

## **Load ring (Lastbock) for welding - Operating and welding instructions Latest update May 2022**

### **Operating manual**

- 1.) The components may only be used by instructed and trained persons, subject to the relevant national regulations. In Germany, BGR 500 must be applied.
- 2.) Prior to commissioning, the user of the load rings is obliged to regularly check the ring load rings for cracks in the welding seams, heavy corrosion, wear or deformation etc. Individual tests must be carried out to ensure: completeness of the suspension point - full legibility of the load-bearing capacity and the manufacturer's mark – no deformation on load-bearing parts such as body and a suspension hangers – no mechanical damage such as strong notches, in particular in areas under tensile stress > 10% - no severe corrosion – no cracks in load-bearing parts – no tears or other damage to the welding seams.
- 3.) The place of use is to be selected in such a way that the initiated forces can move from the load ring to the base without causing any deformation. The load ring can be loaded on all sides with the specified load capacity. The welding material must be suitable for welding. Contaminants such as oils, fats, paints, etc. must be removed in advance.
- 4.) The weld-on blocks are made of ST52.3 (1.0570)
- 5.) The location of the load rings must be selected in a way that twisting or turning of the load is avoided. Please refer to the BGI 622 - load tables for lifting gear.
- 6.) The lifting gear must be freely movable in the load ring. No crushing, shearing, catching and blocking may occur when attaching or removing the lifting gear. Damage caused by sharp-edged loads must be excluded.
7. The temperature range for the use of the load rings is -40 to 200°C without requiring a reduction of the load capacity. In temperatures between 200 and 300°C, the load capacity is reduced by 12% and in temperatures between 300 and 400°C by 25%. Use in temperatures above 400°C is excluded.

#### **Anschrift**

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#### **Eintragung**

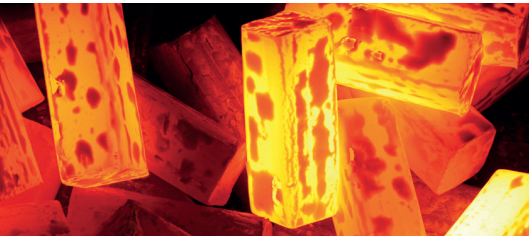
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- 8.) The load rings may not get into contact with aggressive chemicals, acids or their vapours.
- 9.) The distance naps serve as clearance to ensure the necessary air gap towards the root weld (approx. 2.5 mm). They must not be removed.
- 10.) If the load ring is used for lashing only, the specified capacity for the lashing may be doubled.
- 11.) Welding may be performed only by a certified welding expert in accordance with DIN EN ISO 9606-1.
- 12.) Before and during assembling/welding lifting point – the ring has to be place between 45 – 0 - 45 degree concerning vertical reference level .  
After welding the ring can be moved to the maximum.

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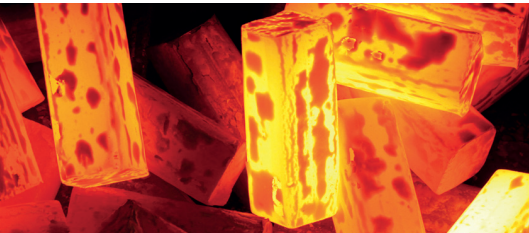
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## Maximum load weight "G" for different hoisting types for load ring GK 10

Hoisting type									
<b>Number of ropes</b>	1	1	2	2	2 symmetrical		3: 4 symmetrical		2; 3; 4
<b>Angle</b>	0°	90°	0°	90°	0°-45°	45° 60°	0° 45°	45°-60°	asymm.
<b>Load-bearing capacity in tons</b>	1,5	1,5	3	3	2,1	1,5	3,15	2,25	1,5
<b>Load-bearing capacity in tons</b>	2,5	2,5	5	5	3,5	2,5	5,25	3,75	2,5
<b>Load-bearing capacity in tons</b>	4	4	8	8	5,6	4	8,4	6	4
<b>Load-bearing capacity in tons</b>	6,7	6,7	13,4	13,4	9,5	6,7	14	10,1	6,7
<b>Load-bearing capacity in tons</b>	10	10	20	20	14	10	21	15	10
<b>Load-bearing capacity in tons</b>	16	16	32	32	22,4	16	33,6	24	16

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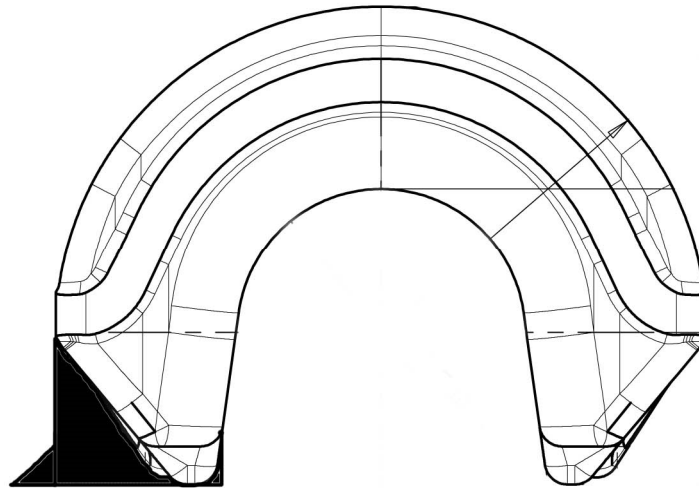
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## Welding seam arrangement



Please note that the **size of the welding seam** depends on the size of the weld-on block

	Size	Length
Load ring 1.5	HV 4 + 3	2 x 35 mm
Load ring 2.5 t	HV 7 + 3	2 x 41 mm
Load ring 4 t	HV 8 + 3	2 x 47 mm
Load ring 6.7 t	HV 12 + 4	2 x 61 mm
Load ring 10 t	HV 16 + 4	2 x 61 mm
Load ring 16 t	HV 25 + 6	2 x 91 mm

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**Welding processes + additives** for Europe, USA, Canada for the material construction steels, low-alloy steels

MAG / MIG	EN 440 G4Si1 e.g. Castolin 45250	AWS: A-5.18 HE 70 S-6 e.g. Eutectic MIG-Tec Tic A88
E-hand DC	EN499 E 426 B32 H5 e.g. Castolin 6666 or 6666N - observe drying instructions	AWS: A 5.5 E8018-G E7016 e.g. Eutectic 6666/35066 CP
E-hand AC	EN499 E 380 RR 12 e.g. of Castolin 35086 CP 6600	AWS: A-5.1 S 6013 e.g. Eutectic Beauty Weld II
WIG	DIN 8575 WSG CrMo1 e.g. Castolin 45252 W	AWS: A 5.18 ER 70 S-6 e.g. Eutectic TIG-Tec-Tic: A 88

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