

construction) be annealed, Temperature < 600° C, stress-release without reduction of WLL.

- The complete construction can be annealed stress release at <600°C without reduction of WLL.
- Do not rapidly cool the weld.
- A thorough inspection of the weld should be performed. No cracks, pitting, inclusions, notches or undercuts are allowed. If doubt exists, use a suitable NDT method, such as magnetic particle or liquid penetrant to verify.
- If repair is required, grind out the defect and re-weld using the original qualified procedure.

Welding material

Weld material is to have a minimum tensile strength of 70,000 PSI (such as AWS A5.1 E-7018), following the electrode manufacturer's recommendations. Reference information as below:

MIG arc welding:

Wire diameter 0.8 - 1.2 as per DIN 8559-SG 3, AWS A 5.18.

Important: do not weld in the open air during bad weather

Manual electric:

Direct current supply welding:

Electrodes according to EN ISO 2560-A - E 42 6 B 3 2, AWS A 5.5 : E 8018-G.

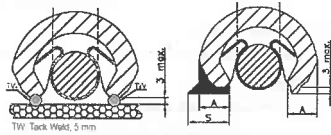
Electrode: root pass and final weld pass, type E5154 B10 as per DIN 1913, used in accordance with the manufacturers.

Alternating current supply welding:

Electrode as per DIN 1913, modified for alternating current use.

HV welding and final weld pass, type E5155 B10.

Specifications:



Art No	Code	WLL (ton)	Thickness A (mm)	Weld Size S (mm)
8-057-1T	DAA1	1.0	10	S = A + 3
8-057-3T	DAA3	3.0	12	S = A + 4
8-057-5T	DAA5	5.0	17	S = A + 5
8-057-8T	DAA8	8.0	18	S = A + 4
8-057-10T	DAA10	10.0	17	S = A + 5
8-057-15T	DAA15	15.0	25	S = A + 7