PROTON ENERJİ

Doc. no. :	ITP2023-11
Date :	30.01.2023
Reference :	2023.11
Project :	KP 8
Customer :	Enerteh-V.S.
PO No :	

No.	NAME, METHOD OR TYPE OF INSPECTION OR OPERATION	SPECIFICATIONS ACCEPTANCE NORMS	ACTIVITY	
			PROTON ENERJİ	Customer
1.0	**MATERIALS**			
1.1	Structure Steel Mild Strength Steel: Angle, Channel, Square Tube (Hollow Section)	**DIN EN 10025 - DIN EN 10056-1-2 DIN 1026 S235JR or equivalent**	P	
	High Strength Steel : Angle, Channel, Square Tube (Hollow Section)	**DIN EN 10025 - DIN EN 10056-1-2 S355J2 or equivalent**	P	
1.2	Steel Plates Mild Strength Steel:	**DIN EN 10025 - DIN EN 10029 S235JR or equivalent**	P	
	High Strength Steel :	**DIN EN 10025 - DIN EN 10029 S355J2 or equivalent**	P	
1.3	Material Tests -Mechanical Test -Charpy Impact test	**EN 10025 EN 10045**	P P	R/A/W R/A/W
1.4	DOCUMENTATION Material Certificate, Material Test Report		P	R

A = Approved	H = Hold point
R = Review	M = Monitor
W = Witness	X% = Extent(Random check)
F = First piece	RI = Random inspection
P = Preparation	J = See Note

Notes :

Issued by : Okan TARHAN of PROTON ENERJİ

Issued date : 30.01.2023

Approved by : Şükrü TARHAN of PROTON ENERJİ

Approved date : 30.01.2023

PROTON ENERJİ SANAYİ VE TİCARET ANONİM ŞİRKETİ
Alcı OSB Mah. 2150 Cad. No: 12 Sincan / ANKARA
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Ticaret Sicil No: 122607 Sermaye: 15.000.000 TL
Sincan V.D. 733 076 78 04

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2.0	**BOLT, NUT AND WASHER**			
2.1	Inspection Routine	**DIN 931 Class 5.8 / EN ISO 4014**	P	
	Bolts	**DIN 934 Class 5 K**	P	
	Nuts	**DIN 126**	P	
	Plain Washers	**DIN 127**	P	
	Spring Washers		P	
			P	
			P	
2.2	Bolts Nuts and Washers - Hot Dip Galvanized	**EN ISO 1461**	P	
2.3	U-bolt or shackles (if require)			
2.4	Material Tests	**EN ISO 898-1**	P	R/A/W
	-Mechanical Test / Bolts	**EN ISO 898-2**	P	R/A/W
	-Mechanical Test / Nuts			
2.5	DOCUMENTATION Material Certificate, Material Test Report		P	R

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3.0	**FABRICATION**			
3.1	Workmanship			
3.2	Punching	**Max thickness = 12 mm**		
3.3	Hole Diameter	**Bolt Diameter + 2mm**		
3.4	DOCUMENTATION Member Inspection Report (Dimension Inspection Report)			

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Notes :
*(Code of Standard Practice for Steel Buildings and Bridges)
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Approved date : 30.01.2023

PROTON ENERJİ ANONİM ŞİRKETİ
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PROTON ENERJİ		Doc. no. :	ITP2023-11	
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		Reference :	2023.11	
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No.	NAME, METHOD OR TYPE OF INSPECTION OR OPERATION	SPECIFICATIONS ACCEPTANCE NORMS	ACTIVITY	
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4.0	**HOT DIP GALVANIZING**			
4.1	Hot Dip Galvanizing General	**EN ISO 1461 (ASTM A123 / A123M-09 / A385 - 03)**	P/RI/M	RI
	Zinc Coating thickness			
	Steel Members			
	t ≥ 6 mm.	**Av. thickness : 85 µm - Min thickness : 70 µm**		
	t < 6 mm.	**Av. thickness : 70 µm - Min thickness : 55 µm**		
	Nuts, Bolts and Washer	**Av. thickness : 50µm - Min thickness : 40µm**		
4.2	Tests			
	Weight of zinc coating	**ASTM A90 / A90M - 09**	P/J	W
	Adherence Test	**ASTM A153/A153M-09**	P/J	W
	Embrittlement Test	**ASTM A143/A143M-07**	P/J	W
	Uniformity Test	**ASTM A239-95(2009)e1**	P/J	W
	Thickness of coating tests	**ASTM A90 / A90M - 09**	P/J	W
4.3	DOCUMENTATION			
	Galvanizing Test Reports		P	R
	Zinc Thickness Measurement Results		P	R

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Notes :
One set of test shall be carried out for each 50 tons of steel passing through the fabrication plant.

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5.0	**PACKING - MARKING AND SENDING**			
5.1	Standard Procedure			
	Marking		P	R/A
	Wooden box		P	
	Delivery	**EXWORK/ANKARA**	P	
5.2	DOCUMENTATION			
	Packing List		P/R/A/H	R

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Mersis No: 0733 3578 [illegible] 00001
Sincan V.D.: 733 076 78 84

Digitally signed by Chirița Andrei
Date: 2024.04.08 10:03:41 EEST
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