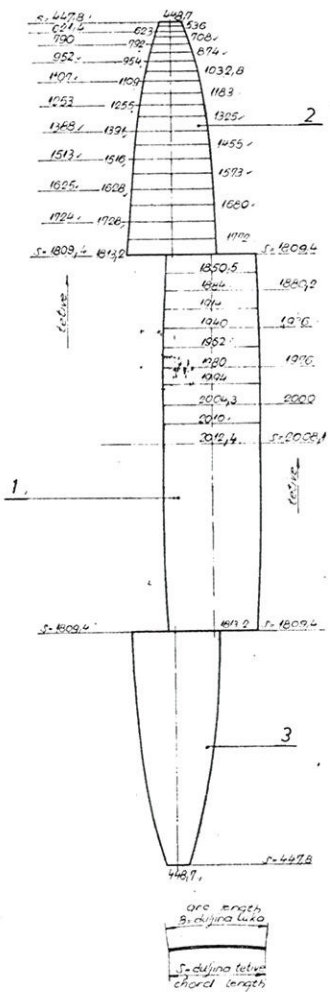
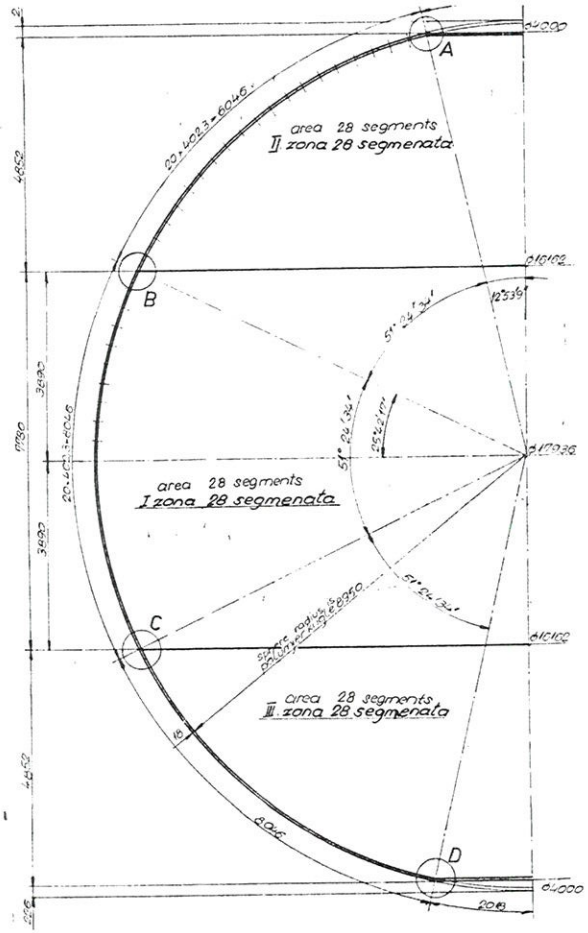
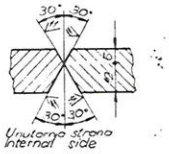


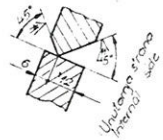




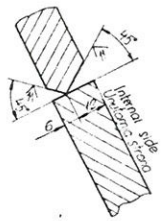
vertical weld
Okomiti var

vaditi korijen
200C

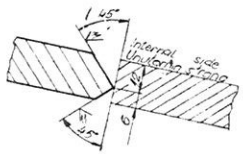
Detail
Detalj - B -
M 1:1



Detail
Detalj - C
M 1:1



Detail
Detalj - D
M 1:1



Note:

1. Material must be with attestation on mechanical propeties and chemical composition
2. Plates shall be examined for uniformity. The plates with irregulovities shall be rejected.
3. All welds to be ultrasonic tested at 100%
4. All joint areas and 30% of weld length to be X-rayed
5. Dimensions are taken from outside of the sphere
6.
7. Plate are around weld to be heated up to 150°-200° before welding
8. Segments pos 2 and pos 3 to be made longer for 100 m and cut and site
9.
10. Segments to be protected against corrosion in 50 mm on edges
11. Any other examination according to be arrangement drawing

Napomena:

1. Materijal mora imati ateste za mehaničke osobine i kemijski sastav
2. Ispitati ravnolatost limova te odbaciti one kod kojih je primjećena
3. Sve varove ispitati ultrazvukom 100%
4. Sva čvorna mjesta i 30% dužine vara snimiti rentgenom
5. Mjere su računate po vanjskoj površini kugle
6. Izvršiti probnu montažu segmenta I i II zone.
7. Zonu limo u okolini zavara prije zavarivanja zagrijati na 150 - 200°C
8. Segmente pos 2/3 na užem kraju izvesti 50 mm duže te na montaži isjeći
9.
10. Segmente uz rubove 50 mm zaštititi od korozije
11. Sva ostala ispitivanja prema dispozicionom nacrtu.

This drawing belongs to arrangement drawing
Ovaj nacrt pripada dispozicionom nacrtu

P03-1562
P01-3034, 3093

Čista težina za izvedbu, a' je. 12.600 kp
Net weight for performance, a' is

Pos.	Naziv i broj dimenzija	Dim.	Broj	Dimenzija sirovca u kg/komad	Ukupna težina po kom.	Opaska
4	Kosi zavar 18, 800 m Elektroda		4		1500	
3	Kružni segment 18, 1809,8 - 2010,8 Novalit		3		39000	
2	Kružni segment 18, 1809,8 - 2010,8 Novalit		2		39000	
1	Kružni segment 18, 1809,8 - 2010,8 Novalit		1		39000	
					Σ=120	

Crtež br. / Izvedba	Naziv i broj dimenzija	DIN / JUS Material	Dim.	Dimenzija sirovca u kg/m	Ukupna težina po kom.	Opaska

Br.	Datum	Sadržaj izmjene	Od pozivnog broja	Potpis
0				

Revizija / Revision

Datum	Ime	Potpis	Original: Sphere Kugla 3000 m³	«DURO DAKOVIĆ» Industrija brodskih vozila, industrijskih i energetskih postrojenja i čeličnih konstrukcija
Projektirao / Konstruirao				
Crtao	Srivard			
Pregledao / Provjerio	9.10.90	Ivanović		
Odobrio	9.10.90	Kirabjev		

Mjerilo 1:50

PLAST KUGLE
SPHERE SHELL

Broj crteža P03-1562-1
Zamjena za
Zamijenio sa

TOLERANCE NEOBIČNOJ MJERI PRI M. AI 418 ZA DIJELOVE GRAĐENE SKIDANJEM STRUGOTINE

Stupanj tolerancije	Područje nazivnih mjera u mm iznad						
	6	30	120	315	1000	2000	4000
	do						
	6	30	120	315	1000	2000	4000
[illegible]	±0,2	±0,3	±0,4	±1,2	±2	±3	±4
[illegible]	±0,1	±0,2	±0,3	±0,8	±1,2	±2	±3
[illegible]	±0,05	±0,1	±0,2	±0,3	±0,5	—	—

Tolerancija mjera