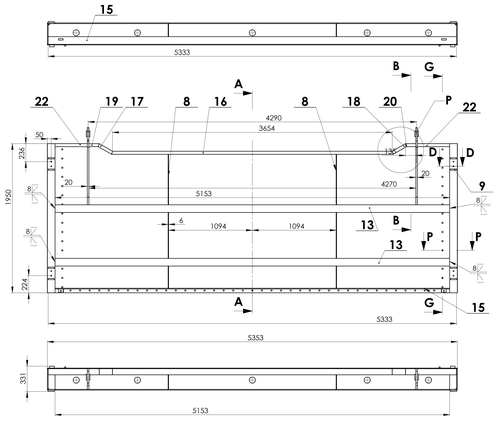
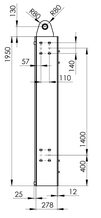
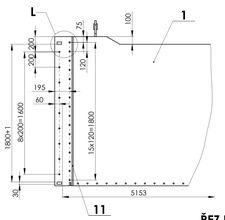
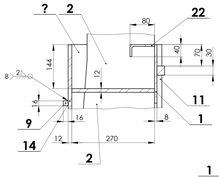
NÁTĚRY : W1 - 35 m2



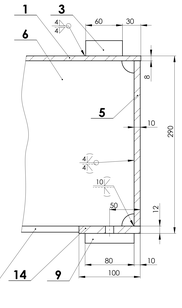




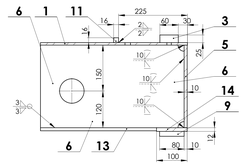
ŘEZ M-M
MĚŘÍTKO 1 : 5



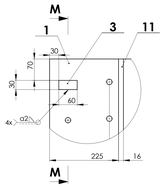
ŘEZ D-D
MĚŘÍTKO 1 : 2.5



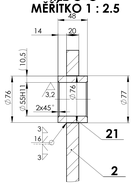
ŘEZ P-P
MĚŘÍTKO 1 : 5



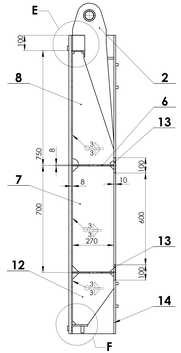
DETAIL L
MĚŘÍTKO 1 : 5



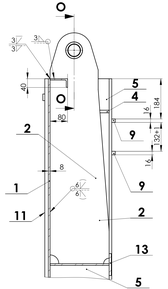
ŘEZ O-O
MĚŘÍTKO 1 : 2.5



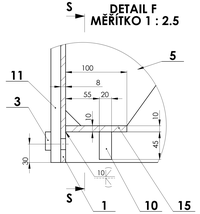
ŘEZ A-A
MĚŘÍTKO 1 : 10



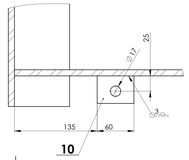
ŘEZ B-B
MĚŘÍTKO 1 : 7



DETAIL F
MĚŘÍTKO 1 : 2.5



ŘEZ S-S
MĚŘÍTKO 1 : 2.5



DETAIL E
MĚŘÍTKO 1 : 5

neoznačené svary provařit plným tupým svarem

2	L 60x40x5-674	EN 10 056	S 235 JR	2.75		22
2	TR 76x12,5-52	ČSN 42 5715	11 353.0	0.80		21
1	L 80x40x6-135	EN 10 056	S 235 JR	0.71		20
1	L 80x40x6-135	EN 10 056	S 235 JR	0.71		19
1	L 80x40x6-211	EN 10 056	S 235 JR	1.08		18
1	L 80x40x6-211	EN 10 056	S 235 JR	1.08		17
1	L 80x40x6-3675	EN 10 056	S 235 JR	19.66		16
1	PLO 100 x 10 - 5333	EN 10 058	S 355 J2G3	41.60		15
2	PLO 100 x 12 - 1950	EN 10 058	S 355 J2G3	18.20		14
2	PLO 100x10- 5153	EN 10 058	S 355 J2G3	40.19		13
2	P 6 - 270 x 336	EN 10 029	S 355 J2G3	3.24		12
2	4 HR 16 - 1950	EN 10 059	S 235 JR	3.89		11
2	PLO 60x20-45	EN 10 058	S 235 JR	0.39		10
8	4HR 16 - 80	EN 10 059	S 235 JR	0.16		9
2	P 6-270x740	EN 10 029	S 355 J2G3	6.11		8
2	P 6-270x 692	EN 10 029	S 355 J2G3	8.64		7
2	P 8 -270X5333	EN 10 029	S 355 J2G3	88.20		6
2	P 10 - 270 X 1950	EN 10 029	S 355 J2G3	40.71		5
2	P 12 90x 270	EN 10 029	S 355 J2G3	2.25		4
4	PLO 60 x 25 - 30	EN 10 058	S 235 JR	0.35		3
2	P 20 - 270 X 1056	EN 10 029	S 355 J2G3	37.39		2
1	P 8- 1950 x 5355	EN 10 029	S 355 J2G3	626.21		1
Kusů	Rozměr	POLOTOVAR	MATERIÁL	HMOT NOST	Číslo výkresu	Poz.

Změna				Hmotnost kg	Měřítko
Sestavil:	Ing. Kovářík	Navrhl:			1:20
Vyhot.:		Schválil:		Poz:	A1
Přezk.:		Datum:			
Heslo:		20.07.2023		Nov.=	Nová =
SVAŘENEC TABULE				175-010301	
Typ		Skupina		List	

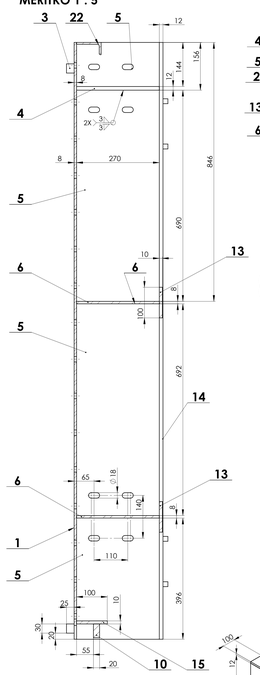
PŘEVZS PODMÍNKY SVAŘOVÁNÍ PRO VÝROBCE / REQUIREMENTS OF WELDING FOR MANUFACTURER

SVAR ČÍSLO - / WELD NO.:	ALL
ZKUŠEBNÍ LABORTŘ / ZKOUŠEJÍCÍ DOHLED:	EN ISO 3817 B
TOLERANCE ROZMĚRŮ / TOLERANCE OF DIMENSIONS:	EN ISO 13920 BF
KONTROLA SVAŘENCŮ / KONTROLA SVAŘENCŮ:	EN ISO 15609 YES
KVALIFIKACE SVAŘEČŮ / QUALIFICATION OF WELDERS:	EN 287-1 YES
METODA SVAŘOVÁNÍ / WELDING METHOD:	EN ISO 4063 135
PŘÍDAVNÝ MATERIÁL / FILLER METAL:	AWS A 5.18 ER 70S-6
DUTÉ / Dutted:	EN ISO 14175 MIG
MOŘENÍ A PASIVACE / MOŘENÍ A PASIVACE:	NO

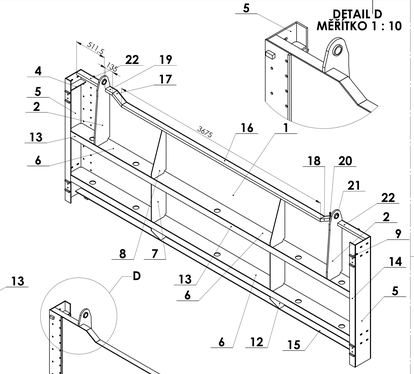
HOT CHECKS	VT	EN 970	100%
	PT	ASME Section VIII Div.1 App.8	20%
	MPT	ASME Section VIII Div.1 Add.6	
	UT	ASME Section VIII Div.1 App.12	
	RT	ASME Section VIII Div.1 par.UW-51	
	ZKNĚ / OTHER		

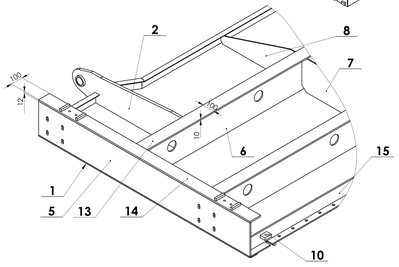
ŘÍDÍCÍ PRACOVNÍK / HEAD TECHNOLOGIST:	NO
SCHVÁLIL HSE / APPROVED BY:	

ŘEZ G-G
MĚŘÍTKO 1 : 5

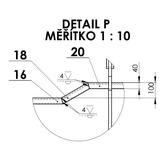


DETAIL D
MĚŘÍTKO 1 : 10

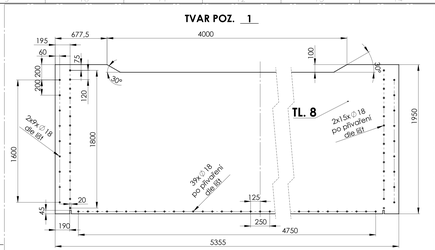




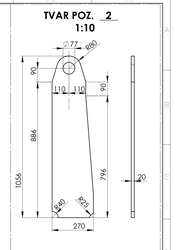
DETAIL P
MĚŘÍTKO 1 : 10



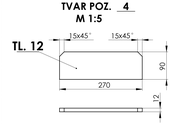
TVAR POZ. 1



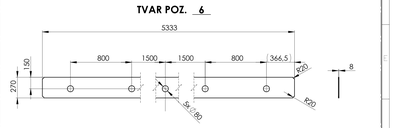
TVAR POZ. 2
1:10



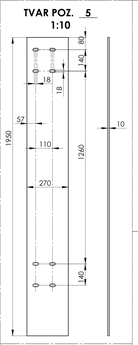
TVAR POZ. 4
M 1:5



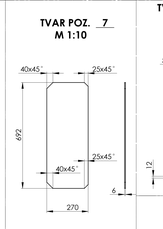
TVAR POZ. 6



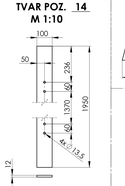
TVAR POZ. 5
1:10



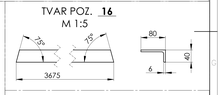
TVAR POZ. 7
M 1:10



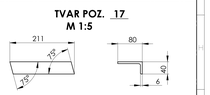
TVAR POZ. 14
M 1:10



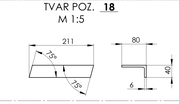
TVAR POZ. 16
M 1:5



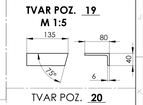
TVAR POZ. 17
M 1:5



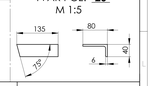
TVAR POZ. 18
M 1:5



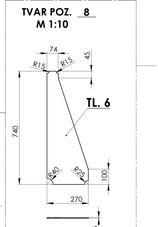
TVAR POZ. 19
M 1:5



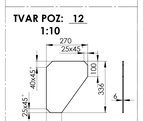
TVAR POZ. 20
M 1:5



TVAR POZ. 8
M 1:10



TVAR POZ: 12
1:10



Změna				Hmotnost kg	
Sestavil:	Ing. Kovářík	Navrhl:			1:20
Vyhot.:		Schválil:		Poz:	A1
Přezk.:		Datum:			
Heslo:		20.07.2023		Nov.=	Nová =
SVAŘENEC TABULE				175-010301	
Typ		Skupina		List	