



BALLESTRA S.p.A
MILANO (ITALIA)

PREPAR. DEI LEMBI PER SALDAT. DI CORPI,
FONDI FISSI CON DIAM. SUPER. A 350 mm

EDGE PREPARATION FOR SHELL WELDING,
FIXED BOTTOMS WITH DIAMETER HIGHER THAN 350 mm.

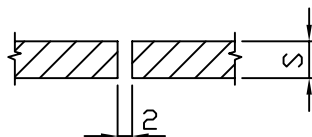
DIS. SP.1344

SHEET 1 OF 4

REV.	DESCRIPTION	DATE
1	ENGLISH TRANSLATION	05/11/2010

1

SPESSORI $S = 3$ mm
THICKNESS

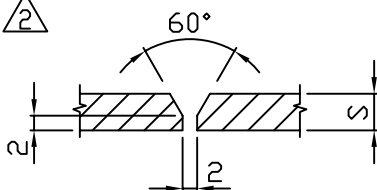


MATERIALI: -TUTTI / ALL
MATERIAL

SALDATURE: -TIG
WELDING -AE
-TIG + AE

2

SPESSORI $S = 4$ mm
THICKNESS

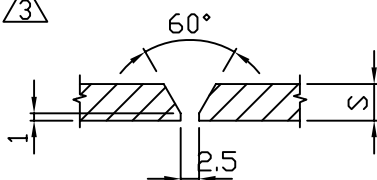


MATERIALI: -TUTTI / ALL
MATERIAL

SALDATURE: -TIG
WELDING -AE
-TIG + AE

3

SPESSORI $S = 5-2b$ mm
THICKNESS

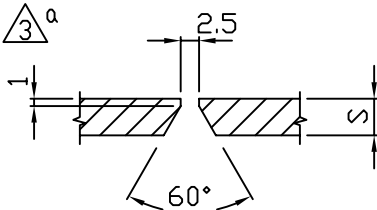


MATERIALI: -TUTTI / ALL
MATERIAL

SALDATURE: -TIG
WELDING -AE + AUTOMAT.
-TIG + AE + AUTOMAT.
-TIG + AE

3^a

SPESSORI $S = 5-2b$ mm
THICKNESS

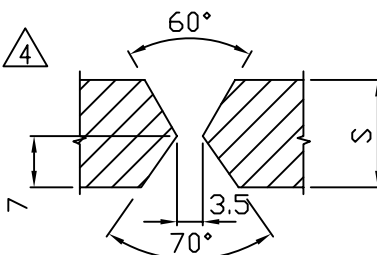


MATERIALI: -TUTTI / ALL
MATERIAL

SALDATURE: -AE + AUTOMAT.
WELDING

4

SPESSORI $S = 21-30$ mm
THICKNESS



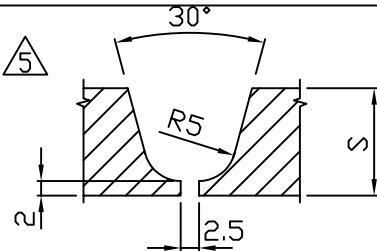
MATERIALI: -TUTTI / ALL
MATERIAL

ESCLUSI: -ACCIAI AL Cr. > 6%
EXCEPT -STEELS WITH Cr. > 6%

SALDATURE: -TIG
WELDING -AE + AUTOMAT.

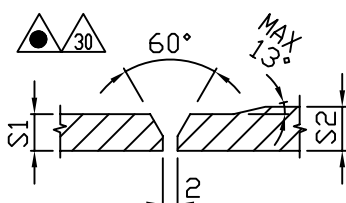
5

SPESSORI $S = 21-30$ mm
THICKNESS



MATERIALI: -SOLO PER ACCIAI AL
MATERIAL Cr SUPERIORI AL 6%
-ONLY FOR STEELS
HAVING Cr. > AU 6%

SALDATURE: -TIG + AE
WELDING -TIG + MIG
-AE
-AE + AUTOMAT.
-TIG + AE + AUTOMAT.



LA RASTREMATURA E'
PREVISTA QUANDO:
 $S2 - S1 > S1/4$ OPPURE
 $S2 - S1 > 3$ (1/8")



PREPARAZIONE CHE
COMPETE LO
SPESSORE "S"



PREPARATION
PERTINENT
TO THICKNESS "S"

TAGGING IS FORESEEN WHEN:
 $S2 - S1 > S1/4$ OR
 $S2 - S1 > 3$ (1/8")