

Load ring (Ringbock) EDGE weldable - Operating and welding instructions Status May 2022

Operating instructions

- 1) The components may only be used by authorised and instructed persons in compliance with the relevant national regulations. Within Germany, BGR 500 standards must be observed.
- 2) The user of the load rings is obliged to check the load rings regularly for cracks in the weld seam, strong corrosion, wear or deformations etc. before putting them into operation. The following must be checked in detail: - completeness of the anchor point - complete legibility of the load capacity indication and the manufacturer's mark - deformations on load-bearing parts such as the base body and the suspension bracket - mechanical damage such as severe notches, especially in areas subject to tensile stress - changes in cross-section due to wear > 10% - severe corrosion - cracks on load-bearing parts - cracks or other damage to the weld seam.
- 3) The place of use is to be chosen in such a way that the forces applied by the load ring to the substructure can be absorbed without deformations. The load ring can be loaded on all sides. The welding material must be suitable for welding. Impurities such as oil, grease, paint, etc. must be removed beforehand.
- 4) The material of the welding blocks is ST52.3 (1.0570).
- 5) The position of the load rings is to be chosen in such a way that twisting or turning over of the load is avoided. Reference is made to BGI 622 - Load tables for slings.
- 6) The sling must be freely movable in the load ring. When attaching and detaching the lifting gear, there must be no crushing, shearing, catching or impact points for handling. Damage due to sharp-edged loads must be excluded.
- 7) The temperature range of the load rings is -40 to 200 °C without a reduction of the load capacity being necessary. At temperatures from 200 degrees to 300 degrees the load capacity is reduced by 12%, and at temperatures from 300 degrees to 400 by 25%. Use above 400 degrees is excluded.



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- 8) The load rings must not be brought into contact with aggressive chemicals, acids or their vapours.
- 9) The spacer knobs serve as a distance measure for the necessary air gap for root welding (approx. 2.5mm). These must not be removed. The water drainage opening must remain open.
- 10) If the load ring is only used for lashing, the specified load capacity for lashing can be doubled.
- 11) Welding may only be carried out by a certified manual welder according to DIN EN ISO 9606-1.
- 12) The load ring is delivered pre-assembled with 2 weld-on brackets. During disassembly and assembly by the customer, it must be ensured that the two spring rings in the bracket are in the correct position in order to maintain full functionality.
- 13) Only properly fitted, inspected load rings be used. Corrosion points and deformations must be excluded. It is recommended to check the ring supports before each use, but at least once a year, the points are to be checked by an expert.

Anschrift

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Eintragung

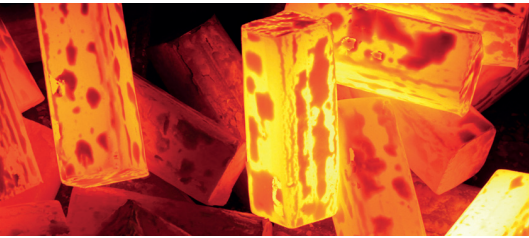
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Maximum load weight "G" with different modes of assembly for load GK 10

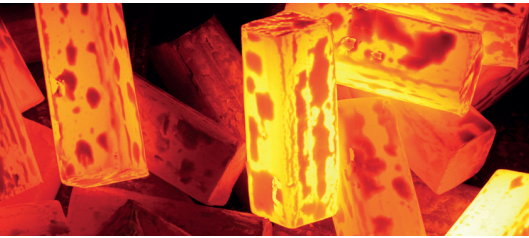
Mode of assembly									
Number of strands	1	1	2	2	2 symmetrical		3; 4 symmetrical		2; 3; 4
Angle	0°	90°	0°	90°	0°-45°	45°-60°	0°-45°	45°-60°	asymm.
Load capacity in t	4	4	8	8	5,6	4	8,4	6	4
Load capacity in t	6,7	6,7	13,4	13,4	9,5	6,7	14	10,1	6,7
Load capacity in t	10	10	20	20	14	10	21	15	10
Load capacity in t	16	16	32	32	22,4	16	33,6	24	16

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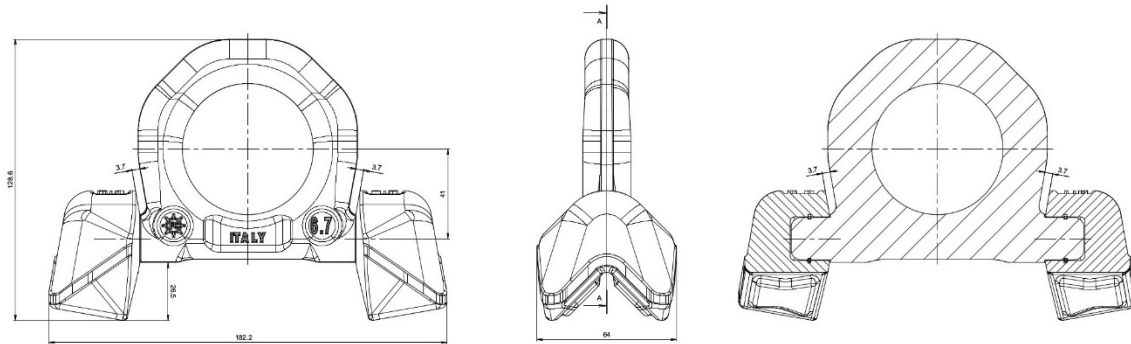
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Component arrangement for welding



Notes on welding:

- 1.) Position the load ring at the desired location, observing points 1- 13 of the operating specifications.
- 2) Staple the rings in place with spot welds.
- 3) Check the proper functionality of the load ring - movement amplitude of 270 degrees. When welding the root seam, the outer sides are welded first, the inner side to the ring last.
- 4) Check the root weld after cooling and make sure the weld surface for the cover weld is perfect.
- 5) The starting point of the cover seam is the inside (side to the ring). Then the welding of the outer sides takes place. Please note that the welding seam on the inside may only be thick enough to allow the ring to move properly.
- 6) After completing the welding, make sure that the weld has been carried out properly.

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Welding processes + additives for Europe, the USA, Canada for structural steels, low-alloy steels

MAG / MIG	EN 440 G4Si1 e.g. Castolin 45250	AWS: A 5.18 ER 70 S-6 e.g. Eutectic MIG-Tec Tic A88
MMA direct current	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
MMA alternating current	EN499 E 380 RR 12 e.g. Castolin 35086 CP 6600	AWS: A 5.1 E 6013 e.g. Eutectic Beauty Weld II
TIG	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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