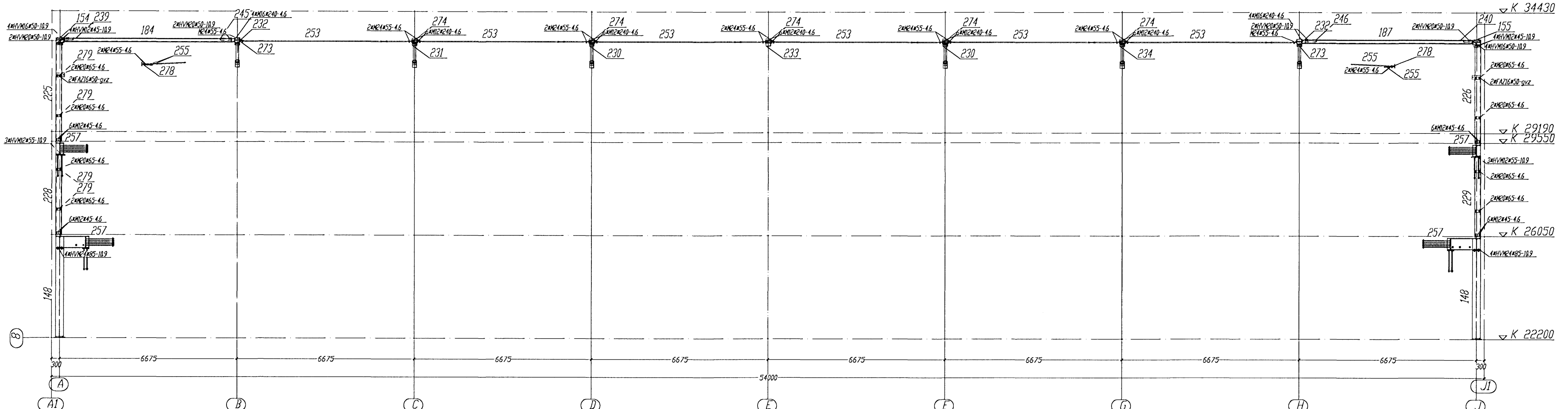
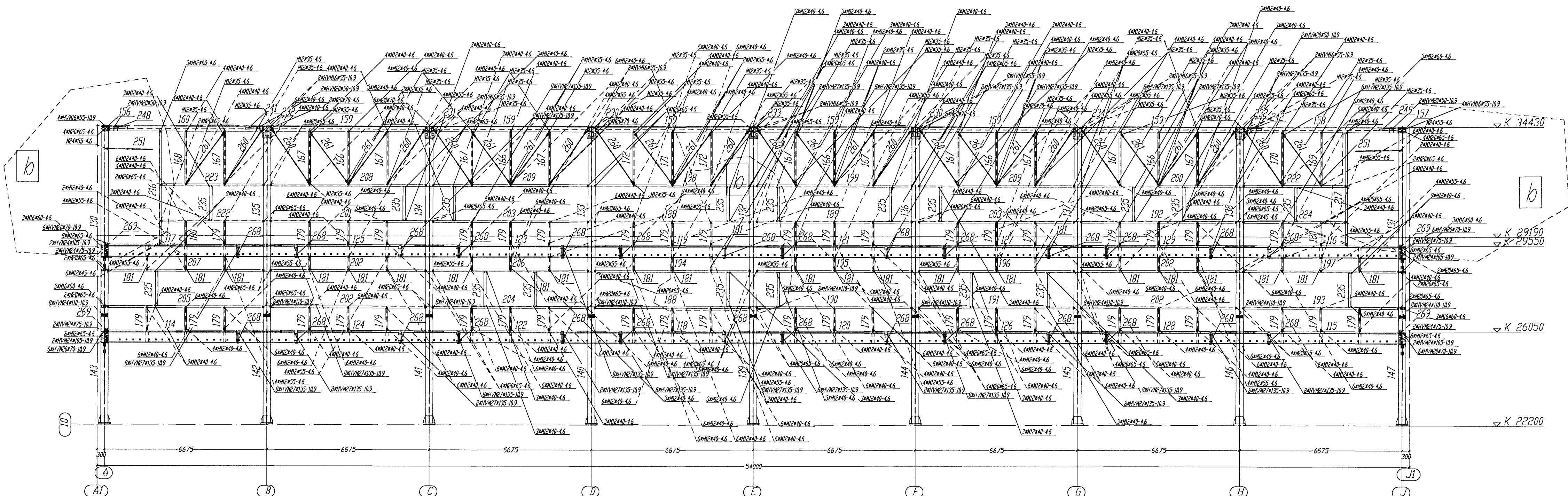


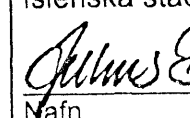
Byggingarhluti af Húsnámsbúi  
 18 FEB 2008  
 VPS



SECTION AXIS 8 Sc. 1:75



SECTION AXIS 10 Sc. 1:75

Fyrir hönd Conis ehf., kt. 600105-1400  
 staðfestist að teikning þessi hefur verið  
 yfirfarin. Teikningin er í samræmi við  
 íslenska staðla og reglugerðir. 28/9/08  
 Ráðgjafi:  Kennitala: 130657-4439

Tolerance for welded constructions According to DIN 8530, Pt 1+3/4/10/87 Welding (VPS) according to DIN EN 288 - 2	Required torques, prestressing forces and forced tension angles according to DIN 18800 Pt. 7, 8/83																																																																												
	<table border="1"> <thead> <tr> <th rowspan="2">Weld</th> <th rowspan="2">Welding process</th> <th rowspan="2">Welding position</th> <th colspan="4">Tension angle <math>\alpha</math> according to</th> </tr> <tr> <th><math>\alpha \le 45^\circ</math></th> <th><math>45^\circ &lt; \alpha \le 60^\circ</math></th> <th><math>60^\circ &lt; \alpha \le 75^\circ</math></th> <th><math>\alpha &gt; 75^\circ</math></th> </tr> </thead> <tbody> <tr> <td rowspan="2">Bolt</td> <td rowspan="2">MIG</td> <td rowspan="2">Vertical</td> <td>0.1</td> <td>0.15</td> <td>0.2</td> <td>0.25</td> </tr> <tr> <td>0.1</td> <td>0.15</td> <td>0.2</td> <td>0.25</td> </tr> <tr> <td rowspan="2">Bolt</td> <td rowspan="2">MIG</td> <td rowspan="2">Horizontal</td> <td>0.1</td> <td>0.15</td> <td>0.2</td> <td>0.25</td> </tr> <tr> <td>0.1</td> <td>0.15</td> <td>0.2</td> <td>0.25</td> </tr> <tr> <td rowspan="2">Bolt</td> <td rowspan="2">MIG</td> <td rowspan="2">Vertical</td> <td>0.1</td> <td>0.15</td> <td>0.2</td> <td>0.25</td> </tr> <tr> <td>0.1</td> <td>0.15</td> <td>0.2</td> <td>0.25</td> </tr> <tr> <td rowspan="2">Bolt</td> <td rowspan="2">MIG</td> <td rowspan="2">Horizontal</td> <td>0.1</td> <td>0.15</td> <td>0.2</td> <td>0.25</td> </tr> <tr> <td>0.1</td> <td>0.15</td> <td>0.2</td> <td>0.25</td> </tr> <tr> <td rowspan="2">Bolt</td> <td rowspan="2">MIG</td> <td rowspan="2">Vertical</td> <td>0.1</td> <td>0.15</td> <td>0.2</td> <td>0.25</td> </tr> <tr> <td>0.1</td> <td>0.15</td> <td>0.2</td> <td>0.25</td> </tr> <tr> <td rowspan="2">Bolt</td> <td rowspan="2">MIG</td> <td rowspan="2">Horizontal</td> <td>0.1</td> <td>0.15</td> <td>0.2</td> <td>0.25</td> </tr> <tr> <td>0.1</td> <td>0.15</td> <td>0.2</td> <td>0.25</td> </tr> </tbody> </table>	Weld	Welding process	Welding position	Tension angle $\alpha$ according to				$\alpha \le 45^\circ$	$45^\circ < \alpha \le 60^\circ$	$60^\circ < \alpha \le 75^\circ$	$\alpha > 75^\circ$	Bolt	MIG	Vertical	0.1	0.15	0.2	0.25	0.1	0.15	0.2	0.25	Bolt	MIG	Horizontal	0.1	0.15	0.2	0.25	0.1	0.15	0.2	0.25	Bolt	MIG	Vertical	0.1	0.15	0.2	0.25	0.1	0.15	0.2	0.25	Bolt	MIG	Horizontal	0.1	0.15	0.2	0.25	0.1	0.15	0.2	0.25	Bolt	MIG	Vertical	0.1	0.15	0.2	0.25	0.1	0.15	0.2	0.25	Bolt	MIG	Horizontal	0.1	0.15	0.2	0.25	0.1	0.15	0.2
Weld	Welding process				Welding position	Tension angle $\alpha$ according to																																																																							
		$\alpha \le 45^\circ$	$45^\circ < \alpha \le 60^\circ$	$60^\circ < \alpha \le 75^\circ$		$\alpha > 75^\circ$																																																																							
Bolt	MIG	Vertical	0.1	0.15	0.2	0.25																																																																							
			0.1	0.15	0.2	0.25																																																																							
Bolt	MIG	Horizontal	0.1	0.15	0.2	0.25																																																																							
			0.1	0.15	0.2	0.25																																																																							
Bolt	MIG	Vertical	0.1	0.15	0.2	0.25																																																																							
			0.1	0.15	0.2	0.25																																																																							
Bolt	MIG	Horizontal	0.1	0.15	0.2	0.25																																																																							
			0.1	0.15	0.2	0.25																																																																							
Bolt	MIG	Vertical	0.1	0.15	0.2	0.25																																																																							
			0.1	0.15	0.2	0.25																																																																							
Bolt	MIG	Horizontal	0.1	0.15	0.2	0.25																																																																							
			0.1	0.15	0.2	0.25																																																																							

BIURO INZYNIERSKIE  
 Marek i Janina MUCHA  
 Usiny, ul. Dpolska 30a, 46-070 Komprachcice tel.071-46 46 757

Drawn by: Checked by: Verified by:	DATE: _____ SCALE: _____ SHEET: _____
--	---

SECTION AXIS 8,10  
 TJARNARVELLIR 11  
 Steel Office part  
 DRG 020 b