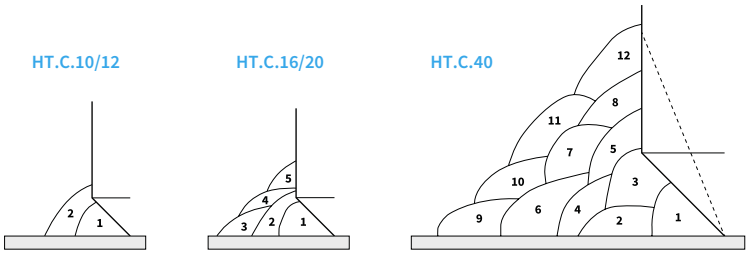
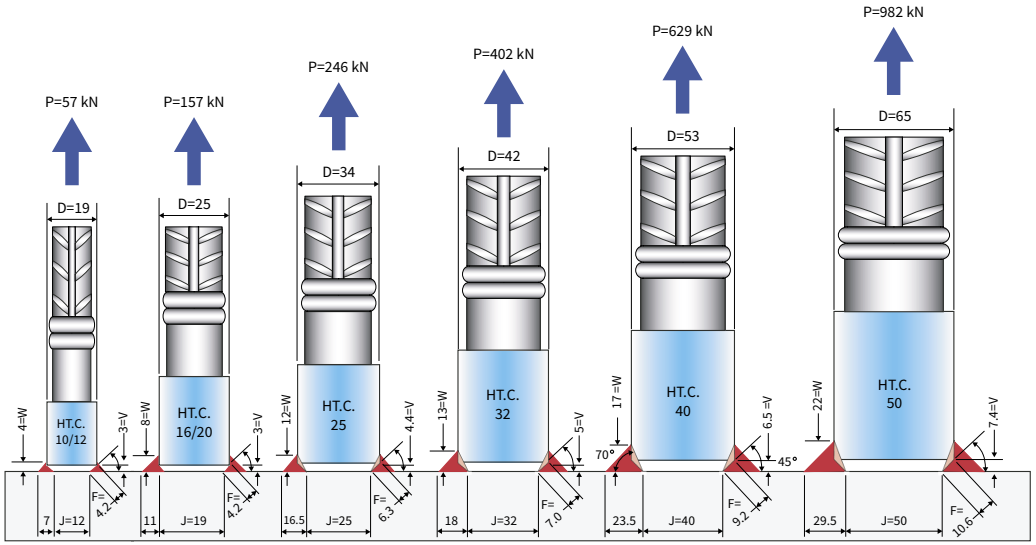
HT.C Connecting Couplers - Weld Advice

Indicative welding sequences and welding rod Ø for some typical HT.C Connecting Couplers





NOTES:

All weld joint designs are to be reviewed and instructed by the client's qualified engineer considering local and specific design requirements, material onto which the couplers are to be welded and conditions under which the work is undertaken.

This document is meant only to act as a guide for welding

- HY-TEN HT.C Connecting Couplers
- to 30mm thick steel plate, grade S235
- Using process 111 - Arc welding
- With electrode EN ISO 2560-A-E38 2
- RB Ø 2.5 ; 3.2 and 4.0 mm
- Current 100-1 BOA

Welding to be in accordance with

- EN 287-1 :2004-03-Welder qualification
- EN ISO 14731:2006-12-Coordination

To be read in conjunction with HY-TEN HT.C details, installation instructions and product brochure.

Weld design based on min 45° chamfer and can be used with chamfer up to 70°.

Engineer to consider site conditions and process in detail when welding 50 dia coupler.

Coupler	Rebar			Force	Coupler Dimensions (mm)-(45°-70°)				Weld (mm)	Plate	
Reference	Dia (mm)	A_s (mm²)	f_y (N/mm²)	P (kN)	D	J	F	V	W	Grade	Size (mm)
HT.C.10/12	12	113	500	57	19	12	4.2	3	4	S235	100x100x30
HT.C.16/20	16/20	314	500	157	25	20	4.2	3	8	S235	100x100x30
HT.C.25	25	491	500	246	34	25	6.3-12.7	4.4-11.5	12	S235	100x100x30
HT.C.32	32	804	500	402	42	32	7.0-14.1	5.0-12.5	13	S235	100x100x30
HT.C.40	40	1257	500	629	53	40	9.2-18.4	6.5-16.5	17	S235	100x100x30
HT.C.50	50	1963	500	982	65	50	10.6-21.2	7.4-21	22	S235	100x100x30