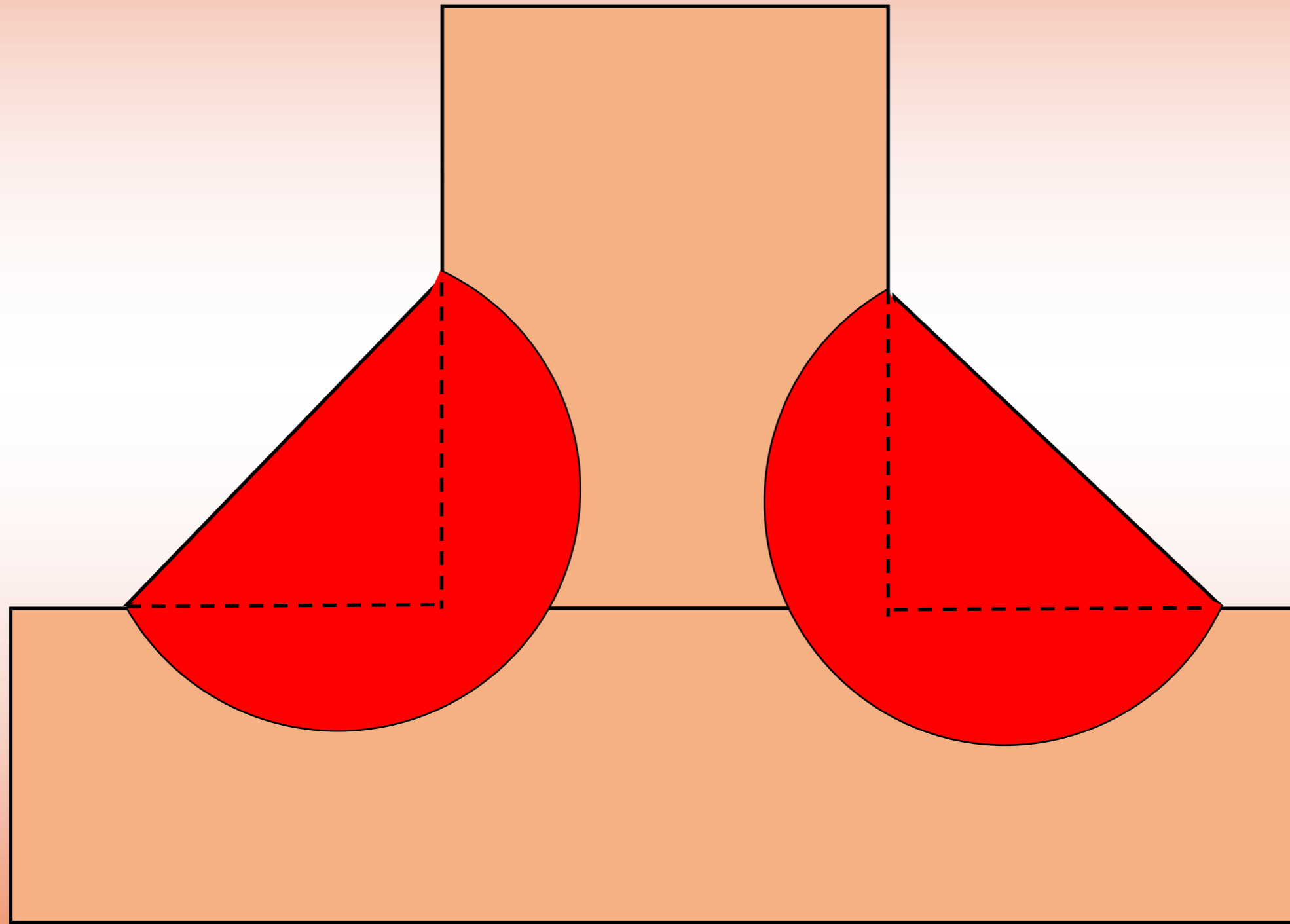
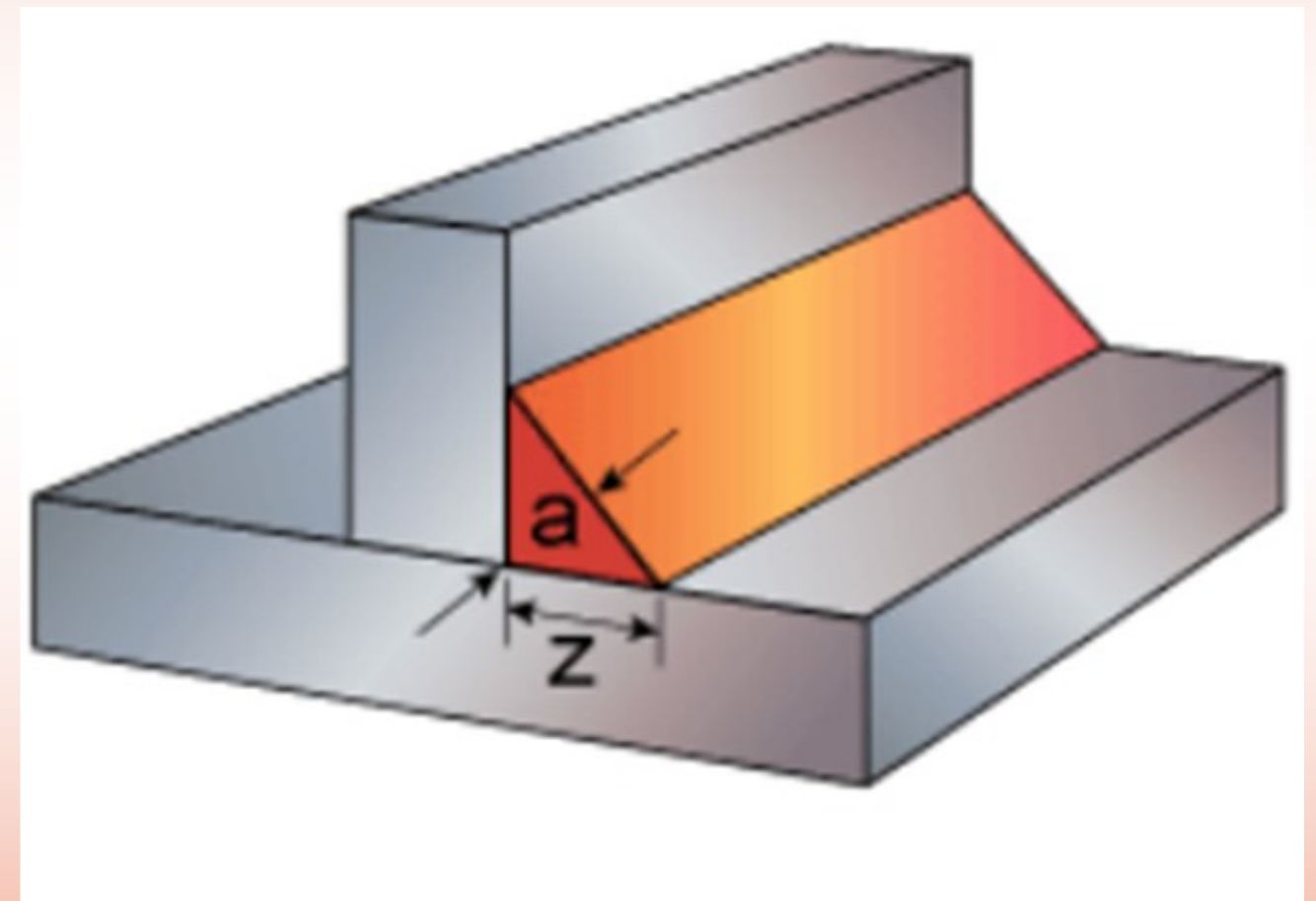
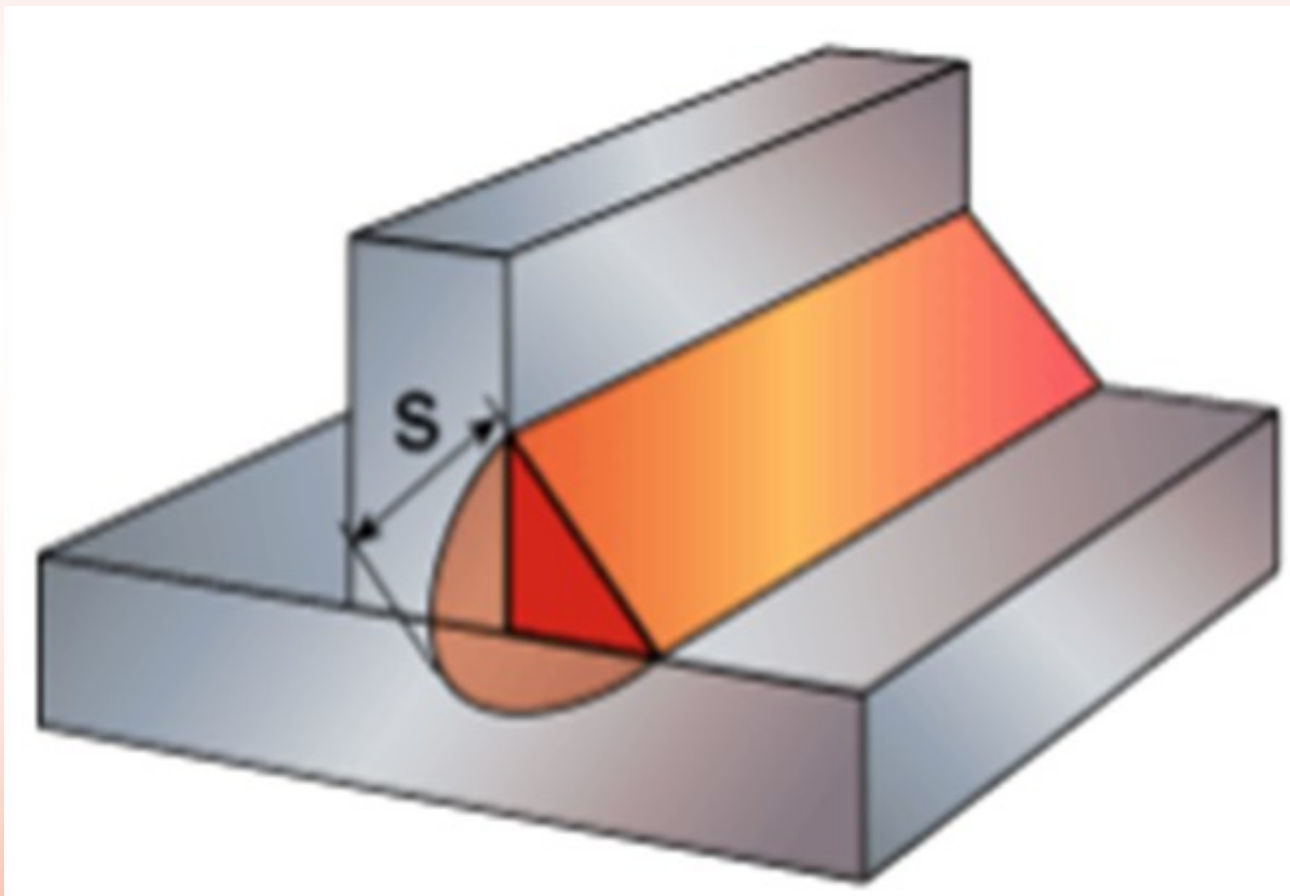


De **a** **Z** en **S** waarde.



De **a** **Z** en **S** waarde.



S 235 JR

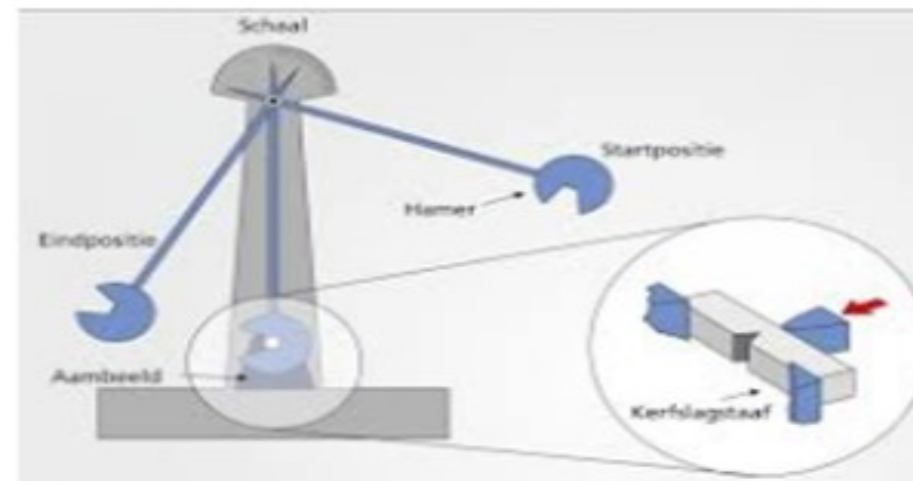
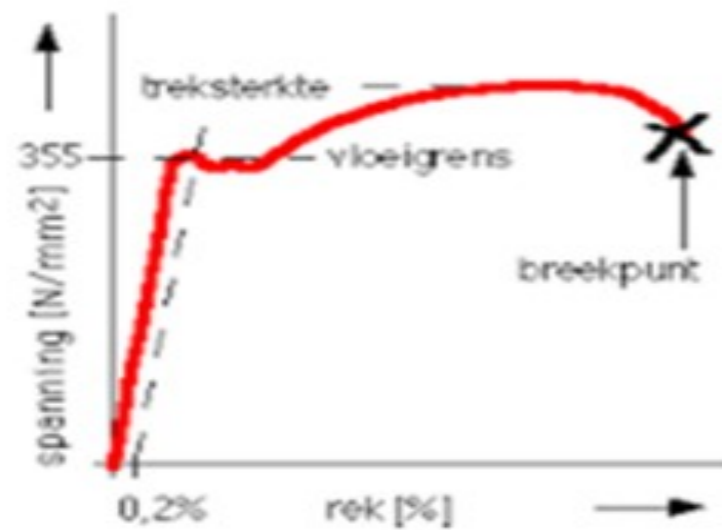
- Verklaring der symbolen

S235JR

- S : symbool voor constructiestaal
- 235 : minimale vloeigrens in N/mm^2
- JR : kerfslagwaarde in Joule bij bepaalde temperatuur

Kerfslagenergie in Joule			Beproevingstemperatuur in °C
eis 27 J	eis 40 J	eis 60 J	
JR	KR	LR	20
J0	K0	L0	0
J2	K2	L2	-20
J3	K3	L3	-30
J4	K4	L4	-40
J5	K5	L5	-50
J6	K6	L6	-60

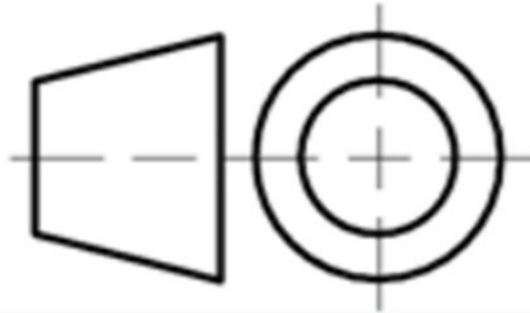
Tabel 2.2.2: Achtervoegsel betreffende eisen voor de kerfslagwaarde



Lassymbolen A of B

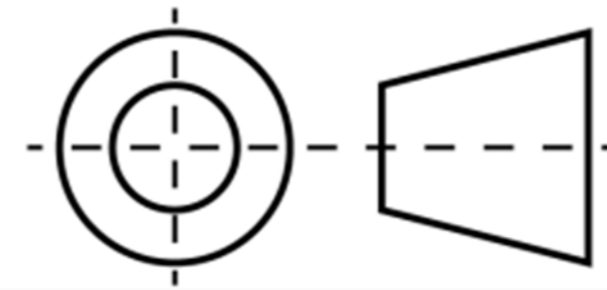
Europese projectiemethode

Wordt voorgesteld met onderstaand symbool.

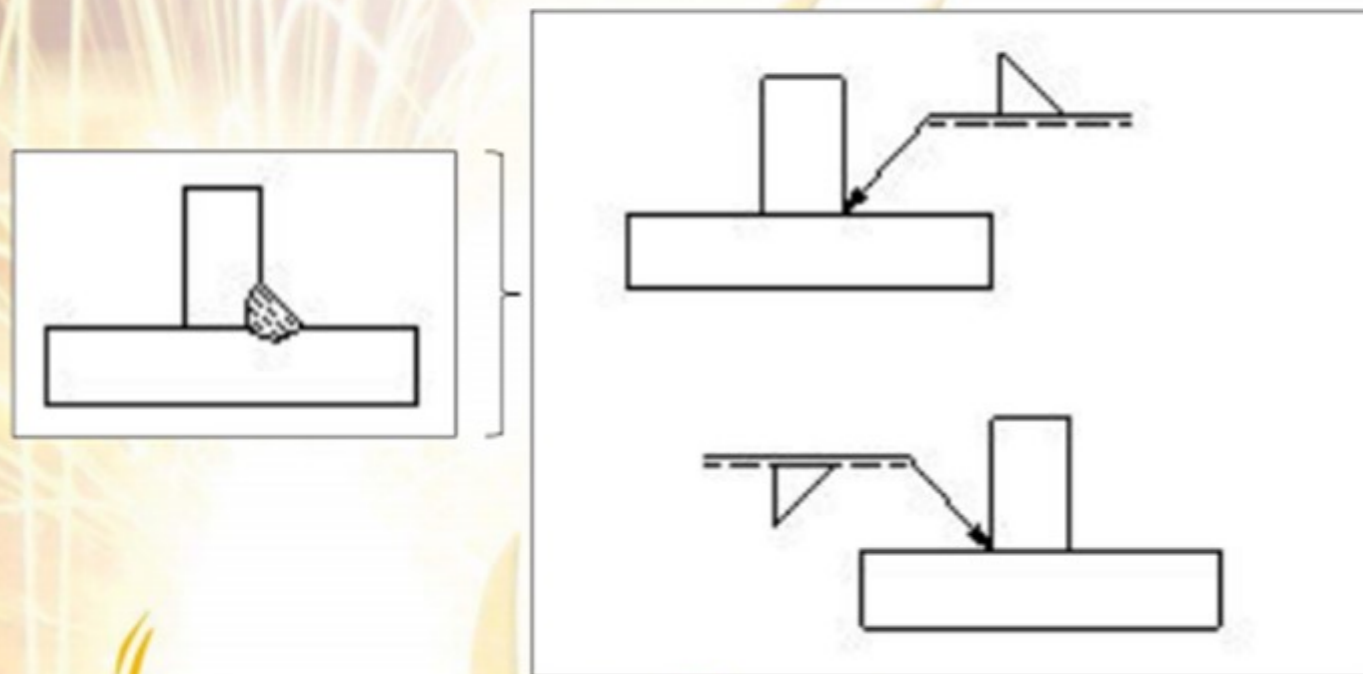


Amerikaanse projectiemethode

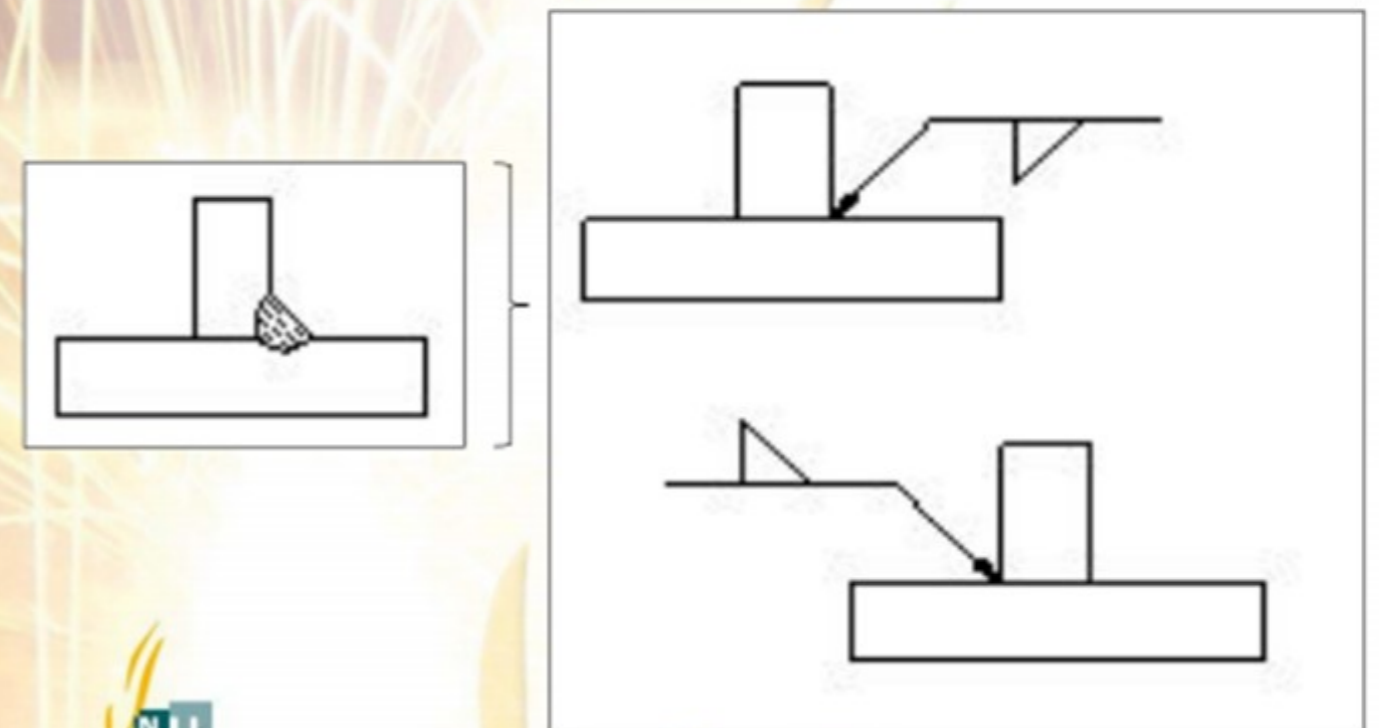
Wordt voorgesteld met onderstaand symbool.



System A



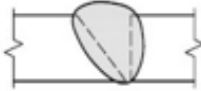
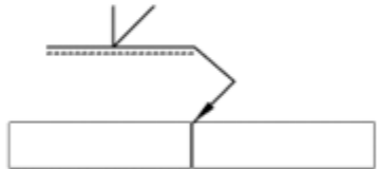
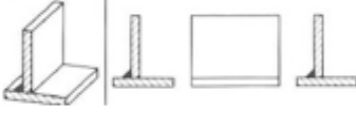
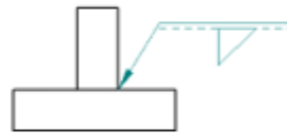



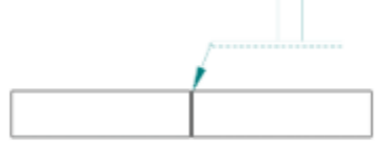

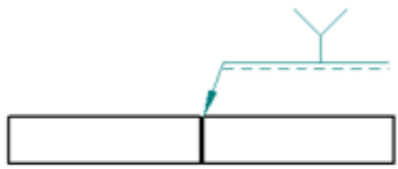

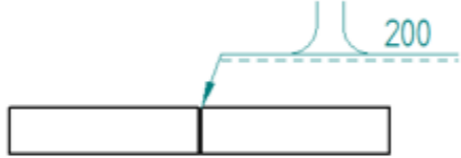
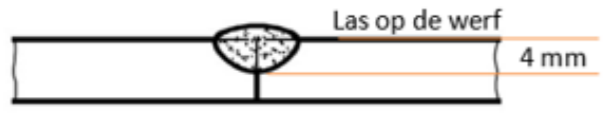

System B



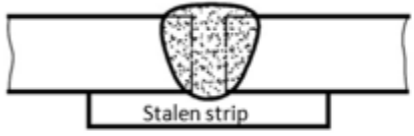
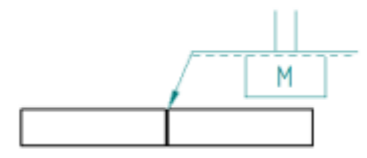
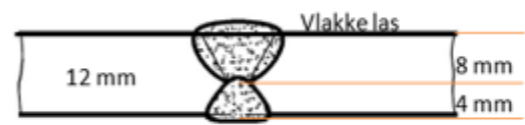
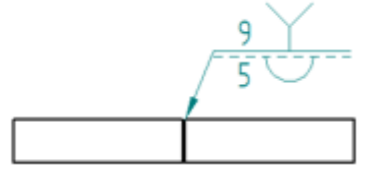
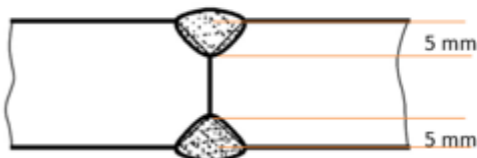


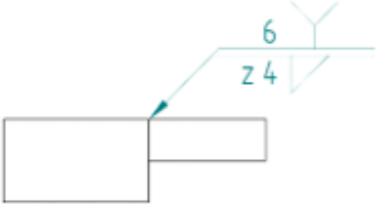




Lassymbolen

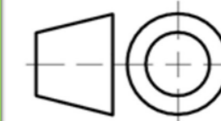


<p>1. Halve V naad met lasvoorbereiding links.</p> 	
<p>2. Hoeknaad aanduiding rechtse zijde.</p> 	
<p>3. Gelaste I naad aan beide zijden</p> 	
<p>4.</p> 	
<p>5.</p> 	
<p>6.</p> 	
<p>7.</p> 	

<p>8.</p> 	
<p>9.</p> 	
<p>10.</p> 	 <p>Waarom geen 8 en geen 4? Omdat de lassen elkaar moeten overlappen!</p> <p>Of</p> <p>onderstaand lassymbool indien de volgorde van belang is.</p>
<p>11.</p> 	 <p>Norm eist 2 x hetzelfde!</p>
<p>12.</p> 	



Lassymbolen

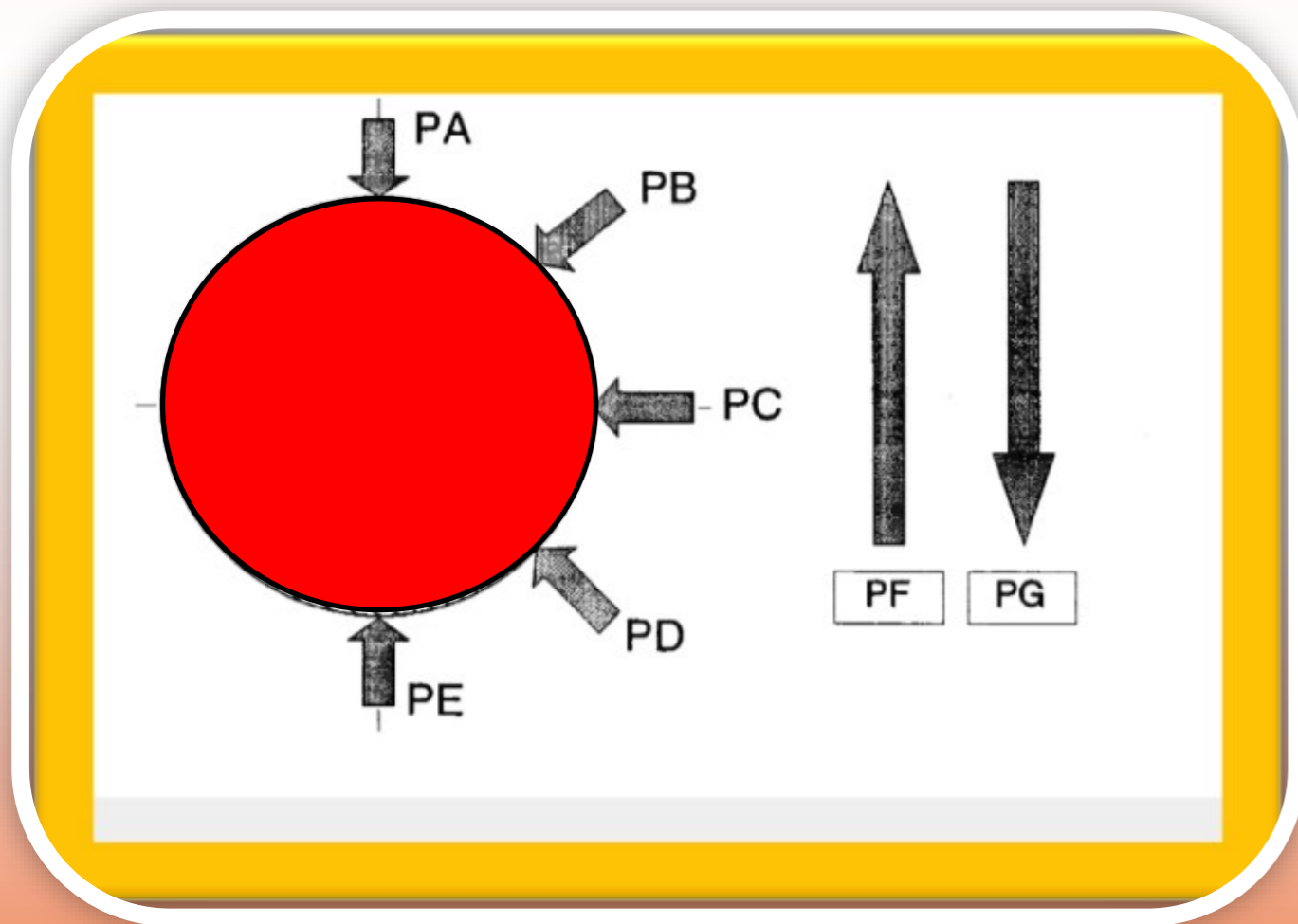


<p>13.</p> <p>2 mm</p>		<p>20.</p>	
<p>14.</p> <p>Keeldoorsnede 6 mm Convex qpp 4 lassen 150 mm lang en 300 mm tussen</p>		<p>21.</p>	
<p>15.</p> <p>Kwaliteitsniveau B volgens ISO 5817</p>		<p>22.</p> <p>MAG gelast massieve draad Lengte 400 mm</p>	
<p>16.</p> <p>Volgens WPS: W58</p> <p>$\alpha = 60^\circ$</p>		<p>23.</p> <p>4 Puntlassen (tussenafstand 50 mm) met diameter 8</p>	
<p>17.</p>		<p>24.</p> <p>Vierkant kokerprofiel rondom gelast op voetplaat op site Met hoeklas keeldoorsnede 5 mm en concaaf lasprofiel Lasproces elektrode</p>	
<p>18.</p> <p>$R 20^\circ$</p> <p>3</p>		<p>25.</p>	
<p>19.</p> <p>Keeldoorsnede 4 mm Convex</p>		<p>26.</p> <p>Maakt niet uit welke lasnaadvoorbereiding Boven vlak afgewerkt na lassen Lengte 100 mm</p>	



Lasposities

Platen



Buizen

