

Quality standards for steel constructions – tolerances and surface preparation

The standards are defined for tanks and steel constructions belonging to the project, such as platforms, ladders, railings.

The following standards for "Technical Conditions of Execution and Acceptance of Steel Structure" are used at CGH for production of steel constructions, unless

- not stated different in the norms used for the project or
- not specified different by the customer.

1. Welded joints of structures on the basis of visual tests according EN ISO 5817
 - quality level "C"
2. General tolerances for welded elements - EN ISO 13920:
 - linear and angular measure dimensions - tolerance class "C",
 - straightness, flatness, parallelism - tolerance class "G".
3. Tolerances for execution of parts /machining/ - 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:
 - Surface according to EN 10088-2; level 1D, which include traces of grinding as a result from the technology of manufacturing and / or execution of steel structure at the producer.
5. Steel surface preparation:
 - surface preparation by grit-blasting according to EN-ISO 8501-1 in Sa 2½;
 - degree of corrosion before grit-blasting "C" according to EN-ISO 8501-1;
 - degree of preparation of welds and other surfaces "P2" according to EN-ISO 8501-3.
6. Anti-corrosion coatings:
 - painting system acc. to EN ISO 12944-5 under protection in corrosivity categories "C3 M";
 - acceptance according to the 80/20 principle defined in EN ISO 12944-7.