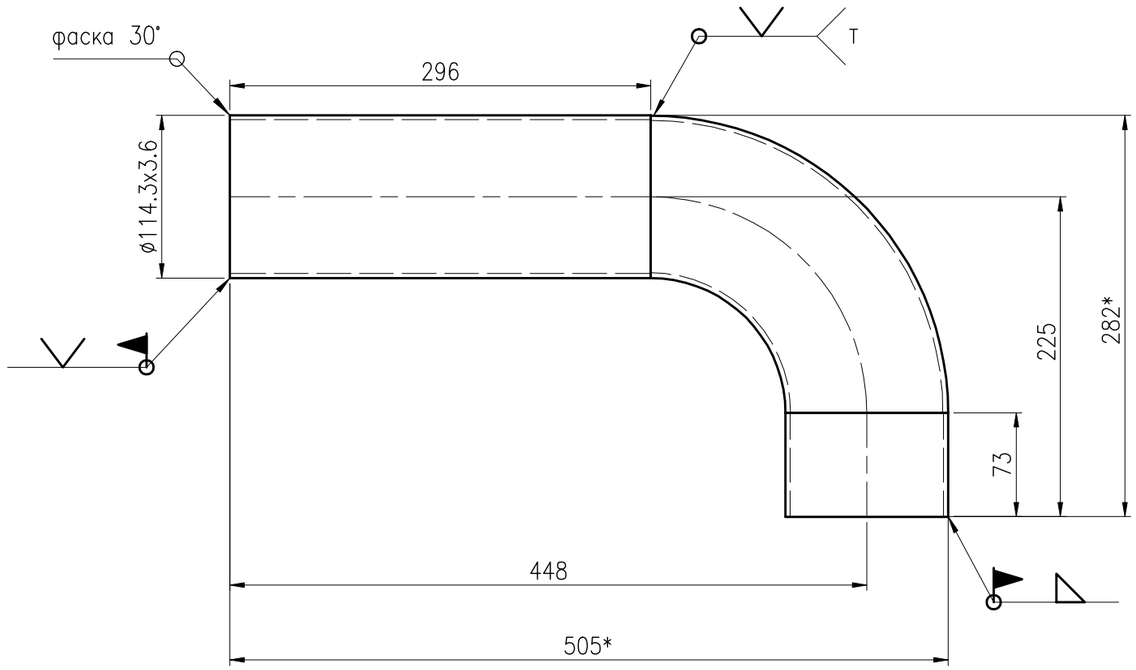
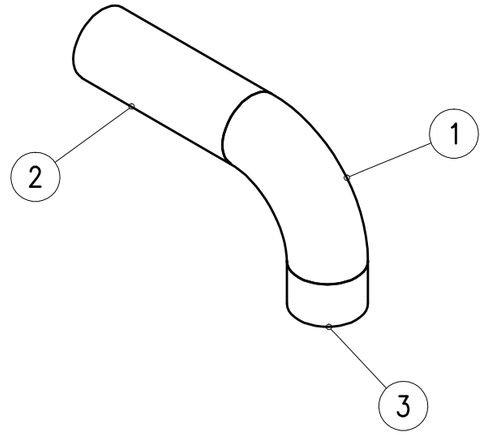
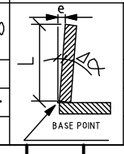




1. Неуказанные предельные отклонения: EN ISO 13920–B,F.
2. Сварка: EN ISO 5817:2003–C.
3. T – газоплотный сварной шов.
4. Сварочный шов a4, если не указано иного.
5. Острые кромки притупить.
6. Обработка поверхности: ST2 грунт Tecnolac Primer 2x40µm 0168–71 Hall
7. Покрытие зон монтажных швов (50мм): ST2 KORRO PVB 20µm.

					6	
1	3	Pipeø114.3x3.6 L=73	S235JR		1	no dwg
1	2	Pipeø114.3x3.6 L=296	S235JR		3	no dwg
1	1	Elbow ø114.3x3.6 90° type 3 R=152	S235JRG2	DIN 2605	2	
Qty	Item	Name	Material	Drawing Nr / Standard	Mass	Note

MAXIMUM TOLERANCES FOR WELDED STRUCTURES - LENGTHS												ANGLE			
NOMINAL DIMENSION →		> 30 ≤ 120	120 315	315 1000	1000 2000	2000 4000	4000 8000	8000 12000	12000 16000	16000 20000	20000		315	315 1000	1000
CLASS OF WORK		TOLERANCE										TOLERANCE			e mm/m
~~A~~		~~± 1~~	~~± 1~~	~~± 2~~	~~± 3~~	~~± 4~~	~~± 5~~	~~± 6~~	~~± 7~~	~~± 8~~	~~± 9~~		~~± 6~~	~~± 4.5~~	~~± 3~~
B		± 2	± 2	± 3	± 4	± 6	± 8	± 10	± 12	± 14	± 16		± 13	± 9	± 6



Enefit	Eesti Energia Technology Industries	DRAWN 18.05.2015 Alla Skorohodova	SIZE A3	APPR.	SHEET
		SCALE 1:4	ISSUED	CONTRACT NO	
Title 14K D02804643088_1430451_0015020b			DWG NO 151550.14.00		REV