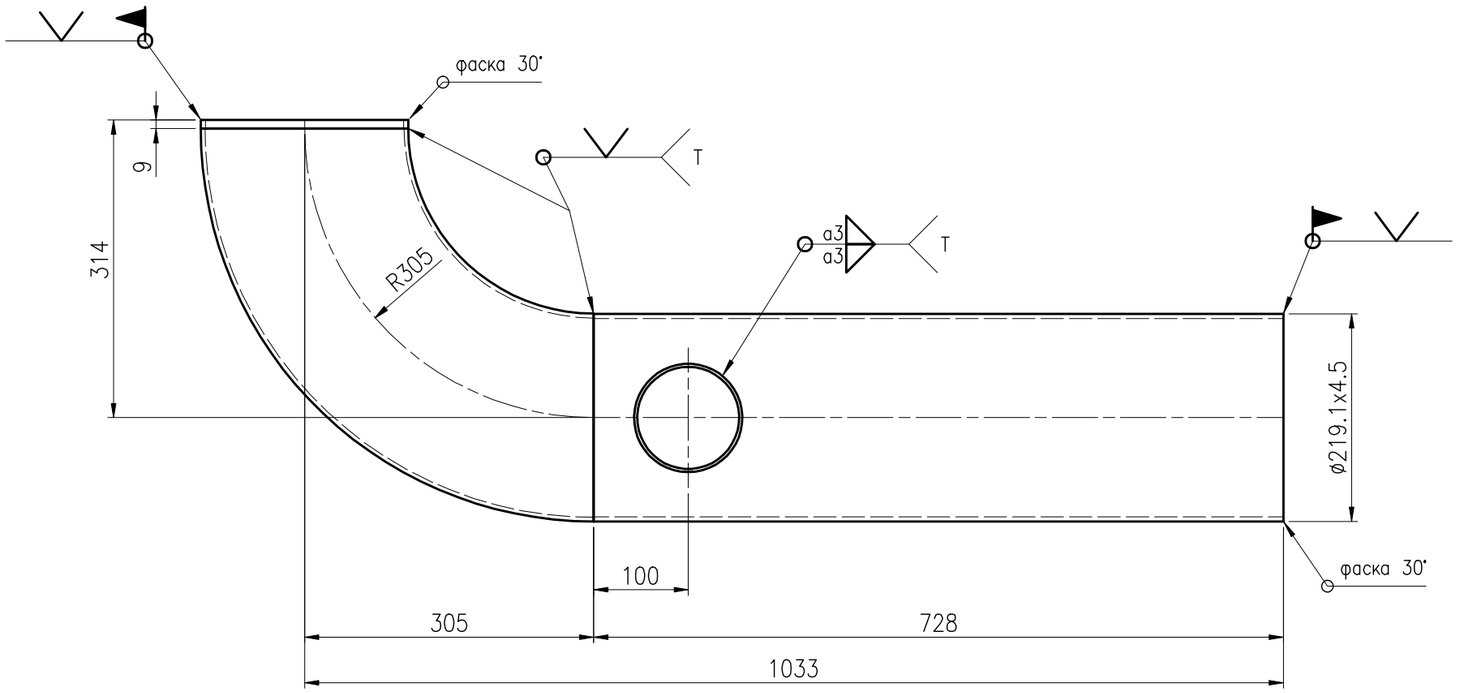
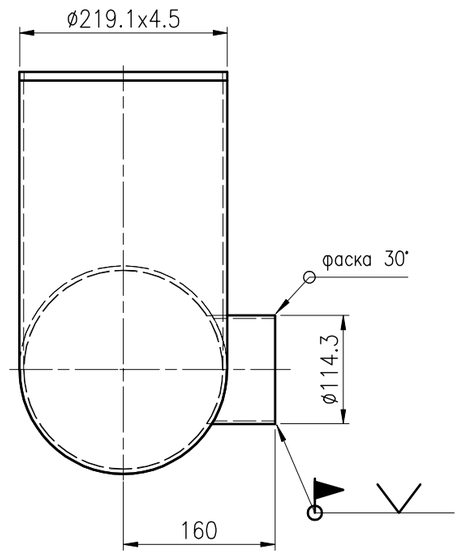
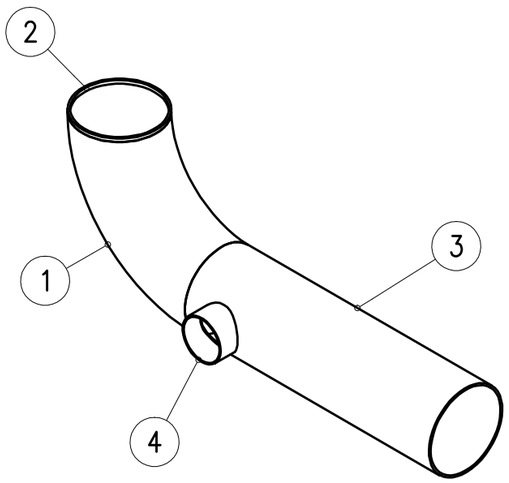






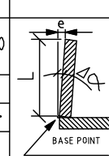
1. Неуказанные предельные отклонения: EN ISO 13920–B,F.
2. Сварка: EN ISO 5817:2003–C.
3. T – газоплотный сварной шов.
4. Сварочный шов a4 , если не указано иного.
5. Острые кромки притупить.
6. Обработка поверхности: ST2 грунт Tecnolac Primer 2x40µm 0168–71 Hall
7. Покрытие зон монтажных швов (50мм):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

					31	
1	4	Pipe ø114.3x3.6	S235JR	151550.07.02	1	
1	3	Pipe ø219.1x4.5	S235JR	151550.15.01	19	
1	2	Pipe ø219.1x4.5 L=9	S235JR		0	no dwg
1	1	Elbow ø219.1x4.5 90° type 3 R=305	S235JRG2	DIN 2605	11	
Qty	Item	Name	Material	Drawing Nr / Standard	Mass	Note

MAXIMUM TOLERANCES FOR WELDED STRUCTURES - LENGTHS

NOMINAL DIMENSION →	> 30 ≤ 120	120 315	315 1000	1000 2000	2000 4000	4000 8000	8000 12000	12000 16000	16000 20000	20000
CLASS OF WORK	TOLERANCE									
A	± 1	± 1	± 2	± 3	± 4	± 5	± 6	± 7	± 8	± 9
B	± 2	± 2	± 3	± 4	± 6	± 8	± 10	± 12	± 14	± 16

ANGLE



315	315 1000	1000
TOLERANCE		e mm/m
± 6	± 4.5	± 3
± 13	± 9	± 6

Enefit — Eesti Energia Technology Industries

DRAWN 14.05.2015 Alla Skorohodova	SIZE A3	APPR.	SHEET
SCALE 1:6	ISSUED	CONTRACT NO	
Title 15K D02804643088_1430451_0015020b	DWG NO 151550.15.00		REV