



STAINLESS STEEL PROCESS TANKS PRODUCT CATALOGUE



EKIN PRODUCTS. LUMIPRA CONTACT.

Your authorized Ekin partner in the DACH region.

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Products, technical advice, procurement and spare parts.



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Sustainable Innovation, Quality Standardization and Dynamism

Ekin Endustriyel, which has entered Turkish heating sector by exporting of plated heat exchangers, is known with customer focused vision and dynamism. Ekin has expanded into new and upcoming investments. One of the main steps was gaining the identity of being a producer. Ekin has started the production of plate heat exchangers with the brand of "MIT". We have grown in the philosophy of quality, through initially adapting to ISO Quality Management.

MIT plate heat exchangers have become a solution for engineering problems in the world market and have grown through an expansion of franchises.

Engineering Approaches, Integrated Solutions

Ekin has expanded into the production of components, sales, and after-sales service by employing expert engineers. The factors that guided Ekin to success are their exceptional customer service to the needs and wants of consumers, modern facilities, and becoming partners to projects that involve high-end technology.

Ekin is an expert company which has a wide product range which includes plate heat exchangers, accumulation tanks, water heater tanks, installation, and its service group and submit competitive advantages to mechanical installation sector in Turkey and all around the world.



APPLICATION FIELDS



HEAT TRANSFER PRODUCTS

- Gasketed Plate Heat Exchangers • Brazed Heat Exchangers • Shell&Tube Heat Exchangers • Air Fan Oil Cooler • Economizers • Coils and Radiators



PRESSURE VESSELS

- Water Heater Tanks • Water Storage Tanks • Buffer Tanks • Expansion Tanks • Stainless Steel Process Tanks • Balance Tanks / Dirt Separators / Air Separators • Pressured Air Tanks • Neutralization Tanks • Air Tubes • Steel IBC Tanks with ADR



COMPLETE SYSTEMS UNITS

- Heat Stations • Steam Package Systems • Special Designed Systems • Dosing Systems • Substations • Thermoregulators



FOOD GRADE SYSTEMS

- Pasteurizers with plate heat exchangers • Hygienic Pasteurizers with Shell & Tube Heat Exchangers • Cheese and whey Systems • UHT – Sterilization Systems • CIP Systems • Hygienic Storage and Process Tanks • Homogenizers • Standartization Systems • Evaporators • Turn-key Projects



FLUID TRANSFER PRODUCTS

- Lobe Pumps • Hygienic Centrifuge Pumps • Turbo / Roots / Centrifuge Blowers • Drum Pumps • Acid Pumps • Dosing Pumps • Monopumps • Air operated Double Diaphragm Pumps (AODD)



VALVES

- Thermoplastic Valves • Plastomatic Valves



ENERGY SYSTEMS

- Solar Collectors • Water Heater Tanks for Solar

Contents

1

Stainless Steel
Process Tanks





MIT STAINLESS STEEL ACCUMULATION TANKS AND WATER HEATER TANKS

MIT, one of the most known and preferred brands of Turkey, has been continuing to create new ideas and developments to improve plate heat exchanger sector.

Ekin aims to develop its product range and the most concrete proof of this determination is MIT stainless tanks.

Since the day it is founded with the philosophy of "We have a dream", Ekin personnel, who work nonstop, have been realizing that the dream is becoming true and they raise the bar and continue chasing their dreams.



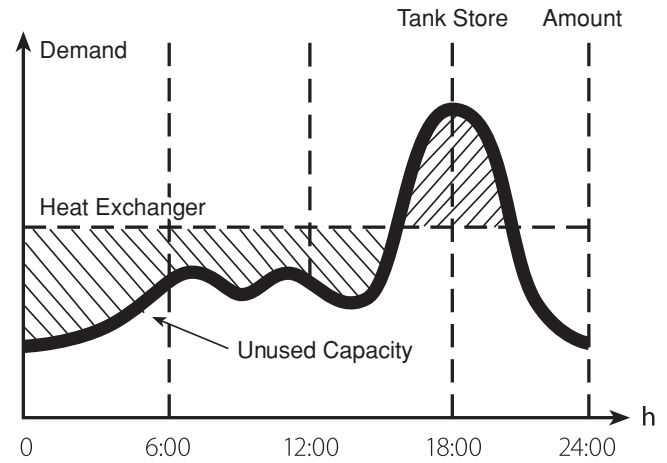
Why Should I Use Stainless Steel Tanks?

In order to obtain the water needed hygienically, they can be easily used in all drinking water and food processes due to their material properties. Due to their extremely long life compared to standard pressure tanks it is recommended to use stainless tanks. Our stainless production tanks offer excellent resistance to corrosion, regardless of the hardness of the mains water. These tanks are able to operate in a long life and in a healthy way at the places of use. Customer-dependent designs can be customized.

Usage Areas

- Apartments
- Drinking water facilities
- Hospitals
- Dormitories
- Sports facilities
- Factories
- Public buildings

Wherever there is a need for hot water, an accumulation tank is used.



Stainless Steel Tanks in different capacities from 100 lt to 30.000 lt.

Accessories that can be added according to customer's request

- Safety valve is also mounted on tanks upon request.
- In addition, our stainless tanks are produced with electric control panel upon request.



Horizontal and vertical models are available.

Why Should I Use Stainless Steel Water Heater Tank and Accumulation Tank?

MIT stainless steel tanks are produced by advanced technology and experienced R & D engineers. As the welding method of the products and the pressure applied during the test are produced by increasing the safety coefficients, they can be used with a long life and suitable for the system. Since our stainless production tanks can be produced with special design according to each system, they can be easily integrated into the systems.

In addition to the robust, long-lasting and hygienic products we have adopted in our production, this quality is the most affordable price policy that can be achieved.

Hygienic + Long Life MIT Stainless Steel Tanks = Smooth Operation

MIT stainless steel boilers and storage tanks are manufactured with hygiene materials that can be safely used in the food industry. Thanks to the custom design serpentine, bacteria are prevented from forming in the boiler. Thanks to the hygienic water inside the MIT stainless tanks, the stored hot water can be used both as domestic hot water and as drinking water.

Corrosion Resistance Is Very High;

All MIT tanks and accumulator tanks made of stainless steel are produced with appropriate materials considering all corrosion types. In addition, galvanic and cathodic protection was increased to a very high level with the magnesium anodes used.

Durability;

The service life of MIT stainless steel tanks and storage tanks is longer than enamel or galvanized immersion chambers due to the structure of the material used. Maintenance and repair is very easy.

Uninterrupted and Trouble-Free Operation;

MIT stainless steel tanks and accumulation tanks provide long life, maintenance and repair facilities, as well as efficient use of energy throughout the system, providing ideal solution for residential and commercial buildings, industrial plants, providing uninterrupted and trouble-free operation.

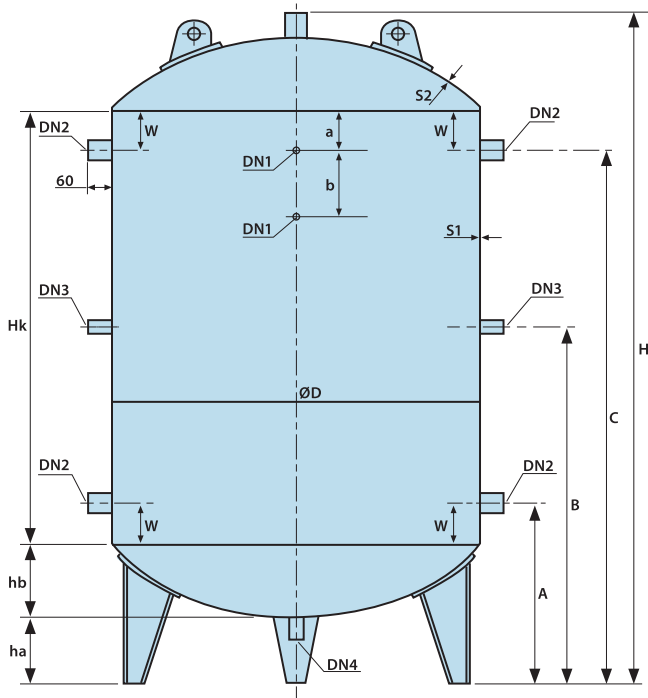


Dimensions and Material Features

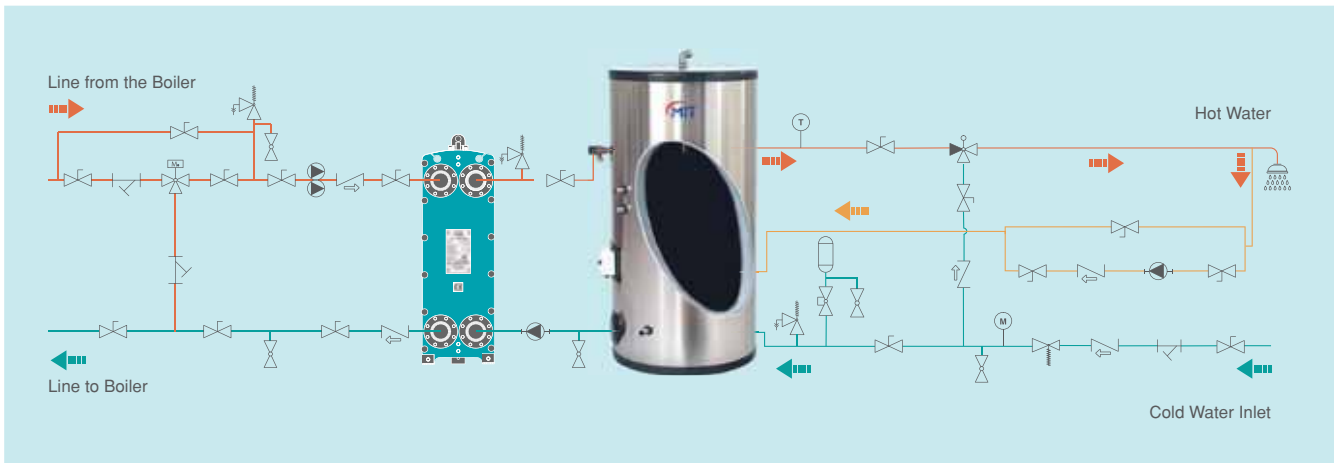
Model		MIT-SS 100	MIT-SS 160	MIT-SS 200	MIT-SS 350	MIT-SS 500	MIT-SS 600	MIT-SS 800
D	mm	400	460	475	550	650	660	780
Dpul	mm	420	500	500	700	820	820	935
A	mm	350	350	350	350	400	400	450
B	mm	650	650	750	875	925	1025	1075
C	mm	900	950	1150	1400	1450	1650	1700
H	mm	1160	1210	1410	1660	1760	1960	2010
Hk	mm	750	800	1000	1250	1250	1450	1450
hb	mm	100	100	100	120	150	150	150
ha	mm	150	150	150	150	150	150	200
w	mm	100	100	100	100	100	100	100
a	mm	100	100	100	100	100	100	100
b	mm	150	150	150	200	200	200	200
DN 1		1/2"	1/2"	1/2"	3/4"	3/4"	3/4"	3/4"
DN 2		1"	1"	1"	1 1/4"	1 1/4"	1 1/4"	1 1/2"
DN 3		3/4"	3/4"	3/4"	1"	1"	1"	1"
DN 4		3/4"	3/4"	3/4"	1"	1"	1"	1"
Material		AISI 304	AISI 304	AISI 304	AISI 304	AISI 304	AISI 304	AISI 304
Serpentine		1"	1 1/4"	1 1/4"	1 1/4"	1 1/4"	1 1/4"	1 1/4"
Serpentine Surfaces	m²	0,6	0,85	1,2	1,5	2	2,2	2,92
S1 Body	mm	2	2	2	3	3	3	3
S2 Camber	mm	2	2	3	3	3	3	3

Model		MIT-SS 1000	MIT-SS 1500	MIT-SS 2000	MIT-SS 2500	MIT-SS 3000	MIT-SS 4000	MIT-SS 5000
D	mm	850	1050	1050	1200	1300	1300	1500
Dpul	mm	1055	1290	1290	1500	1590	1590	1830
A	mm	500	580	570	570	600	670	680
B	mm	1100	1130	1445	1370	1425	1770	1780
C	mm	1700	1680	2320	2170	2200	2870	2880
H	mm	2060	2060	2700	2550	2610	3350	3360
Hk	mm	1500	1500	2000	1800	2000	2500	2500
hb	mm	200	220	220	220	250	320	320
ha	mm	200	260	250	250	250	250	260
w	mm	100	100	100	100	100	100	100
a	mm	100	150	150	150	150	150	150
b	mm	200	200	200	200	200	200	200
DN 1		3/4"	3/4"	3/4"	3/4"	3/4"	3/4"	3/4"
DN 2		2"	2 1/2"	2 1/2"	2 1/2"	3"	3"	3"
DN 3		1 1/4"	1 1/2"	1 1/2"	1 1/2"	2"	2"	2"
DN 4		1 1/4"	1 1/2"	1 1/2"	1 1/2"	2"	2"	2"
Material		AISI 304	AISI 304	AISI 304	AISI 304	AISI 304	AISI 304	AISI 304
Serpentine		1 1/4"	1 1/4"	1 1/4"	1 1/4"	1 1/4"	1 1/2"	1 1/2"
Serpentine Surfaces	m²	2,95	4	5	6	7	8	9
S1 Body	mm	3	4	4	4	4	4	5
S2 Camber	mm	4	4	5	5	5	6	6

Dimensions



Accumulations Tank - Connection Diagram



 Solar Panel	 Temperature Display	 Pressure Display	 Switch Flow	 Pump	 Twin Pump	 Check Valve	 Air Relief Cock
 Bypass Valve	 Pressure Breaker	 Dirt Holder	 Discharge Valve	 3 Way Valve	 Sediment Holder	 Air Separat	 Expansion Tanks with membrane
 Balance Valve	 Lock Valve	 Radiator Valve	 Spherical Valve	 Pressure Safety Valve	 3 Way Proport. Motor Valve	 2 Way Motor Valve	 Thermostatic Valve

Water Heater Tank Types

Stainless Steel Tanks

Material: 304 L or 316 L

Insulation

- Polyurethane
- Special sponge
- Glass wool
- Rock wool

Advantages

- Very high corrosive strength
- Very long service life
- High compressive strength
- Low heat loss



MIT Boiler Capacities

- Stainless Steel.
 - Cathodic protection is available.
 - Soft PU (Sponge) insulation.
 - Stitched pipe with serpentine.
- Cleaning hole is available.
 - Thermometer is on the boiler.
 - Electric heater can be added in desired sizes.

SINGLE SERPANTINE			
Capacity (lt)	Heater Fluid Temperature	Heating Capacity (lt/h) 10 °C - 60 °C	Heating Capacity (lt/h) 10 °C - 45 °C
100	90-70 °C	280	529
	80-60 °C	178	357
160	90-70 °C	400	714
	80-60 °C	238	477
200	90-70 °C	620	1114
	80-60 °C	380	763
300	90-70 °C	620	1114
	80-60 °C	380	763
500	90-70 °C	1080	1857
	80-60 °C	680	1315
800	90-70 °C	1560	2729
	80-60 °C	1020	1915
1000	90-70 °C	1560	2729
	80-60 °C	1020	1915
1500	90-70 °C	2000	3486
	80-60 °C	1300	2458
2000	90-70 °C	2580	4429
	80-60 °C	1680	3143
2500	90-70 °C	3361	5801
	80-60 °C	2200	4115
3000	90-70 °C	3881	6687
	80-60 °C	2560	4744
4000	90-70 °C	4120	6870
	80-60 °C	3020	5220
5000	90-70 °C	5430	8750
	80-60 °C	4230	6600

DOUBLE SERPANTINE			
Capacity (lt)	Heater Fluid Temperature	Heating Capacity (Top+Bottom) (lt/h) 10 °C - 60 °C	Heating Capacity (Top+Bottom) (lt/h) 10 °C - 45 °C
160	90-70 °C	432	797
	80-60 °C	238	508
200	90-70 °C	568	1032
	80-60 °C	328	683
300	90-70 °C	568	1032
	80-60 °C	328	683
500	90-70 °C	1708	2971
	80-60 °C	1068	2078
800	90-70 °C	2260	3978
	80-60 °C	1460	2772
1000	90-70 °C	2260	3978
	80-60 °C	1460	2772
1500	90-70 °C	2700	4735
	80-60 °C	1740	3315
2000	90-70 °C	3750	6475
	80-60 °C	2430	4572
2500	90-70 °C	4801	8287
	80-60 °C	3120	5864
3000	90-70 °C	5696	9773
	80-60 °C	3710	6916
4000	90-70 °C	2100	4250
	80-60 °C	1230	3210
5000	90-70 °C	3050	4800
	80-60 °C	1730	4010

80 °C

90-70 Boiler

70 °C

80-60 Boiler



Ekin is aware that the progress in its sector is possible through continuous development and learning.

Ekin Academy, established with this awareness, aims to provide high-quality and sustainable development with its modern education methods, to provide successful employees and to provide value to the society through social responsibility projects.

Training and development programs that will make a direct contribution to the results of our employees' work processes and which will make a difference in their personal development are prepared by Ekin Academy.

For our business partners and customers, our training modules prepared by our expert staff provide training support for pre-sales and post-sales issues such as commissioning, operation, maintenance and repair of our products.

In cooperation with universities within the scope of corporate social responsibility projects, we are experiencing the happiness of adding value to the society by allowing the engineer candidate, who aims to take place in the fields where Ekin is active, to meet with the sector and to experience the theoretical knowledge acquired in the fields of application.

In-Company Trainings

Ekin Academy conducts technical, leadership, strategy development, sales and training and development programs for different tasks in the fields of heat transfer, pressure vessels, package systems, food systems and liquid transfer.



Out-of-Company Trainings

We are realizing conferences and training activities to our business partners, professional groups and institutions where we carry out social responsibility projects in various locations of Turkey.



SALES TEAM

At Ekin, we produce a proactive solution by our engineering staff who are specialized in their field. Our team, which works with the aim of unconditional customer satisfaction, works selflessly in order to gain customer loyalty by raising the bar of success in products, services and processes.

We are happy to share our accumulated knowledge with our valued customers. Ekin will continue to be the best solution partner for you in all applications with all kinds of heating and cooling applications.



Customer Satisfaction

Customer rights are protected in all circumstances.



Privacy Policy

Aware of the importance of protecting personal information, personal information is not shared with third parties.



Information Security

The requirements of ISO 27001 information security management system are fulfilled at Ekin.



Ethical Values

In all our business relations, our principle of mutual benefit by adhering to laws and ethics is our principle.

CERTIFICATES





TCS



CE

AT TİP İNCELEME SERTİFİKASI / EC TYPE EXAMINATION

Holder Of Certificate (Sertifika Sahibi) :	SKIN ENDÜSTRİYEL İSTİTMA SOĞUTMA SAN. TİC. LTD. ŞTİ
Company Address (Firma Adresi) :	Emirhanlı M.Deri San. San. Bö. 107. Sok. A Blok C/B 14Blok 2A 4 Gömrükçübaşı/İstanbul
Production Address (Üretim Adresi) :	Bağcılar Mah. Tünelci Yolu Arıbalı Cad.No 23 Gebze/Kocaeli /Türkiye
Trade Mark (Ticari Marka) :	MİT
Product (Ürün) :	Kapak Genişleme Tankı / Closed Expansion Vessel
Model(s) (Model)	Ekli Liste / They have shown in the attached list

The technical documentation review and evaluation of the product(s) was done for above described product(s) according to 87/23/EEC Pressure Equipment Directive Annex II Modul B EC Type Examination of the company whose information given above and it was found suitable for conditions of Technical Regulation/Euroconform Standards / Yukarıda bilgileri verilen olan Kuruluşun teknik yeterliliğiyle yukarıda belirtilen ürünün/ürünlerin Teknik düzenlemeye istinaden ve Ürünün/Ürünlerin Değerlendirilmesi 87/23/AT Basınçlı Ekipmanlar Yönetmeliğinin EK II Modul B AT Tip İncelemesi NGM'nin kapamada gerçekleştirilmiştir ve Teknik Düzenleme/Ürünün/ürünlerin Standartlarına uygun olduğu tespit edilmiştir.

For affixing the Notified Body number, with CE mark, company has to carry out one of the modules mentioned in 87/23/EEC Pressure Equipment Directive Annex II. / Kuruluşun CE İşareti ile birlikte Onaylarının Kuruluş Kimlik numaralarını içeren listesine 87/23/AT Basınçlı Ekipmanlar Yönetmeliği EK II ile belirtilen listeden modüllerinden biri uygulanması gerekmektedir.

Sertifika No / Certificate No	965-C01-00-TN-PED-14-002	
Rapor Numarası / Report No	R-565-PED-001	
Sertifika Tarihi / Certificate Date	18.11.2015	
Geçerlilik Tarihi / Expiry Date	18.11.2020	
Yer / Place	İSTANBUL	 General Manager / Genel Müdür

Manufacturer who issues TCS International Certification about every modification that can affect safety of equipments / İnceleyici TCS Uluslararası Belgelendirme'ye içinde yapılabilecek her türlü değişikliği etkileyecek olan değişiklikler bildirilmelidir.

A460 10100 000 00 30000000

Yatırımcılar, Kurumlar, Ticaret, San. ve Sanayi Bakanlığına Belirtilen / Müahhidler

T: 00 90 212 331 33 33 / 00 90 212 331 33 33 / 00 90 212 331 33 33 / 00 90 212 331 33 33



TÜRK STANDARDLARI ENSTİTÜSÜ

TÜRK STANDARDLARINA UYGUNLUK BELGESİ

TURKISH STANDARDS INSTITUTION

CERTIFICATE OF CONFORMITY TO TURKISH STANDARDS

BELGE NUMARASI

REFERENCE NUMBER OF LICENCE

BELGENİN İLK VERİLİŞ TARİHİ

DATE OF FIRST ISSUE OF LICENCE

BELGENİN SON GEÇERLİLİK TARİHİ

LICENCE VALID UNTIL

BELGE SAHİBİ KURULUŞUN ADI

NAME OF THE LICENCE HOLDER

BELGE SAHİBİ KURULUŞUN ADRESİ

ADDRESS OF THE LICENCE HOLDER

ÜRETİM YERİ ADI

NAME OF THE MANUFACTURING PLACE

ÜRETİM YERİ ADRESİ

ADDRESS OF THE MANUFACTURING PLACE

İPTAL EDİLEN BELGE NUMARASI (Varsa)

INDICATION OF SUPERSEDED LICENCE (if any)

TESCİLLİ TİCARİ MARKASI

REGISTERED TRADE MARK

İLGİLİ TÜRK STANDARDI

RELATED TURKISH STANDARD

BELGE KAPSAMI

SCOPE OF LICENCE

011181-TSE-02/01

07.06.2018

07.06.2019

EKİN ENDÜSTRİYEL İSITMA SOĞUTMA SAN. VE TİC. LTD. ŞTİ.

DUDULLU OSB MAH. DES SANAYİ SİT. B14 BLOK 107. SOK.
NO:2-4-6-8 ÜMRANIYE İSTANBUL/TÜRKİYE

EKİN ENDÜSTRİYEL İSITMA SOĞUTMA SAN. VE TİC. LTD. ŞTİ.

DUDULLU OSB MAH. DES SANAYİ SİT. B14 BLOK 107. SOK.
NO:2-4-6-8 ÜMRANIYE İSTANBUL/TÜRKİYE

MİT

TS EN 13831 / Tu tesisatları için diyaframlı kapalı genişleme tankları /
09.11.2010

MİT TİCARİ MODELİ, EN YÜKSEK ÇALIŞMA BASINCI 10 BAR OLAN, SU TESİSLATLARI İÇİN DİYAFRAMLI
KAPALI GENİŞLEME TANKI

08.06.2018

Belgelendirme Merkezi Başkanı Adına

ÖMER FARUK DUMAN

SAKARYA BELGELENDİRME MÜDÜRÜ

*Bu belge, belgelendirilen ürünün, üretim yerinin Enstitümüz tarafından kontrol edilmiş ve onaylanmış olduğunu gösterir.

*Bu belge için bir kopya telif edilmiştir. Arama veya akıllı telefonla kontrol amaçlı kopyalanması, kütlenin ve satış yapılması.

*"TSE SAKARYA BELGELENDİRME MÜDÜRLÜĞÜ" Adres: 1. Organize Sanayi Bölgesi Doğu-Kapısı Şehit Zekariya Özlü Yaman Cad. Hani / ADAPAZARI - Tel: 2642912875
Faks: 2642912875

*"TSE BELGELENDİRME MERKEZİ BAŞKANLIĞI" Adres: Necattıbey Cad. No:112 06100 Bakırköy/İSTANBUL - Tel: 0 312 416 64 81 / 416 64 27, Faks: 0 312 416 66 17
e-posta: belge@tse.org.tr, web: www.tse.org.tr

1 / 1

<https://evrakkontrol.tse.org.tr/BelgeDuruluma.aspx?m=246&g=9> adresinden belgenin doğruluğunu ve geçerliliğini sorgulayınız.

Certificate of Registration

CERTIFICATE OF CONFORMITY

TECHNICAL FILE-TEKNİK DOSYA UYGUNLUK SERTİFİKASI
Certificate No: PC-1066

CE

to the Manufacturer / aşağıdaki üretici için:

EKİN ENDÜSTRİYEL İSITMA SOĞUTMA SAN. VE TİC.LTD.ŞTİ.
(Üreticinin Adı) TEÇ Endüstriyel Isıtma Soğutma Sanayi ve Ticaret A.Ş. - 81100 Şirvan / Van - Türkiye

Product and designation of type / Ürün ve belirtilen türleri:
Air Separator/Hava Ayırıcı / MIT Branded/MIT Markalı

HA20, HA25, HA32, HA40, HA50, HA65, HA80, HA100, HA125, HA150,
HA200, HA250, HA300, HA350, HA400

The products is covered by the following EU-Directive /
Ürünler aşağıdaki yönergelere kapsamındadır:
2014/68/EU Pressure Equipment Directive (PED)

Observing all EU-Directives relating to the product, the CE mark can be available on the products /
Ürüne ait tüm Avrupa Birliği direktiflerine uyum sağlanarak CE işaretini kullanılmaktadır.

This certificate covers the above product.. Does not cover all products produced,
covers the above products / Bu sertifika yukarıdaki ürünleri kapsamaktadır.
Ürünün tüm üretileri kapsamaz, yalnızca bu ürünleri kapsar.

Certificate Date / Sertifika Tarihi:
Date of Initial Registration / İlk Belgelendirme Kayıt Tarihi : November 26th, 2015 / 26 Kasım 2015
Date of Last Issue / Yürge Tarihi : March 23rd, 2018 / 23 Mart 2018
Date of Expiry / Geçerlilik Süresi Bitimi : March 23rd, 2019 / 23 Mart 2019

Signed on behalf of the Inspection Body / Belgelendirme Kurumu Adına İmzalandı

ISQ International Certification Inspection Co., Ltd.
Yatırım ve Kalite Kontrol Sistemleri Belgelendirme Kurumu
www.beygelendirmekurumu.tr
Certification reports can be accessed from our website beygelendirmekurumu.tr

ISQ
INTERNATIONAL CERTIFICATION INSPECTION CO. LTD.
ISO 9001:2015 REGISTERED

Accredited by UKAS ISO/IEC 17024:2012 Accredited
Type B Inspection Body for CE Mark

WELDING PROCEDURE QUALIFICATION RECORD (PQR) (Section IX, ASME Boiler and Pressure Vessel Code)																									
CERTIFICATE 09-702-01-C-30-217-211402991																									
Procedure Identification Record No.: wPQR-EX-BW-03 Company Name: Ekin Endüstriyel İnşaat Sistemleri San. Tic. Ltd. Şti. Address: OES Saraylı İskele 307-58, B14 Blok No:2-4-G-B Üsküdar/İST Welding Process(es): GTAW Type(s): Manual JOINTS (EN 482) Geometrical Design of Test Coupon																									
BASE METALS (EN-403) Material Spec. _____ ASTM _____ Type or Grade, or UNS Number _____ P. No./Alt.No. _____ R/1 _____ R/1 _____ Thickness of Test Coupon _____ S _____ Diameter of Test Coupon _____ N/A _____ Max. Plate Thickness(≤ 13 mm) _____ No pins over 13mm _____ Other: _____			POSTWELD HEAT TREATMENT (EN-407) Temperature: _____ Time: _____ Other: _____																						
FILLER METALS (EN-404) SFA Specification _____ GTAW _____ N/A _____ AWS Classification _____ AS-9 _____ Trade Name _____ ER 308 L _____ Filler Metal P.No. _____ SG 308 L _____ Weld Metal Analysis A-No. _____ 6 _____ Size of Filler Metal _____ 2 _____ Filler Metal Product Form _____ Solid Rod _____ Supplemental Filler Metal _____ N/A _____ Filler Metal Thickness _____ 5 _____ Flux Type _____ N/A _____ Flux Trade Name _____ N/A _____ Other _____ N/A _____			GAS (EN-408) <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th>Gases</th> <th>Percent Composition</th> <th>Flow Rate</th> </tr> </thead> <tbody> <tr> <td>Shielding - GTAW</td> <td>Ar</td> <td>100,0</td> <td>6-9 l/min</td> </tr> <tr> <td>Shielding - FCAW</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Torching</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Baking</td> <td></td> <td></td> <td></td> </tr> </tbody> </table>				Gases	Percent Composition	Flow Rate	Shielding - GTAW	Ar	100,0	6-9 l/min	Shielding - FCAW				Torching				Baking			
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POSITION (EN-405) Position of Groove _____ 3G _____ Weld Progression (Up/ht, Down/ht) _____ N/A _____ Other _____ N/A _____			ELECTRICAL CHARACTERISTICS (EN-409) Current _____ DC _____ Polarity _____ EN _____ Amperage _____ 95-110 _____ Volts _____ 10-12 _____ Tungsten Electrode Size _____ 2 _____ Heat Input _____ 0,61-1,71 kJ/mm _____ Mode of Metal Transfer for GMAW (FCAW) _____ N/A _____ Other _____ N/A _____																						
PREHEAT (EN-406) Preheat Temperature(Min.) _____ Min. 10° _____ Interpass Temperature(Max.) _____ Max. 200° _____ Other _____			TECHNIQUE (EN-410) Travel Speed(mm/min) _____ See below table _____ String or Weave Bead _____ String Bead _____ Oscillation _____ N/A _____ Multi-Stroke Pass (per side) _____ Multi Pass _____ Single or Multiple Electrodes _____ Single _____ Initial and Intermediate Cleaning _____ Grinding and Brushing _____ Method of Back Gouging _____ Grinding _____ Other(EN-410.11 / QW-410.6) _____																						
Actual Values																									
Weld Layers	Process	Filler Metal Class	Gas (liters)	Power / Primary	Average Range (W)	Heat Input (kJ/mm)	Travel Speed (mm/min)	Heat Input (kJ/mm)																	
3	GTAW	ER 308 L	2	DC EN	200-110	10-12	1,87	0,61-0,71																	
2	GTAW	ER 308 L	2	DC EN	95-110	10-12	1,88	0,61-0,85																	
1	GTAW	ER 308 L	2	DC EN	200-110	10-12	0,77	1,5-1,71																	
4	GTAW	ER 308 L	2	DC EN	95-200	10-11	0,6	1,15-1,37																	

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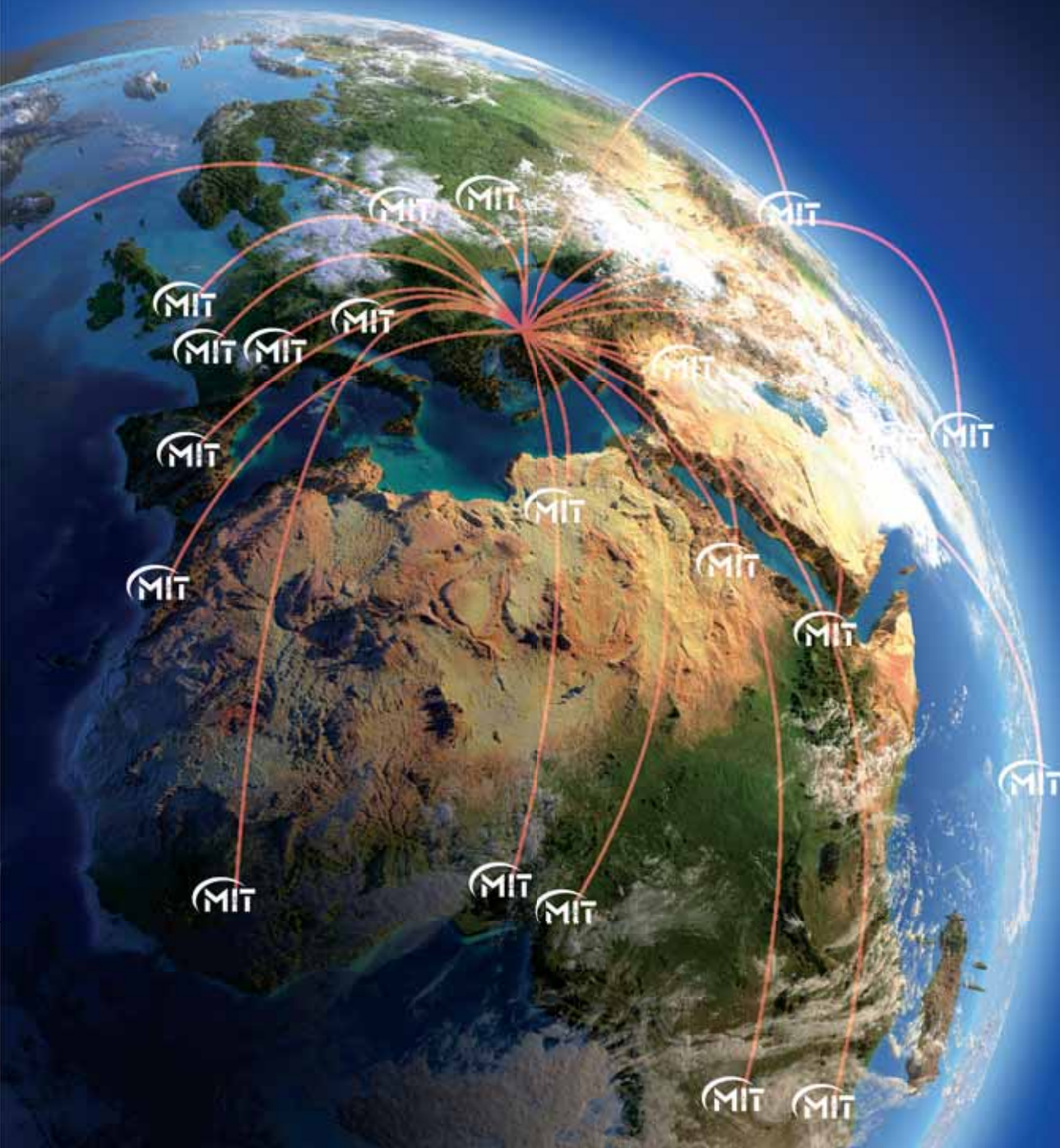
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