



WARNING!

For welding

Pay attention to the following points during welding:

- _ The welding should be carried out by a qualified welder acc. to BS EN ISO 9606-1:2017.
- _ Material of welding block is St 52-3 (1.0570) or carbon content max0.42%.
- _ The connecting surfaces must be free from dirt, oil, colour, etc.
- _ Do not weld at the red, powder coated tempered load ring.
- _ During the welding process, it should be avoided as much as possible to heat the weld hook to excess600°C, and the whole set of weld hook accessories can not exceed the normal operating temperature Over 400 °C;
- _ 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 full filled:

DIN EN 1993-1-5 Eurocode 3:Design of steel structures;Part 1-5: Plated structural elements

At outdoor sites or in case of special danger of corrosion, the welds should only be designed as continuous, fillet welds. The V-shaped weld at the weld hook assures a connection via the whole cross section of the material. This ensures that there is no sign of corrosion on the closed weld.

20T	24	34	28
12.5T	16	28	25
8T	14	22	20
5.3T	12	18	15
3.2T	10	14	10
2T	8	14	10
1.1T	6	12	9
CODE No	(S) Min thickness of baseplate	(E) welding bead width	L (Min)

