



WARNING!

For welding

Pay attention to the following points during welding:

- _ The welding should be carried out by a qualified welder acc. to DIN EN 287-1.
- _ Material of welding block is St 52-3 (1.0570).
- _ The connecting surfaces must be free from dirt, oil, colour, etc.
- _ Do not weld at the red, powder coated tempered load ring.
- _ The complete construction can be annealed stress-free for several times at 600°C without reduction of WLL.
- _ The welding spot has to be suitable for the corresponding force introduction.
- _ The distance lugs assist in achieving the required root weld (approx. 3 mm).

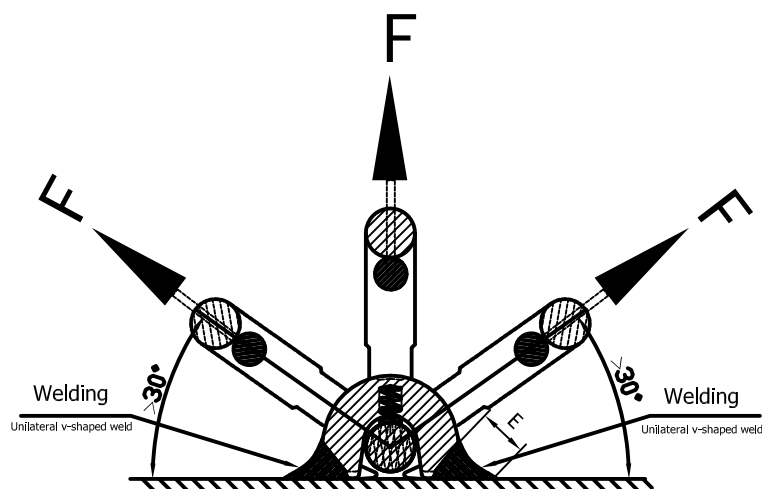
Important

By the arrangement of weld (continuous HV), the following requirements are fulfilled:

DIN 18800 for steel building prescribes

At outdoor sites or in case of special danger of corrosion, the welds should only be designed as continuous, fillet welds. The HV weld at the LBS assures a connection via the whole cross section of the material. This corresponds to the closed weld showing no signs of corrosion.

15T	28
8T	18
5T	16
3T	12
2T	12
1T	10
CODE No	(E) welding bead width



Welding and using schematic diagram of D ring