



Flange		Web		Welding
Thickness of flange of sectional steel	Min. plate-thickness for welded profile	Thickness of web of sectional steel	Min. plate-thickness for welded profile	
9 - 10	12	5 - 7	8	4
>10 - 11	13	> 6 - 7	8	4
>11 - 12	14	> 6.5 - 7.5	9	5
>12 - 13	16	>7.5 - 8	10	5
>13 - 14	17	> 8 - 9	11	5
>14 - 16	19	>8.5- 10.5	14	7
>16 - 18	22	>10 - 11.5	15	7
>18 - 22	25	>11 - 12.5	15	7
>22 - 24	29	>12.5 - 14	15	7
>24 - 30	35	> 14 - 16	17	8
>30 - 36	42	>16 - 22	21	8

DIMENSIONES
 d=290 e=470
 f=5730 g=1006
 h=HE600B l=11430

- ⑬ If the specified profile cross section is not available, the beam may be welded from plate or flat iron. Preserve original outer dimensions, and use plate dimensions from shown table.
- ⑫ Max. deflection: $\pm 0.001 \times l$, but max 10 mm.
- ⑪ Max. deflection: $\pm 0.001 \times l$, but max 10 mm.
- ⑩ Max. torsion 0.05° per/m.
- ⑨ Non-parallelisme of flanges:

height of profile 0 - 240	1% of width
height of profile 240 - 1000	1,2% of width
- ⑧ Max. deflection of web:

height of profile 0 - 450	1.5mm.
height of profile 450 - 700	2.0mm.
height of profile 700 - 1000	3.0mm.
- ⑦ Standard sectional steel.
- ⑥ For mat. see main parts list.
- ⑤ Mat. 110.
- ④ The profile may not be assembled from shorter lengths by simple cross-welding. If assembly is necessary refer to FLS-milj for details.
- ③ The welding must be gas-tight.
- ② Note, do not weld here.
- ① For c,d,e,..... see main parts list.

① c,d,e,f,g,h,l Pos 109

Original	Rev.	Sign. Date	Sign. Date	Sign. Date	Revision in zone: / Description:
990406	990428	990428	990428	990428	
Designed:	Checked:	Approved:	Adhere to general instruction: 520530.		Original format: A1
External identity No.:					
Title:					Projection conv.: Kg: /
Precipitator type FM					ISO-E: $\leftarrow \oplus$
Frames (Centre column)					Pattern number: Mat.: ⑥
Bottom hopper beam for 2 bottom hoppers					Department or OBS code:
Sectional steel Pos-109					CAD file: 1153611.dwg
Drawing No.:					1.153611

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