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| Doc. no. : ITP2023-11 | | Date : 30.01.2023 | |
| Reference : 2023.11 | | Project : UH10-4+5 | |
| Customer : Enerjeh-V.S. | | FO No. : | |
| 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 | |
| High Strength Steel : Angle, Channel, Square Tube (Hollow Section) | | DIN EN 10025 - DIN EN 10056-1-2 S355J2 or equivalent | |
| 1.2 Steel Plates Mild Strength Steel: | | DIN EN 10025 - DIN EN 10029 S235JR or equivalent | |
| High Strength Steel : | | DIN EN 10025 - DIN EN 10029 S355J2 or equivalent | |
| 1.3 Material Tests -Mechanical Test -Charpy Impact test | | EN 10025 EN 10045 | |
| 1.4 DOCUMENTATION Material Certificate, Material Test Report | | P R | |
| Notes : | | | |
| Issued by : Okan TARRHAN of PROTON ENERJİ | | | |
| Issued date : 30.01.2023 | | | |
| Approved by : Sükrü TARRHAN of PROTON ENERJİ | | | |
| Approved date : 30.01.2023 | | | |

A = Approved
R = Review
W = Witness
F = First piece
P = Preparation

H = Hold point
M = Monitor
X% = Extent(Random check)
RI = Random Inspection
J = See Note



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| No. | | NAME, METHOD OR TYPE OF INSPECTION OR OPERATION | Doc. no. : Date : Reference : Project : Customer : | ITP2023-11 30.01.2023 2023-11 U110-1+5 Enerjeh-V.S. |
| 2.0 | | BOLT, NUT AND WASHER | PO No. : | |
| 2.1 | | Inspection Routine | SPECIFICATIONS ACCEPTANCE NORMS | ACTIVITY |
| 2.2 | | Bolts and Washers - Hot Dip Galvanized | DIN 931 Class 5.8 / EN ISO 4014 DIN 934 Class 5 K DIN 126 DIN 127 | PROTON ENERJI Customer |
| 2.3 | | Up-bolt or shackles (if require) | EN ISO 14661 | P P P P P P |
| 2.4 | | Material Testis -Mechanical Test / Bolts -Mechanical Test / Nuts | EN ISO 898-1 EN ISO 898-2 | P P P P P P |
| 2.5 | | DOCUMENTATION Material Certificate, Material Test Report | | R/ANW R/ANW R/ANW |
| A = Approved R = Review W = Witness F = First piece P = Preparation | | H = Hold point M = Monitor X% = Extent(Random check) RI = Random Inspection J = See Note | Notes : | |
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| NAME, METHOD OR TYPE OF INSPECTION OR OPERATION | SPECIFICATIONS ACCEPTANCE NORMS | ACTIVITY |
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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) | | |
| A = Approved R = Review W = Witness F = First piece P = Preparation | H = Hold point M = Monitor X% = Extent(Random check) RI = Random Inspection J = See Note | Notes : *(Code of Standard Practice for Steel Buildings and Bridges) Issued by : Okan TARHAN of PROTON ENERJİ Issued date : 30.01.2023 Approved by : Sükrü TARHAN of PROTON ENERJİ Approved date : 30.01.2023 |



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| 4.0 HOT DIP GALVANIZING | |
| 4.1 Hot Dip Galvanizing General | |
| Zinc Coating thickness Steel Members t ≥ 6 mm. t < 6 mm. | EN ISO 1461 (ASTM A123 / A123M-09 / A385 - 03) |
| Nulls, Bolts and Washer | Av. thickness : 85 µm - Min thickness : 70 µm Av. thickness : 70 µm - Min thickness : 55 µm Av. thickness : 50µm - Min thickness : 40µm |
| 4.2 Tests | P/U |
| Weight of zinc coating | P/U |
| Adherence Test | W |
| Embedment Test | P/U |
| Uniformity Test | P/U |
| Thickness of coating tests | W |
| 4.3 DOCUMENTATION | P |
| Galvanizing Test Reports | P |
| Zinc Thickness Measurement Results | R |
| 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 | | |
| Wooden box | | |
| Delivery | | |
| | EXWORK/ANKARA | P P P |
| | | RA |
| 5.2 DOCUMENTATION | | |
| Packing List | | P/RA/H |
| | | R |
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