

1		2		3		4		5		6		7		8	
No	Подготовка на краищата	Вид на зав. съединение	Термообработка	Добавъчни материали	Материал	Корен на шев	Запълване								
W1				BOHLER SAS 2-IG EN ISO 14343-A: W 19 9 Nb	Ø1820x10 Ø610x12 1.4541 X6CrNiTi18-10	SG (GTAW)	E (SMAW)								
				BOHLER SAS 2 EN 1600:1997 E 19 9 Nb B 2 2											
W2				BÖHLER FOX HL 160 Ti EN ISO 2560-A: E 38 0 RR 54	Ø1820x10 1.4541 X6CrNiTi18-10	SG (GTAW)	E (SMAW)								
W3				BOHLER SAS 2-IG EN ISO 14343-A: W 19 9 Nb	Ø720x10 Ø610x10 1.4541 X6CrNiTi18-10	SG (GTAW)	E (SMAW)								
				BOHLER FOX SAS 2 EN 1600:1997 E 19 9 Nb B 2 2											
W4				BOHLER SAS 2-IG EN ISO 14343-A: W 19 9 Nb	89x5 1.4541 X6CrNiTi18-10	SG (GTAW)	SG (GTAW)								
W5				BOHLER SAS 2-IG EN ISO 14343-A: W 19 9 Nb	Ø610x12,5 Ø426x14 Ø325x12 Ø219x11 1.4541 X6CrNiTi18-10	SG (GTAW)	E (SMAW)								
				BOHLER FOX SAS 2 EN 1600:1997 E 19 9 Nb B 2 2											
W6				BOHLER SAS 2-IG EN ISO 14343-A: W 19 9 Nb	Ø159x8 1.4541 X6CrNiTi18-10	SG (GTAW)	E (SMAW)								
W7				BOHLER SAS 2-IG EN ISO 14343-A: W 19 9 Nb	Ø108x5 Ø89x5 1.4541 X6CrNiTi18-10	SG (GTAW)	E (SMAW)								
W8				BOHLER SAS 2-IG EN ISO 14343-A: W 19 9 Nb	Ø33.7x2.6 1.4541 X6CrNiTi18-10	SG (GTAW)	E (SMAW)								
W9				BOHLER SAS 2-IG EN ISO 14343-A: W 19 9 Nb	Ø17.2x3.2 1.4541 X6CrNiTi18-10	SG (GTAW)	SG (GTAW)								