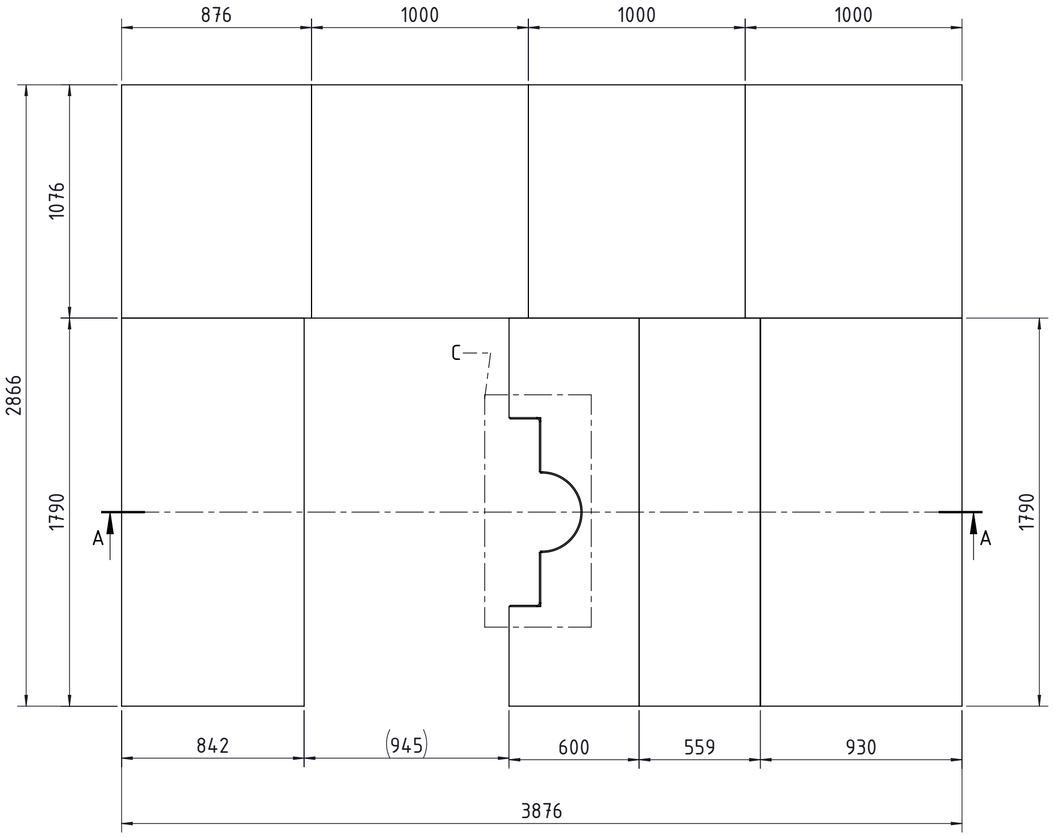
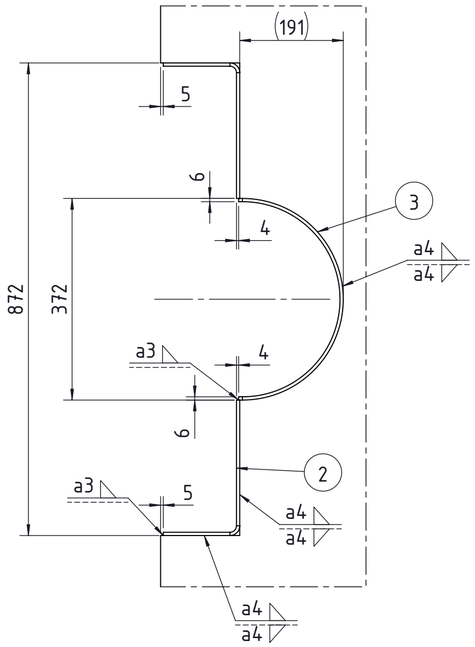
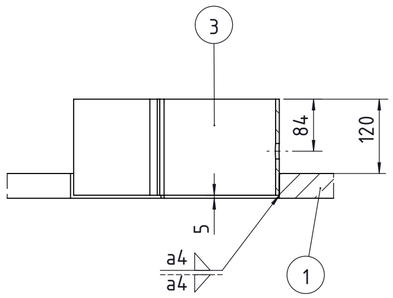


SECTION A-A





DETAIL C
SCALE 1 : 8



DETAIL B
SCALE 1 : 7

GENERAL TOLERANCES
ISO 2768-1 EN ISO 13920 EN ISO 9013 DIN 6935

Values in millimetres

	Basic size range												
LINEAR DIMENSIONS	> 0,5 ≤ 3	> 3 ≤ 6	> 6 ≤ 30	> 30 ≤ 120	> 120 ≤ 400	> 400 ≤ 1000	> 1000 ≤ 2000	> 2000 ≤ 4000	> 4000 ≤ 8000	> 8000 ≤ 12 000	> 12 000 ≤ 16 000	> 16 000 ≤ 20 000	> 20 000
Machining ISO 2768-m	± 0,1	± 0,1	± 0,2	± 0,3	± 0,5	± 0,8	± 1,2	± 2					
Chamfers and external radii	± 0,2	± 0,5	± 1										
Welding ISO 13920-B	± 1 (Range 2-30)			± 2	± 2	± 3	± 4	± 6	± 8	± 10	± 12	± 14	± 16

Thermal cutting ISO 9013-2	≥ 3 < 10	≥ 10 < 35	≥ 35 < 125	≥ 125 < 315	≥ 315 < 1000	≥ 1000 < 2000	≥ 2000 < 4000	Quality of cut surface ISO 9013-44
3,15 < t ≤ 6,3	± 0,7	± 0,8	± 0,9	± 1,1	± 1,2	± 1,3	± 1,3	
6,3 < t ≤ 10	± 1	± 1,1	± 1,3	± 1,4	± 1,5	± 1,6	± 1,7	
10 < t ≤ 50	± 1,8	± 1,8	± 1,8	± 1,9	± 2,3	± 3	± 4,2	

ANGULAR DIMENSIONS	Shorter side ≤ 10	> 10 ≤ 50	> 50 ≤ 120	> 120 ≤ 400	> 400 ≤ 1000	> 1000
Machining ISO 2768-m	± 1°	± 0°30'	± 0°20'	± 0°10'	± 0°5'	
Welding ISO 13920-B	± 13 mm/m				± 9 mm/m	± 6 mm/m
Bending	SEE DIN 6935					
GEOMETRICAL TOLERANCES	Machining ISO 2768-K		Welding ISO 13920-F			

QUALITY AND ACCEPTANCE LEVELS FOR WELDING OF STEEL CONSTRUCTIONS

QUALITY LEVELS ACC. TO STANDARD ISO 5817	EXAMINATION PROCEDURES, EXAMINATION LEVELS AND ACCEPTANCE LEVELS OF WELD JOINTS ACC. TO ISO 17635	COMPLEMENTARY INDICATIONS
QUALITY LEVEL		INDICATION OF WELDS WITH QUALITY LEVELS THAT DIFFERS FROM GENERAL REQUIREMENT
D		EXAMPLE a5 300 111 / B (WELDING PROCESS ACC. TO ISO 4063; QUALITY LEVEL ACC. TO ISO 5817)
C	GENERALLY REQUIRED QUALITY LEVEL, IF NOT OTHERWISE SPECIFIED IN DRAWING	
B		

PART	DESCRIPTION	SUB_DWG.NO.	QTY	WEIGHT [kg]	ITEM NO.	REMARKS
3	KICK PLATE	OU601845082	1	4.28		
2	KICK PLATE	OU601845083	2	2.76		
1	GRATING TankCell® e30	OU601845080	1	324		

DIMENSIONS & BASIC MATERIAL — WEIGHT 334.09 kg

REV.	PREPARED NAME	PREPARED DATE	CHECKED NAME	CHECKED DATE	APPROVED NAME	APPROVED DATE	REVISION TEXT
0	JorLeh	21.02.2022	pekkall	21.02.2022	AntEte	21.02.2022	FOR FABRICATION

Metso:Outotec

DOCUMENT TITLE
WELDING DRAWING
GRATINGS
TANK MAIN ASSEMBLY
TankCell® e30

REPLACED BY

REPLACES

LANGUAGE	UNITS	SCALE	SIZE	SHEET OF SHEETS
EN	mm	1:20	A2	1 / 1

THIS INFORMATION IS CONFIDENTIAL AND PROPRIETARY TO METSO OUTOTEC CORPORATION OR ITS SUBSIDIARIES ("METSO OUTOTEC") AND IS PROTECTED BY TRADE SECRET, COPYRIGHT AND/OR OTHER LAWS. IT MAY NOT BE ACCESSED, USED, COPIED OR DISCLOSED WITHOUT THE WRITTEN CONSENT OF METSO OUTOTEC. ALL RIGHTS RESERVED.

DOCUMENT ID OU601845081 — REVISION 0