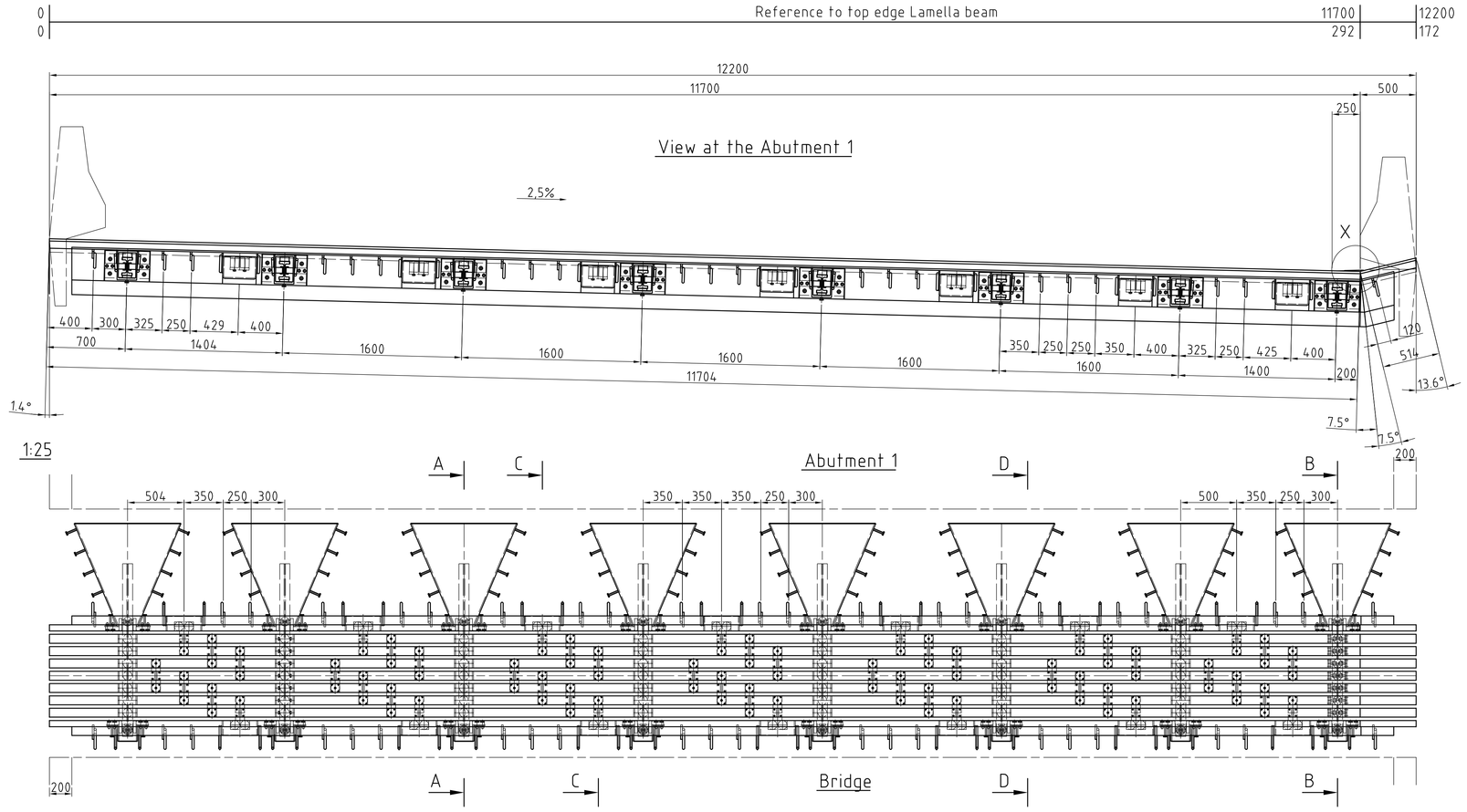


KORROSIONSSCHUTZ Mageba:

Korrossionschutz gemäss DIN EN ISO 12944, System-Nr. S4.14
Korrosivitätsklasse C4, erwartete Schutzdauer L (Lang)
Sandstrahlen ausschliesslich mit kantigem mineralischem Strahlmittel z.B Korund Maximumgrösse 20 bis 24
Rauheit: Rz min. 60 µm (besser 85 µm),
bzw. Rauhigkeit Elcometer 2 (besser 3)

1. SANDSTRAHLEN	Sa 3
2. THERM. SPRITZVERZINKEN	80 µm

oder

1. SANDSTRAHLEN	Sa 2½
2. EP-ZINKSTAUBFARBE	80 µm
3. 2K-EP-EISENGLIMMER	2 x 60 µm
4. 2K-PUR-EISENGLIMMER	80 µm
Total Schichtdicke (Sollschichtdicke)	280 µm

FEUERVERZINKEN:

Folgende Bauteile werden mit einer Mindestschichtdicke von 80 µm feuerverzinkt:

1. Traversenrahmen
2. Steuerriegel
3. Arretierungen der Traversen
4. Distanzstücke zu Steuerriegel

CORROSION PROTECTION Mageba:

Corrosion protection according to DIN EN ISO 12944, system-Nr. S4.14
Corrosivity category, C4, expected durability L (long)
Sandblasting using only angular mineral blasting material e.g. corund, maximum size 20 to 24.
Target surface roughness: Rz min. 60 µm (better 85 µm), alternativly Elcometer-roughness 2 (better 3).

1. SAND BLASTING	Sa 3
2. ZINC METAL SPRAY GALVANISING	80 µm

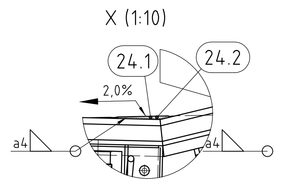
or

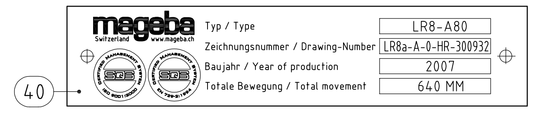
1. SAND BLASTING	Sa 2½
2. ZINC DUST EP PRIMER, 2-pack	80 µm
3. MIO EP, 2-pack	2 x 60 µm
4. MIO PUR, 2-pack	80 µm
Total thickness (target Thickness)	280 µm

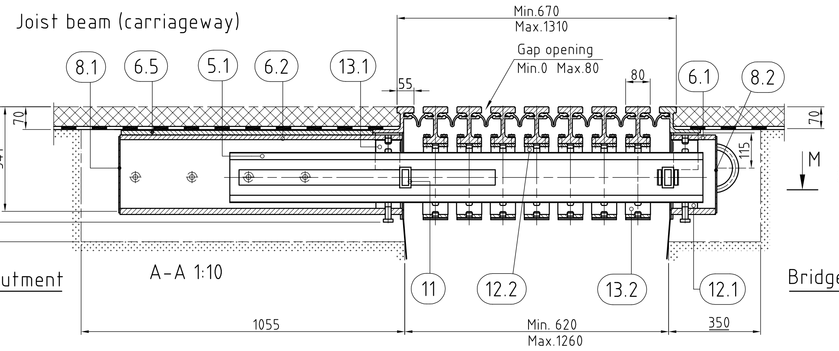
HOT DIP GALVANISING:

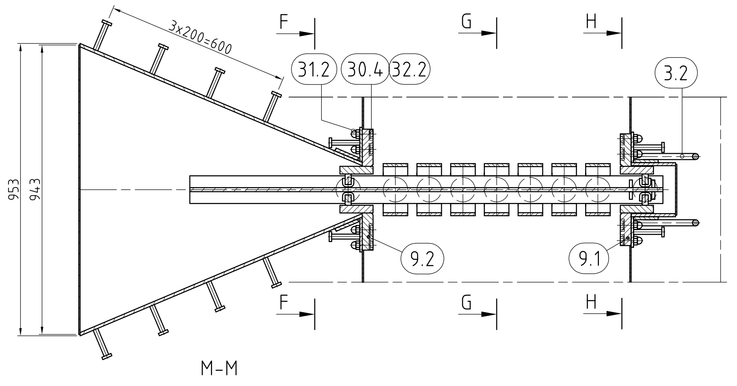
The following components (not exposed to direct weather impact) are hot dip galvanized with a minimum thickness of 80 µm:

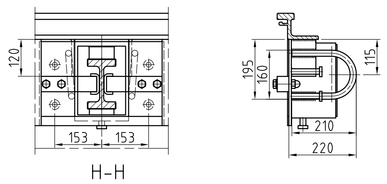
1. Joist box (frame)
2. Distance plate
3. Fixing plate (box)
4. Spacer block

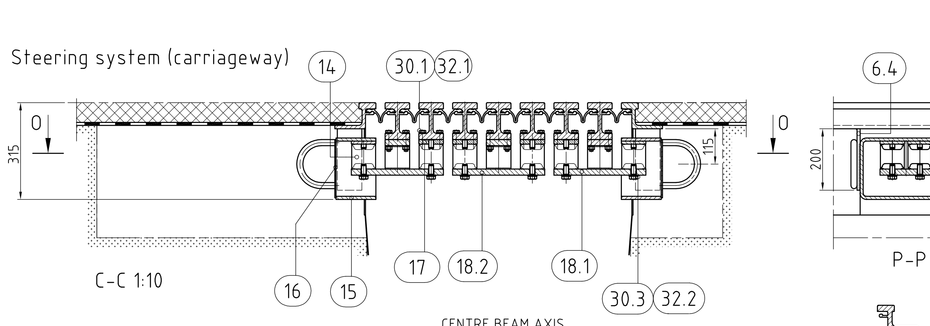


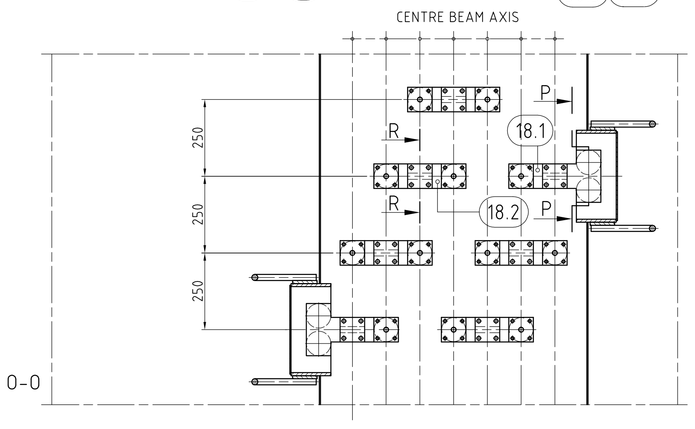


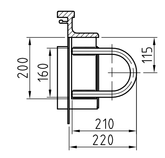




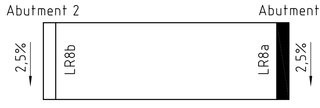




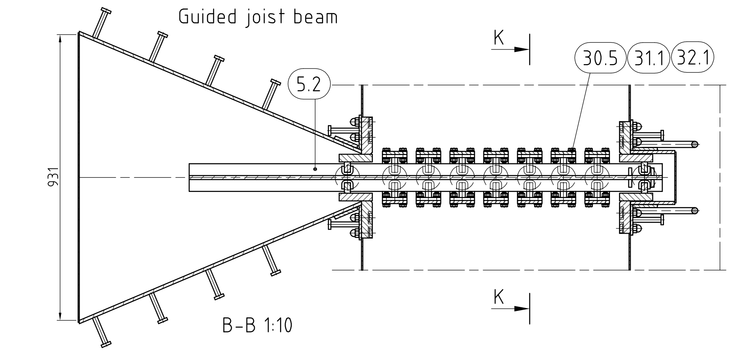


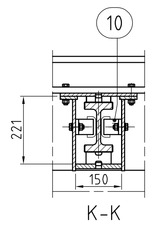


Location scheme



ANZ.	BENENNUNG	DIMENSIONEN	POS.	MATERIAL	ARTIKEL
16	Fixing plate (moved)	108x60x189	9.2	S235JRG2	
16	Fixing plate (fixed)	108x60x174	9.1	S235JRG2	
8	Joist box cover (fixed)	166x4x246	8.2	S235JRG2	
8	Joist box cover (moved)	94.3x4x246	8.1	S235JRG2	
56	Joist box (frame)	150x221 (inside)	7	S235JRG2	
8	Flat Steel	15x237/928; L=820	6.5	S235JRG2	
28	Cont. spring box supp.	80x10x200	6.4	S235JRG2	50.01380
32	Joist box support	80x10x120	6.3	S235JRG2	50.01380
8	Joist box (moved)	156/...x221 L=920	6.2	S235JRG2	
8	Joist box (fixed)	156x221 L=145	6.1	S235JRG2	
1	Guided joist beam (HEM 140)	90x160 L=1542	5.2	S355J2G3	
7	Joist beam (HEM 140)	90x160 L=1542	5.1	S355J2G3	76.09093
1	Identification plate	150x32,5x1,5	40	Alu	50.01569
8	Rubber seal	L = 12400 mm	4	EPDM	50.01485
176	Washer (hot dip galv.)	ø30/17x3	32.2	St	50.00871
1232	Washer (hot dip galv.)	ø20/13x2	32.1	St	50.00872
64	Cap nut (HF)	M16	31.2	8	50.01009
448	Nut (hot dip galv.)	M12	31.1	8.8	50.00874
28	Hexagon screw (hot dip galv.)	M12x40	30.5	8.8	50.00875
64	Hexagon screw (hot dip galv.)	M16x45	30.4	8.8	50.00853
112	Hexagon screw (hot dip galv.)	M16x35	30.3	8.8	50.00878
420	Hexagon screw (hot dip galv.)	M12x60	30.2	8.8	50.00879
336	Hexagon screw (hot dip galv.)	M12x35	30.1	8.8	50.00880
44	Loop anchor	160x210/ø20	3.2	S235JRG2	50.51542
44	Carriageway anchor	170x220	3.1	S235JRG2	75.02217
7	Steel structure	d=70; 0,02 m2	24.2	S235JRG2	
2	Steel structure	d=40; 0,01 m2	24.1	S235JRG2	
34	Shuttering plate 4 mm	4x278;Tot=16,7m	22	S235JRG2	85.20278
4	Shuttering plate 1,5 mm	1,5x130;Tot=23,8m	21	DX51D+Z	85.10144
14	Lamella beam (HEM 100)	Total = 86,1m	2	S355K2G3	74.08121
0	Distance sheet	ø85	19	1.4404	50.01509-14
35	Distance plate	80x116x320	18.2	S235JRG2	80.00012
14	Distance plate	170x116x320	18.1	S235JRG2	80.00022
84	Spacer bloc	80x27x80	17	S235JRG2	50.51411
14	Control spring box cover	290x190x4	16	S235JRG2	
14	Control spring box	300x200x10x130	15	S355J0	
112	Control spring	ø78x81	14	NR	50.01454
56	Sliding spring (frame)	ø82x45	13.2	NR/PTFE	50.01325
16	Sliding spring (box)	ø82x45	13.1	NR/PTFE	50.01323
56	Sliding bearing (frame)	ø78x19	12.2	PA/ Robo Slide Plus I	50.01644
16	Sliding bearing (box)	ø80/78x19	12.1	PA	50.01330
46	Synthetic shoe	37x28x67	11	PUR	50.01327
14	Guide shoe support	80x50x58	10	S235JRG2	
4	Edge Profile RS-A7 int	Total = 24,6m	1	S235JRG2	70.07001

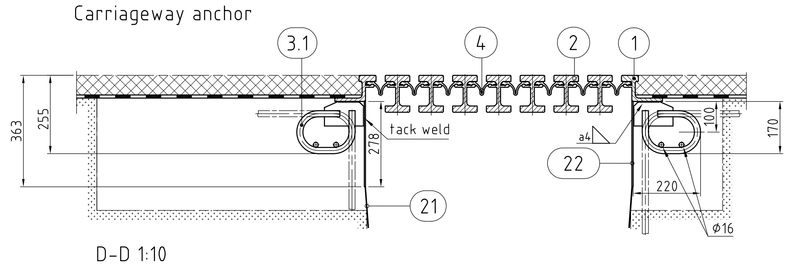


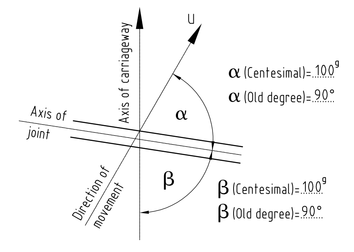


Information for workshop:
Werkstatt:

All welds that are not labelled shall be carried out as a4/4mm. Note that the welding layout plan associated with the structure shall be followed.

Alle nicht bezeichneten Schweissnähte werden in a4/4mm ausgeführt. Der zur Konstruktion zugehörige Schweissübersichtsplan ist zu beachten.





Installation at.....°C	Width per gap.....mm		
Installation at.....°C	Width per gap.....mm		
Installation at.....°C	Width per gap.....mm		
Installation at.....°C	Width per gap.....mm		
Movement per 1°C.....mm			

Revision	Date	Description	Prepared	Reviewed	Approved
00	22.02.07	For approval	TBRU Ø	BU	SR

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Article-No.: 960.08001
General tolerances according ISO 2768-v

Client: Viaduct d.d. Zagreb
Scale: 1:25, 10
Weight: 8420 kg

Project: Zeceve Drage II

Structural Member: Expansion Joint LR8-A80
Location: Abutment 1
Order-No.: 300932
Sheet-No.: 1

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Drawing-No.: LR8a-A-0-HR-300932