

Operating and welding instructions for weld-on lifting points GK 8 (Last update: 20.04.2021)

General principles for use:

Falling loads, caused by the failure or incorrect use of lifting gear or its individual parts, involves an indirect threat to life or the health of persons staying in the danger zone of lifting processes. This manual contains those aspects relating to the safe use, associated with good handling, of the weld-on lifting points. Prior to the application of the weld-on lifting points, the responsible persons must be instructed by experts. Weld-on lifting points may not be used in acids or exposed to acid vapours. It should be noted that certain production processes release acids or vapours.

Installation instructions:

The position of the weld-on lifting points to the load are to be executed in such a way that a flat surface is appropriate to receive the expected force transmission.

The weld-on lifting points are to be attached to the load as follows:

- that they can be reached easily and without obstruction for the slopes of the sling.
- that no danger zones (pinching, shearing, catching or shock marks) are created that endanger or hinder the slinger or the transport.
- that inadmissible stress, for example caused by eccentric load and thus uneven load distribution, taking into account the centre of gravity (EN 818-6), is avoided.
- that the sling is not deviated by other construction components and that damage, e.g. due to sharp edges, is excluded.

The number and arrangement must be selected in such a way that the load cannot change its position unexpectedly during transport.

The sling point may not be turned under load or be used to turn the load.

The load ring must be set in the tensile direction and be freely movable and may not prop up on edges or at the sling point.

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Eintragung

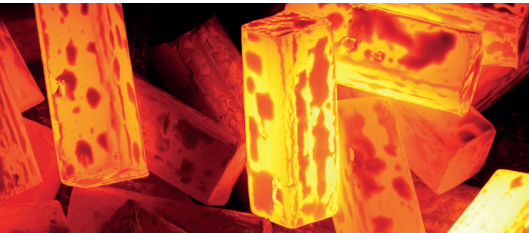
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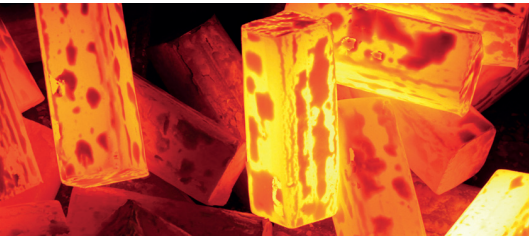


Maximum load weight "G" in various hoisting types for weld-on lifting points GK 8

Hoisting type									
Number of ropes	1	1	2	2	2 symmetrical		3; 4 symmetrical		2; 3; 4
Angle	0°	90°	0°	90°	0°-45°	45°-60°	0°-45°	45°-60°	asymm.
Load in tons	1,12	1,12	2,24	2,24	1,5	1,12	2,36	1,6	1,12
Load in tons	2	2	4	4	2,8	2	4	3	2
Load in tons	3,15	3,15	6,3	6,3	4,25	3,15	6,3	4,75	3,15
Load in tons	5,3	5,3	10,6	10,6	7,1	5,3	11,2	8	5,3
Load in tons	8	8	16	16	11,2	8	16	12	8
Load in tons	15	15	30	30	21,2	15	31,5	22,4	15
Load in tons	20	20	40	40	28,3	20	42	30	20
Load in tons	37,5	37,5	75	75	52	37,5	75	56	37,5

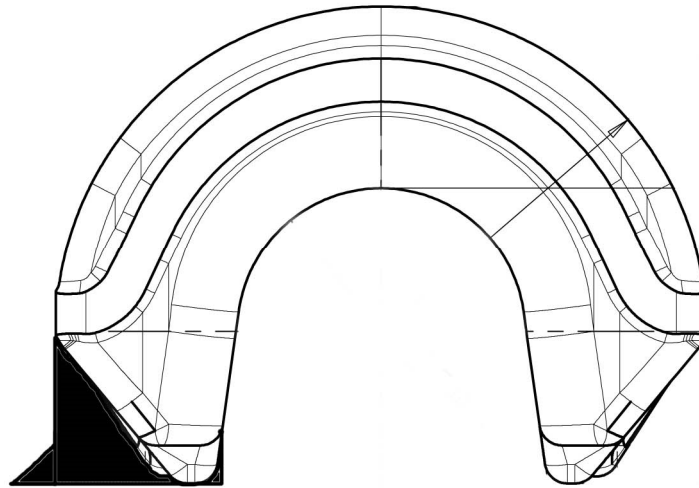
Welding:

- The construction of the weld-on bracket ensures the necessary air gap for the placement of the root pass. Each new pass tempers the already performed pass.
- Welding must be done by certified manual welders only according to DIN EN ISO 9606-1.
- The material of the weld-on bracket is 1.5070 (S355J2 + N) according to EN 10025. Preheating of the weld-on lifting point 37500kg is necessary – the bracket has to reach a temperature of 100 degree. For all other type with less lifting capacity it is not required.
- The welding metal must be introduced into the full cross-section.
- Seam transitions must be executed notch-free.
- Prior to applying the deck seam, slag and impurities must be removed.
- After cleaning the welding seam, a visual check of the welding seam must be carried out for cracks, hacks and inclusions. In case of doubt, a surface crack inspection must be carried out.



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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
Attachment eye 1.12 t	HV 4 + 3	2 x 36 mm
Attachment eye 2 t	HV 5 + 3	2 x 38 mm
Attachment eye 3.15 t	HV 7 + 3	2 x 41 mm
Attachment eye 5.3 t	HV 10 + 4	2 x 50 mm
Attachment eye 8 t	HV 16 + 4	2 x 65 mm
Attachment eye 15 t	HV 25 + 6	2 x 90 mm
Attachment eye 20 t	HV 25 + 6	2 x 90 mm
Attachment eye 37 t	HV 39 + 16	2 x 140 mm

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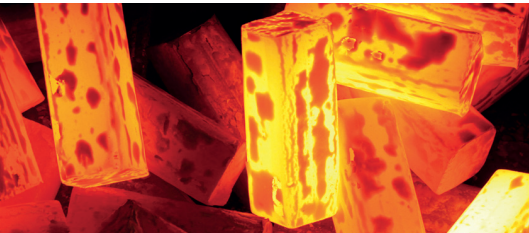
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Welding procedure + additives for Europe, the United States and Canada for the material construction steels, low alloy steels

MAG / MIG	EN ISO 14341 G4Si1 e.g. Castolin 45250	AWS: A-5.18 HE 70 S-6 for example, eutectic MIG-TEC Tic A88
MMA DC	EN499 E 426 B32 H5 e.g. Castolin 6666 or 6666N - observe drying regulation	AWS: A 5.5 E8018-G E7016 for example, eutectic 6666/35066 CP
MMA AC	EN499 E 380 RR 12 e.g. Castolin 35086 CP 6600	AWS: A-5.1 E 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

RESISTANCE TO TEMPERATURE:

The specified capacities of the weld-on lifting points apply to temperatures from minus 40 to plus 200 degrees Celsius without deduction. When used in other temperature ranges, adequate tests for the respective ambient operating temperature are to be carried out in advance. In such cases, the load bearing capacity must be recalculated.

Inspection and maintenance:

Weld-on lifting points must be checked after installation and at least twice a year by a competent person. Before use, e.g. by the slinger, weld-on lifting points must be inspected for cracks, deformations, strong corrosion. List of possible inspection criteria:

- Completeness of the weld-on lifting point.
- Observe the indicated load bearing capacity.
- Immediate prohibition of use in case of cracks.
- Immediate prohibition of use in case of damage of the bow part or the bracket. The current test requirements shall apply.
- Immediate prohibition of use in the presence of severe corrosion.

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