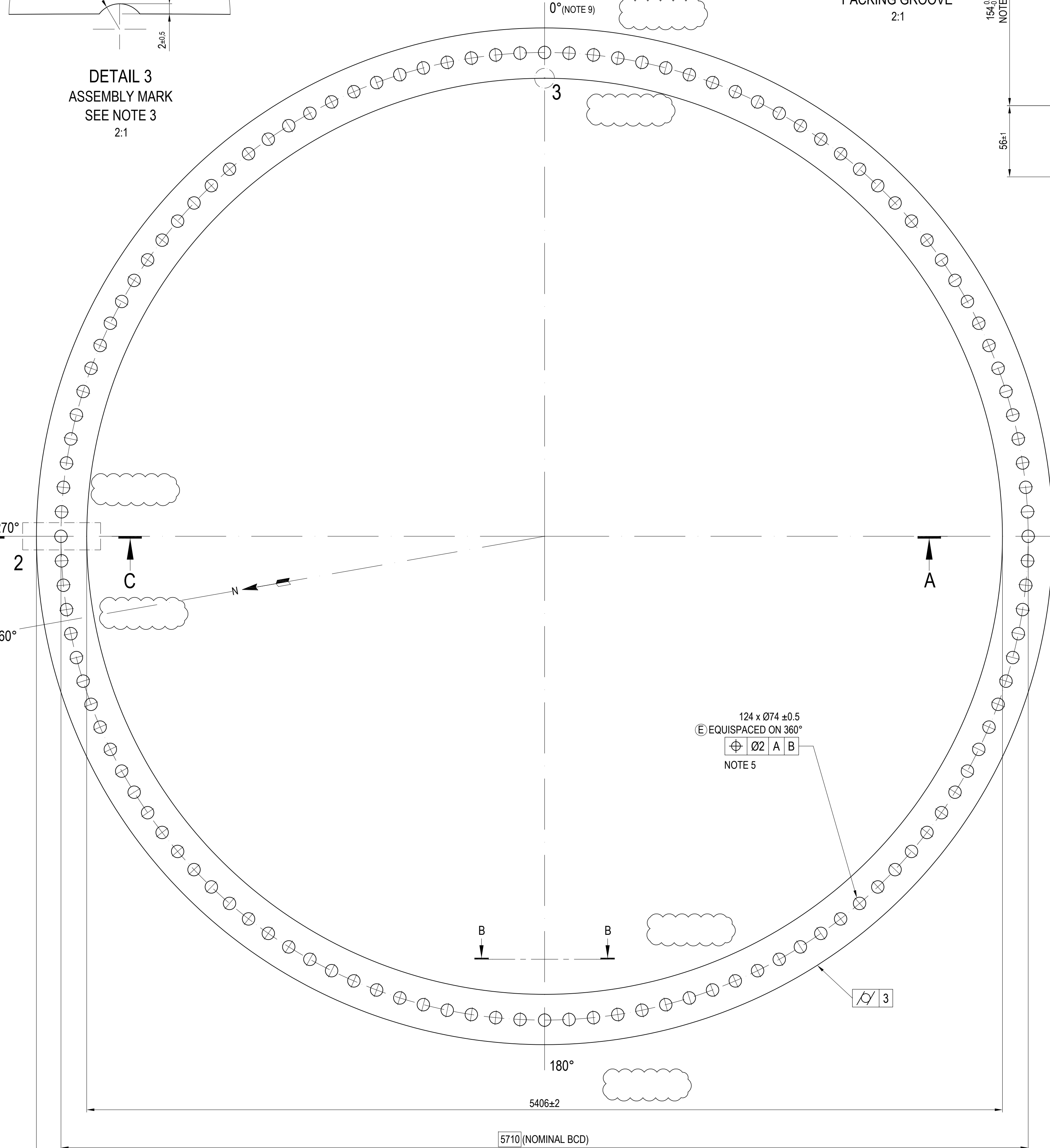
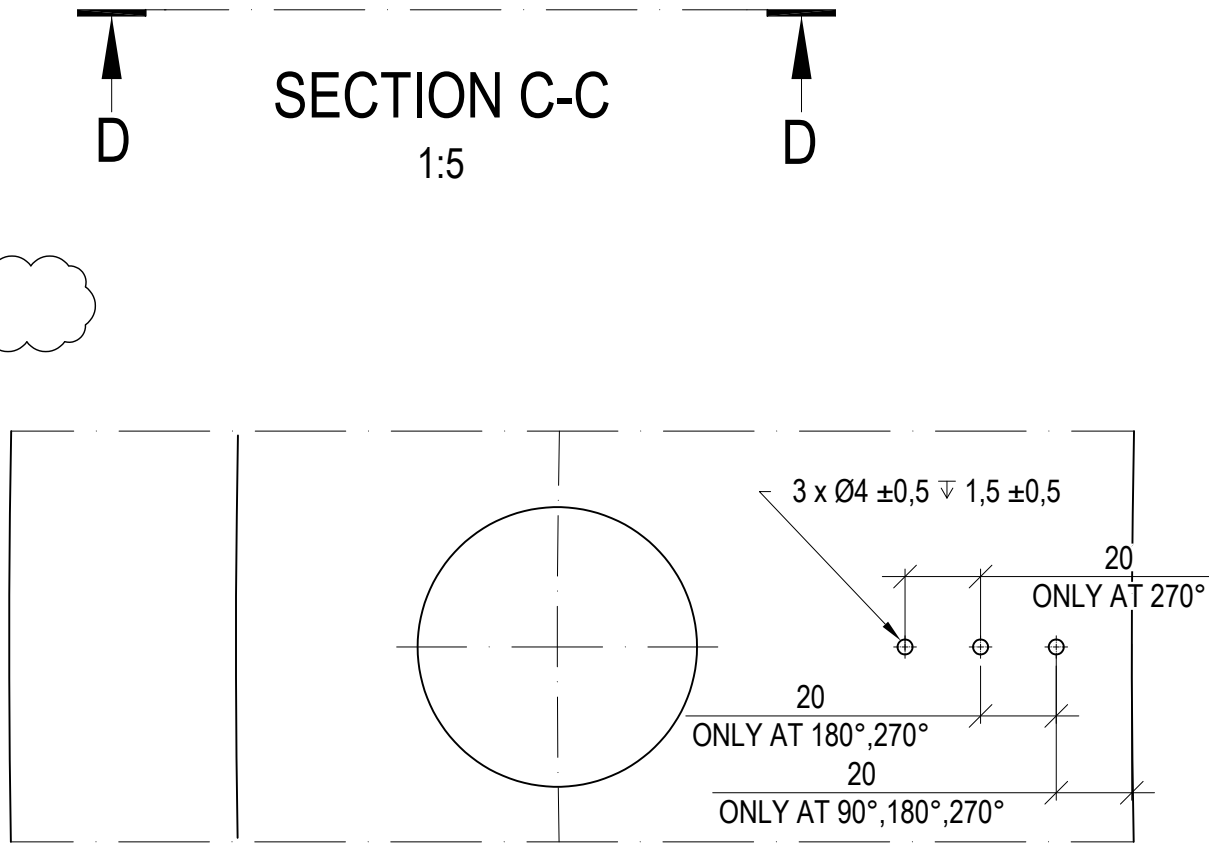
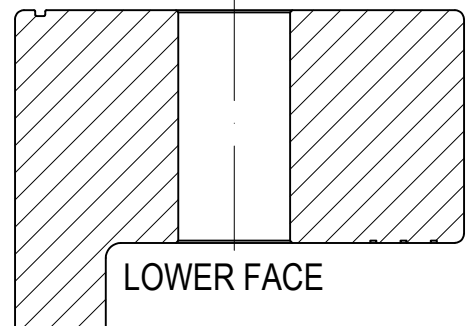
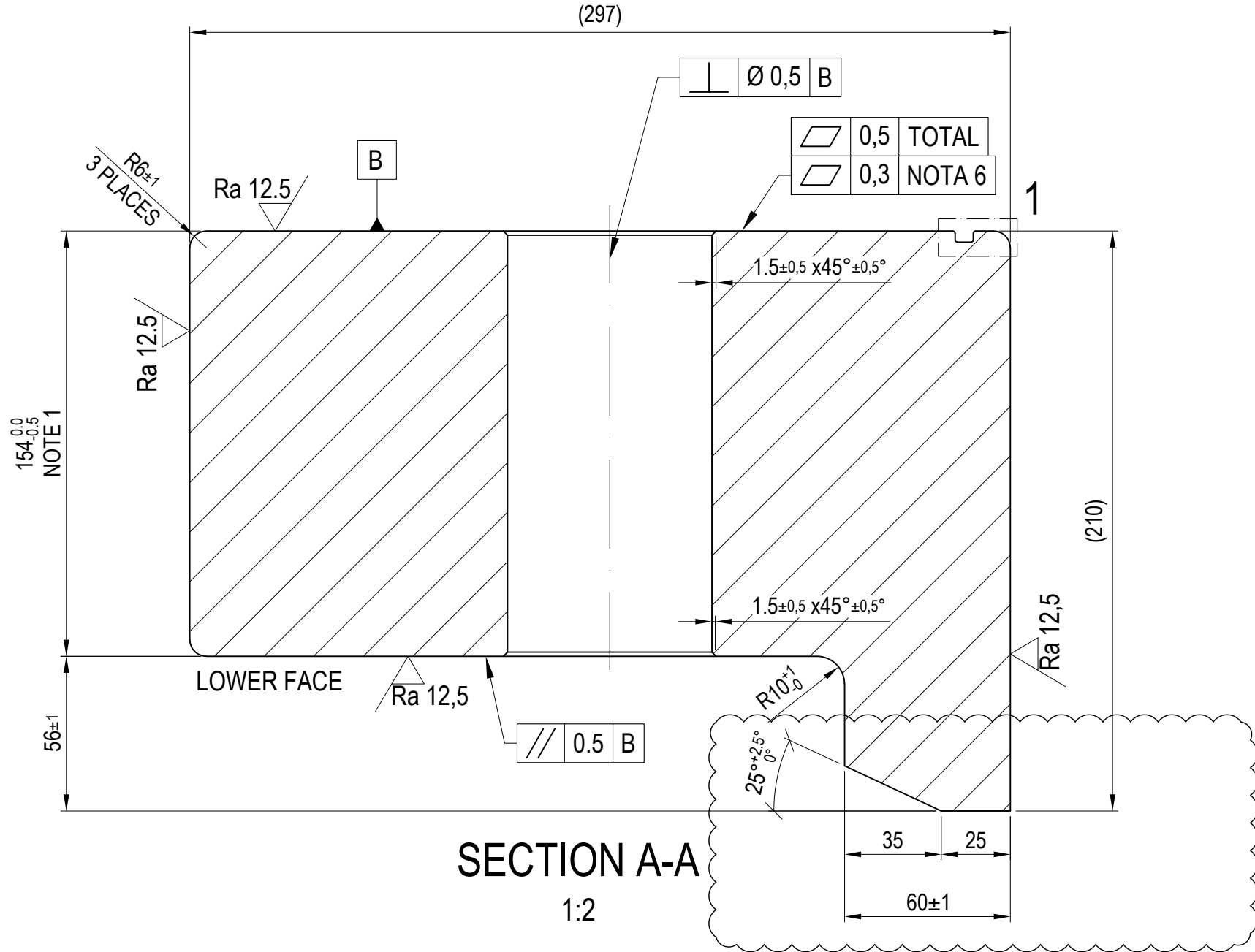
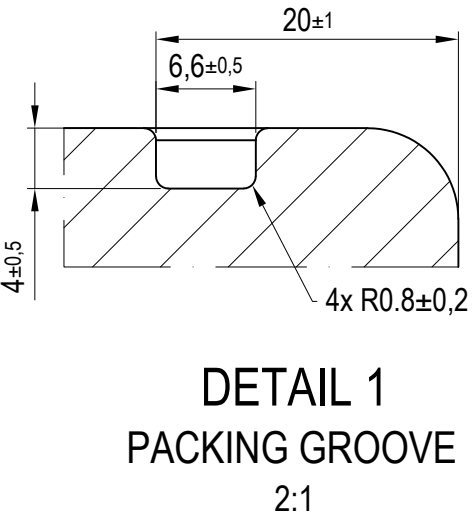
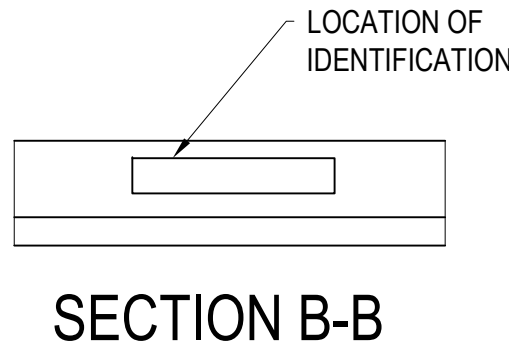
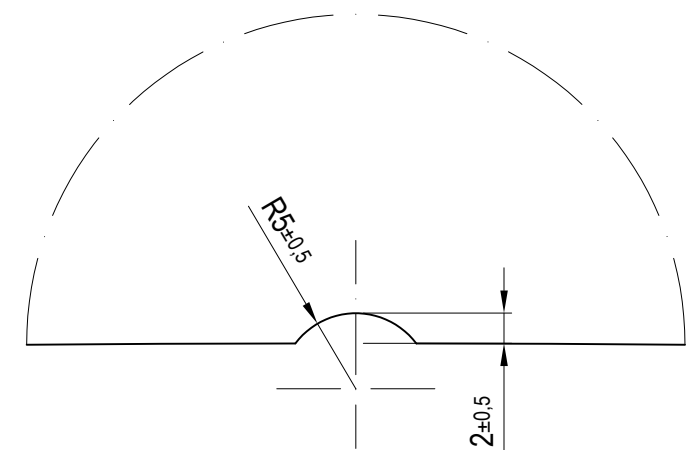
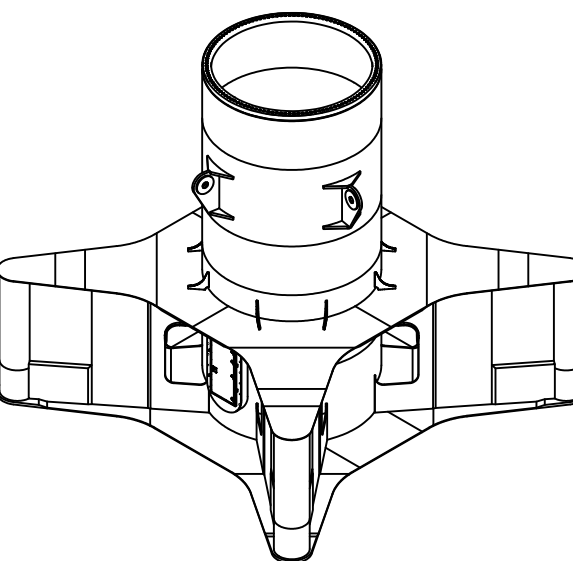
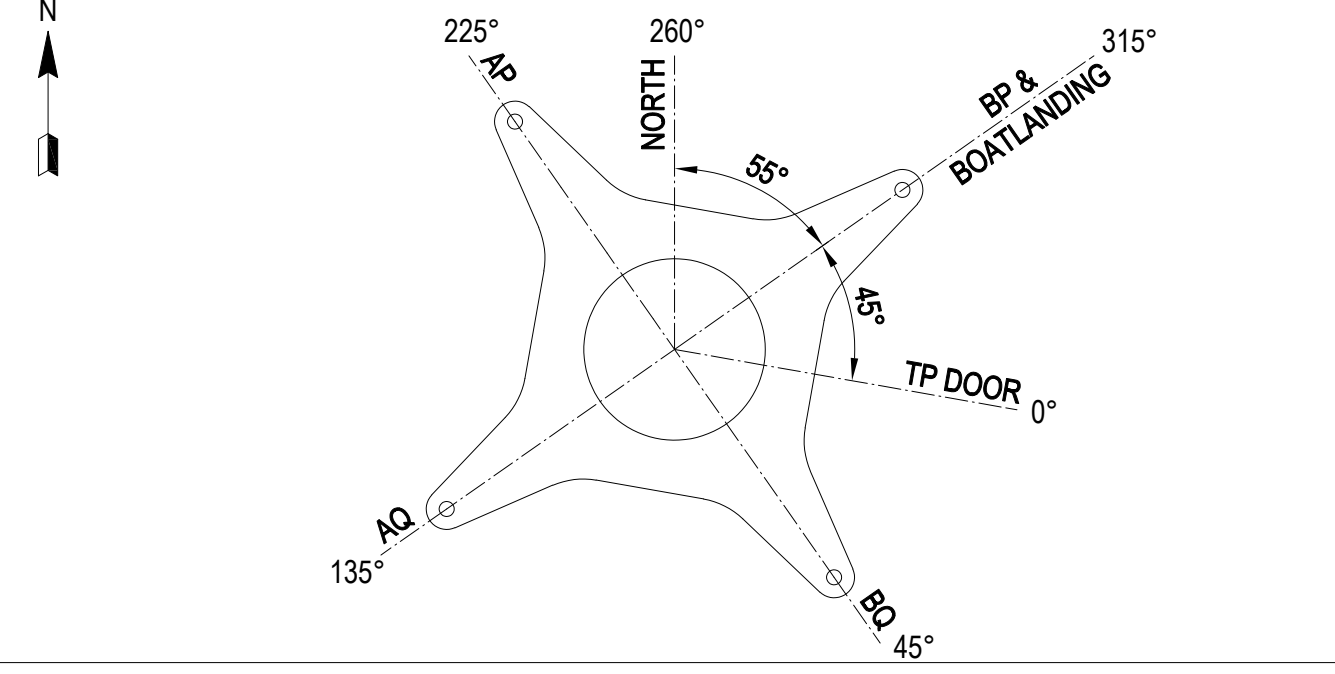


MACHINING FLANGE (FOR FLANGE SUPPLIER)



ASSEMBLY MARK
OPTION NO. 1
NOTE 3
INSIDE FLANGE
1:2



PRIMARY STEEL ACERO PRIMARIO	STRUCTURAL CAT. CAT. ESTRUCTURAL	EXECUTION CLASS CLASE EJECUCIÓN	INSPECTION CAT. CAT. INSPECCIÓN	MAT. CERTIF. CERTIF. MAT.
INTERFACE FLANGE	SPECIAL	EXC3	I	3.2

- GENERAL NOTES / NOTAS GENERALES:
- Increased thickness in order to allow machining after welding process if the flatness tolerance is not achieved.
 - To be checked only in case of machining the flange after the welding process (see sheet 2).
 - The assembly mark indicated in view detail 3 may be replaced by the alternative assembly mark. See detail name "Assembly mark - Option NO. 1)".
 - Flange material as per SGRE design drawing TRE-V10_SGR-MLB0001 & TQ NW-TECH-000005: S355NL-Z25-UT-S2/E3.
 - Positional tolerance shall be documented in the inspection report. Only applicable for flange manufacturer (before welding).
 - Local flatness to be measured within a section of 1 meter and calculated by the maximum deviation within 3 successive measuring points on the outer diameter acc. to GEN-V01_SIE-TFC004 - SGRE Foundation Flange Requirements rev25.
 - All measures to be performed according to GEN-V01_SIE-TFC004 - SGRE Foundation Flange Requirements rev25.
 - See sheet 2.
 - Reference for zero degree (0°) acc. to drawing TRE-V01_SGR-MQH0008.
 - Sobreespesor para permitir el mecanizado después del proceso de soldadura si no se logra la tolerancia de planitud.
 - A comprobar sólo en caso de mecanizar la brida después del proceso de soldadura (ver hoja 2).
 - La marca de montaje indicada en la vista detalle 3 podrá ser sustituida por la marca de montaje alternativa. Ver detalle nombre "Marca de montaje - Opción N° 1)".
 - Material de la brida según el plano de diseño SGRE TRE-V10_SGR-MLB0001 Y TQ NW-TECH-000005: S355NL-Z25-UT-S2/E3.
 - La tolerancia posicional se documentará en el informe de inspección. Solo aplicable para el fabricante de las bridas (antes de soldar).
 - Planitud local a medir dentro de una sección de 1 metro y calculada por la desviación máxima dentro de 3 puntos de medición sucesivos en el diámetro exterior según GEN-V01_SIE-TFC004 - SGRE Requisitos para Bridas de Cementación rev25.
 - Todas las medidas se realizarán de acuerdo con GEN-V01_SIE-TFC004 - Requisitos de bridas de cementación SGRE rev25.
 - Ver hoja 2.
 - La referencia para la marca de cero grados (0°) de acuerdo al plano TRE-V01_SGR-MQH0008.

COMPLEMENTARY DRAWINGS / PLANOS COMPLEMENTARIOS:

CLIENT DRAWINGS / PLANOS DEL CLIENTE:
TRE-V10_RBL-TLA0035 CLUSTER 1-3 - TRANSITION PIECE - INTERFACE FLANGE
GEN-V01_SIE-TFC004 SGRE Foundation Flange Requirements rev25
TRE-V10_SGR-MLB0001 Interface Flange drawing
TRE-V01_SGR-MQH0008 66kV E-TP mechanical Interface drawing

TQ'S REFERENCE / TQ'S DE REFERENCIA:

NW-TECHQ-000005 Transition Piece - Interface flange

NW-TECHQ-000011 Interface flange bolt size and ovality tolerance

PROJECT NAME / NOMBRE DEL PROYECTO	CLIENT / CLIENTE
LE TREPORT OFFSHORE WIND FARM	
01	ON HOLD/ DELETED / SE ELIMINAN PUNTOS DE ESPERA
02	GENERAL EDITION / EDICIÓN GENERAL
REV.	REVISION SUBJECT / OBJETO DE LA REVISIÓN
01	27/02/2023
02	17/02/2023
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