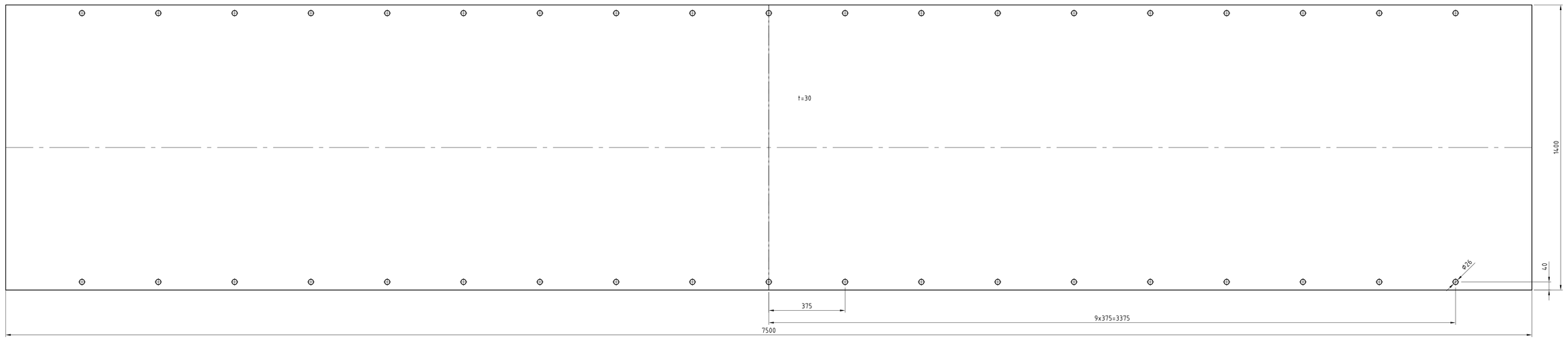
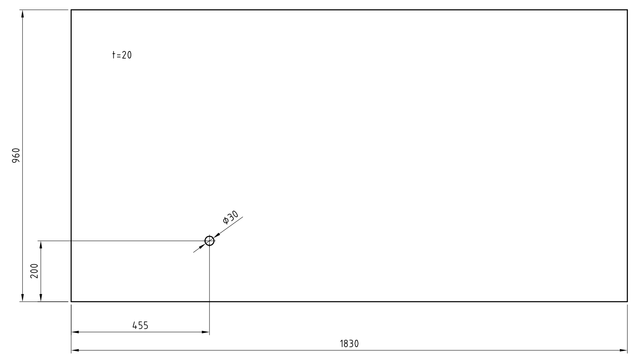
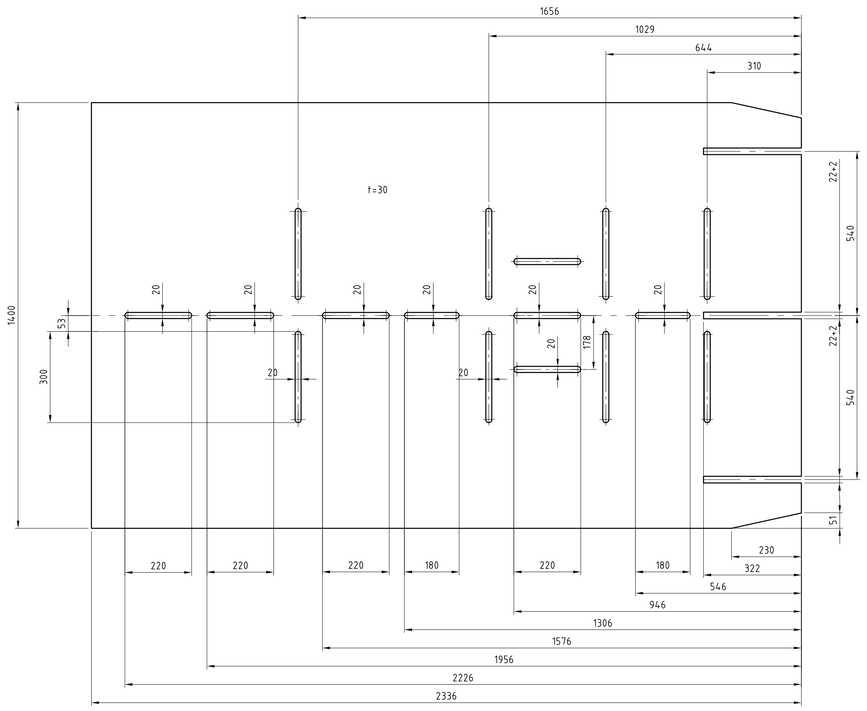
Pos. 1 1x



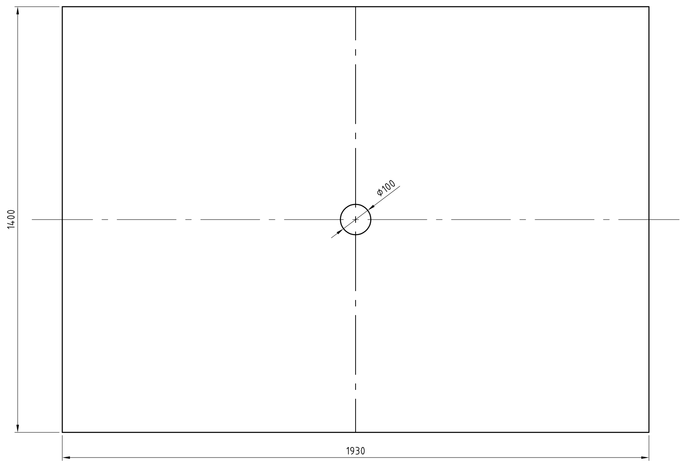
Pos. 12 1x ohne Bohrung ø30 / без отверстий
Pos. 22 1x mit Bohrung ø30 / с отверстием



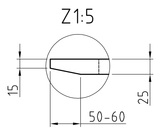
Pos. 2 2x



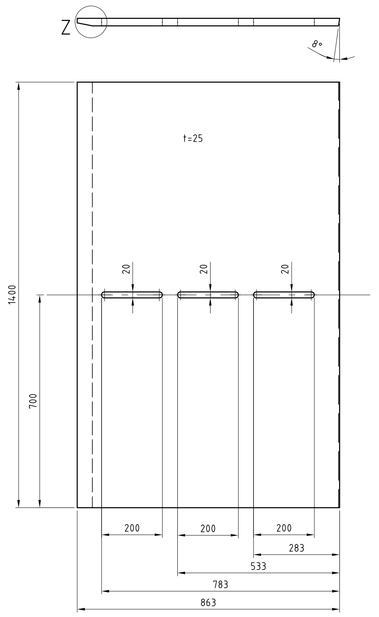
Pos. 3 1x



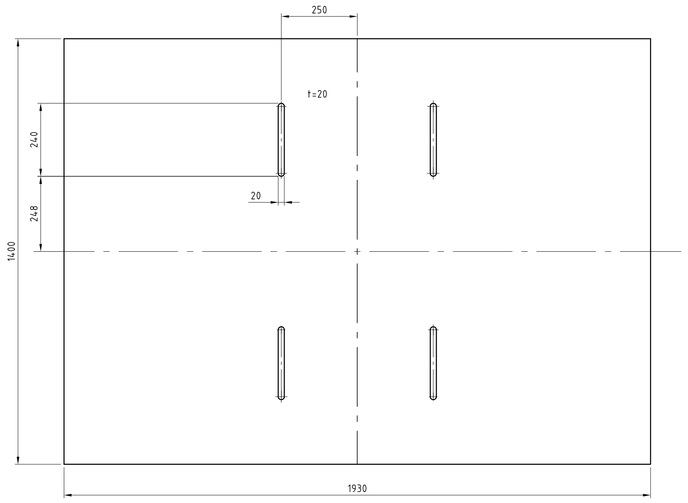
Z1:5



Pos. 4 2x

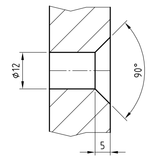


Pos. 5 1x



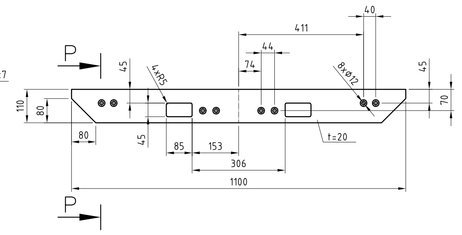
P–P

M 1:1
gilt für alle 8 Bohrungen
распространяется на все 8 отверстий

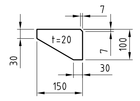


Senkung
сокращение

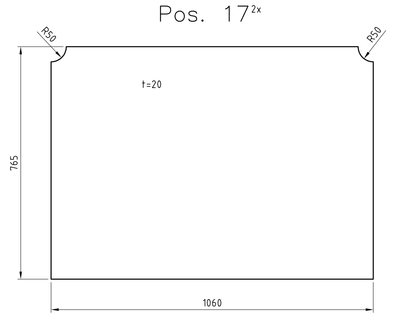
Pos. 6 4x



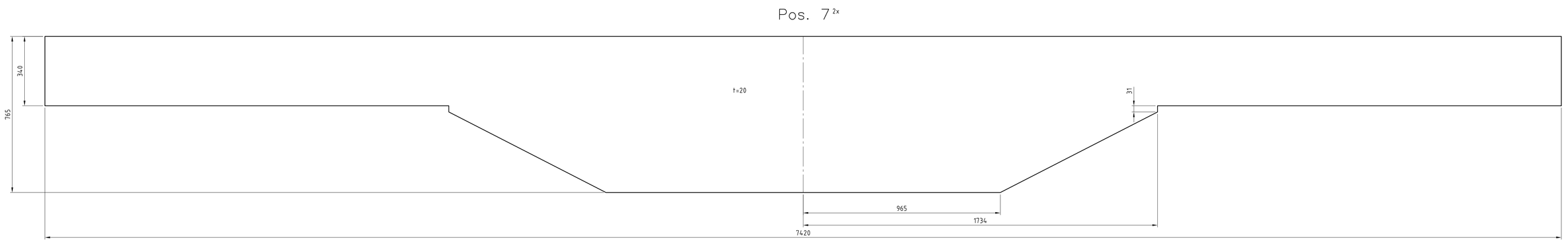
Pos. 16 4x



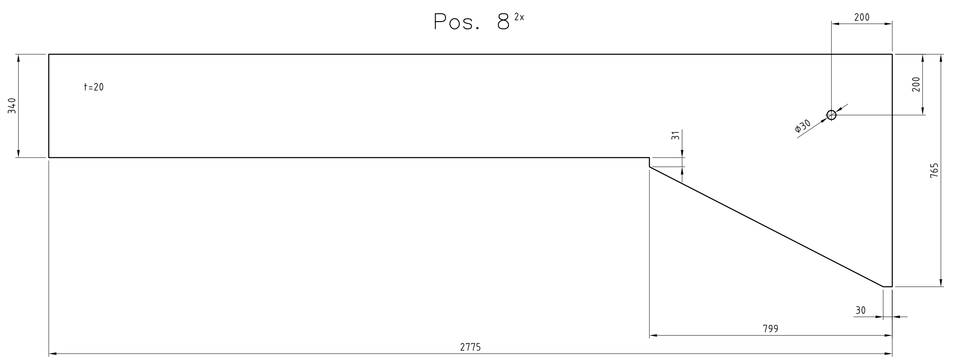
Pos. 17 2x



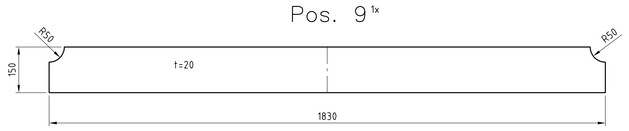
Pos. 7 2x



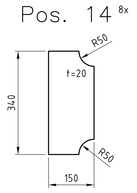
Pos. 8 2x



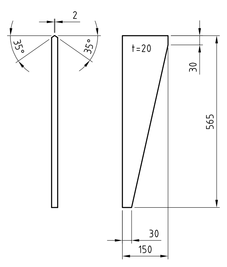
Pos. 9 1x



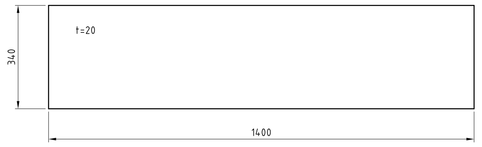
Pos. 14 8x



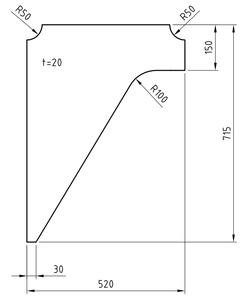
Pos. 10 2x



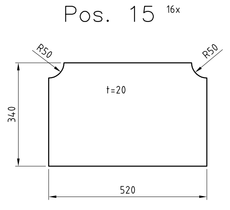
Pos. 13 2x



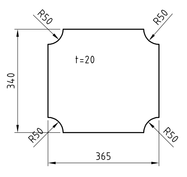
Pos. 19 4x



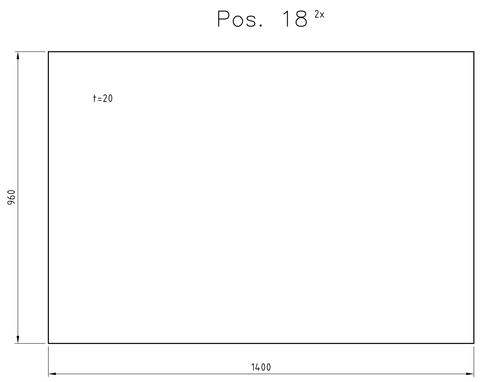
Pos. 15 16x



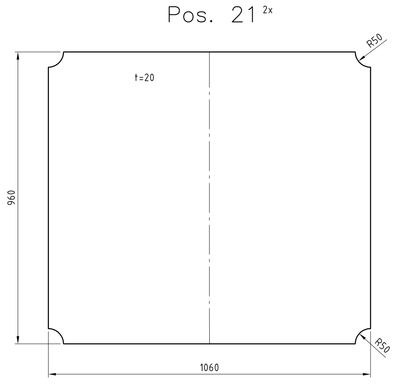
Pos. 11 4x



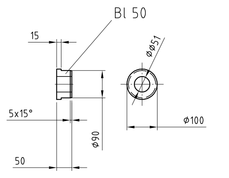
Pos. 18 2x



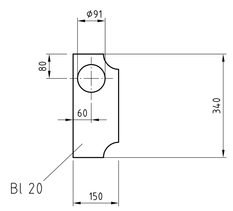
Pos. 21 2x



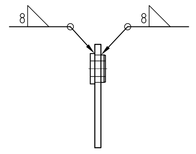
Pos. 23 4x

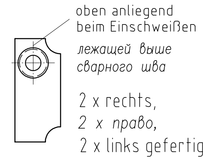


Pos. 20 4x



Pos. 20 + 23





oben anliegend
beim Einschweißen
лежащей выше
сварного шва

2 x rechts,
2 x право,
2 x links gefertigt
2 x остаия
производства

Schnittkanten
Kanten entgratet

25 (6,3)

Bauvorschrift (BV):	DIN 18 800 -7: 2002-09					
Verfahren nach DIN EN ISO 3834:	135(MAG)	Erforderliche Prüfarten/-umfänge Nr. nach DIN EN 1090:				
Konstruktionsstahl: Güte	GL-E36					
Profiltoleranz nach DIN EN 10021:		Bewertungsgruppe nach DIN EN ISO 5817:				
Zusatzwerkstoff:	GAS/I DIN EN 440 M21/ DIN EN 439		"C"			
Wärmebehandlung:		Prüfungen:				
Vorwärmen 150° C beim Schweißen einer Bleche über 20mm Dicke/ Температура при сварке толщиной более			X Sicht	X Hull		
			Darstellungsfreie Prüfung			
Weitere Angaben:						
a=8: 5		Schweißaufsicht:				

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CAD-Zeichnung
Manuelles Ändern nicht gestattet

Allgemeintoleranzen
Mach-Bau-Stahlbau n. DIN 18 708-B
Schalbautoleranzen nach DIN 18 709-B

			Datum	Name
Bearb.			19.07.04	Kaldrack
Gepr.				
Konstr.				
Sachgruppen-Nr.:				
Zust.	Änderung	Datum	Name	

IMG Rostock

EDV Nr.: 265-773

Maßstab 1:10 | Position A0 | Masse: s. Bl. 1

Kielträger, Stahlbau
Стальная конструкция Кильбалки

265-773 RU

Blatt 2
Blz 2

Ers für: