

Standard conditions for steel structures construction (low-pressure/non-pressure tanks) at CGH Polska Sp. z o.o.

If the customer does not specify and does not determine the "Technical Conditions of Execution and Acceptance of Steel Structure" at the tendering stage and the technical documentation does not state otherwise, products manufactured by CGH Polska Sp. z o.o. meet the following requirements/standards:

1. Quality level of welded joints of structures on the basis of visual tests according to PN-EN ISO 5817 - quality level "C",
2. General tolerances for welded elements - PN-EN ISO 13920:
 - linear and angular measure dimensions - tolerance class "C",
 - straightness, flatness, parallelism - tolerance class "G".
3. Tolerances for execution of parts /machining/ - PN-EN ISO 2768-1 and 2:
 - angle length tolerances - tolerance class "m",
 - tolerances for straightness and flatness, perpendicularity, symmetry and axial symmetry - tolerance class "k".
4. For stainless steel materials, traces of grinding that result from the technology of manufacture and execution of steel structures, as well as conditions of delivery of stainless steels according to PN EN 10088-2; 1D standard are acceptable.
5. Substrate preparation (steel surface):
 - surface preparation by abrasive blast cleaning Sa 2½ according to PN-EN-ISO 8501-1,
 - degree of corrosion "C" according to PN-EN-ISO 8501-1,
 - degree of preparation of welds and other surfaces "P2" according to PN-EN-ISO 8501-3.
6. Anti-corrosion coatings:
 - painting system according to PN-EN ISO 12944-5 that provides protection in corrosivity categories "C3 M",
 - Acceptance according to the 80/20 principle - PN-EN ISO 12944-7.

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1. Quality level of welded joints of structures on the basis of visual tests according to PN-EN ISO 5817 - quality level "B",
2. General tolerances for welded elements - PN-EN ISO 13920:
 - linear and angular measure dimensions - tolerance class "C",
 - straightness, flatness, parallelism - tolerance class "G".
3. Tolerances for execution of parts /machining/ - PN-EN ISO 2768-1 and 2:
 - angle length tolerances - tolerance class "m",
 - tolerances for straightness and flatness, perpendicularity, symmetry and axial symmetry - tolerance class "k".
4. For stainless steel materials, traces of grinding that result from the technology of manufacture and execution of steel structures, as well as conditions of delivery of stainless steels according to PN EN 10088-2; 1D standard are acceptable.
5. Substrate preparation (steel surface):
 - surface preparation by abrasive blast cleaning Sa 2½ according to PN-EN-ISO 8501-1,
 - degree of corrosion "C" according to PN-EN-ISO 8501-1,
 - degree of preparation of welds and other surfaces "P2" according to PN-EN-ISO 8501-3.
6. Anti-corrosion coatings:
 - painting system according to PN-EN ISO 12944-5 that provides protection in corrosivity categories "C3 M",
 - Acceptance according to the 80/20 principle - PN-EN ISO 12944-7.