Article

Green Pin® Stainless steel weld-on transport ring (PASI)

Subject

Instructions for use – Green Pin® Stainless steel weld-on transport ring (PASI)

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Ref

PI-03-02 EN

Revision

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PASI

Frequently Asked Questions

Subject: Instructions for use – Green Pin® Stainless steel weld-on transport ring (PASI)
Note: Main dimensions, general info and warnings can be found in our latest catalogue.

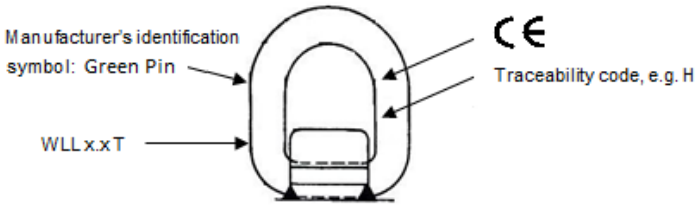
Green Pin® Stainless steel weld-on transport ring

- Material : AISI 316L
- Safety Factor : MBL equals 4 x WLL

1) Description of stainless steel weld-on transport rings PASI

- Stainless steel weld-on transport rings (PASI) need to be welded onto machines in order to secure them.
- The PASI base and ring are made of AISI 316L

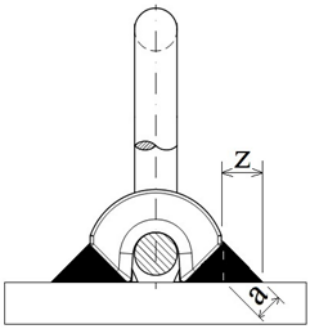
Marking :



2) Instructions for welding and maintenance

Welding:

- Welding must be done in accordance with EN 3581 for manual metal arc welding and to EN ISO 14343 for arc welding.
- The surface must be flat and allow optimal resistance to the load. The base must be able to withstand 2.5 times the WLL without deformation (Proof Load) and a Minimum Break Load of 4 times the WLL.
- The parts must be free of impurities such as oil, paint, grease etc.
- The surface on which the PASI is to be welded has to be weldable, free from rust, paint and degreased prior to welding. It must be flat and must be able to transfer the load.
- Use a stainless steel brush.
- The welder must be qualified according to EN 287-1.
- For manual welding, use an E 318 electrode. For the 1st pass, use a Ø 2.5 mm electrode. For the subsequent passes, use Ø 3.25 to 5 mm electrodes.
- Before welding, angle the base, creating a small space in order to obtain a continual HR welding pass.
- First, one pass of 3 mm high is recommended, then a HR continual pass, and finally an allowance (process similar to an angle welding).
- To give enough strength to the welded transport ring, it is necessary that welds are at least according the dimensions in the table.



Size	Weld size a	Weld size z
PAS0.75I	8	12
PAS1.25I	9	13
PAS3.20I	11	16
PAS5I	14	20

- The welding must be continual on the front surfaces of the plinth. The cranks must be free of impurity (oil, grease, paint).
- Prevent contact between the link and the deposited weld metal as long as it still hot.
- The quality of the welding must be inspected by a competent person.
- It is preferable to proof load the PAS and weld with a load of 1.25 x Lashing Capacity (LC) for lashing, or 2.5 x WLL for lifting.
- Avoid contact between the ring and the filler metal.
- Install components so that no interfering of pivot or handling occur.

Maintenance :

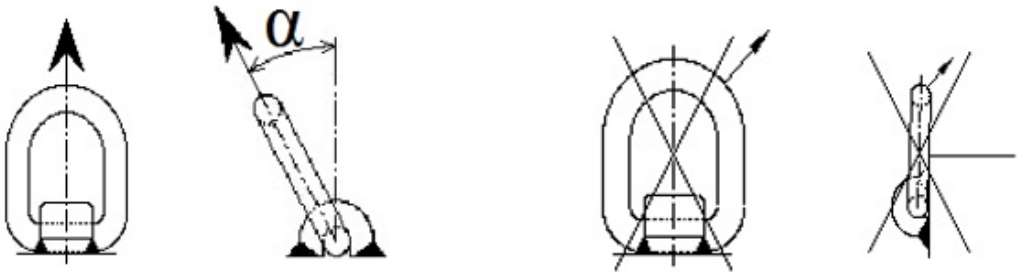
- The transport rings have to be regularly checked visually. They must be inspected at least annually by an expert.
- Do not use transport rings that are rusted, bent, show any visual damage, or have been immersed in an acidic solution. A visual inspection is necessary before use.

3) Use limitations

- During engineering and use, please respect the current load rules (EN 12195 – 1, 2, 3, 4)
- Never exceed the WLL indicated on the PAS..I
- Fix the transport rings in order to prevent any damage with the load system.
- Fix the transport rings so that the load is stable and not outlying.
- Never machine or grind. Modifications or repair must only be carried out by the manufacturer.
- For corrosion resistance to specific chemicals, our catalogue must be consulted.
- Temperature reduces the WLL according to the following values :

-40°C	-	+200°C :	0%
+200°C	-	+300°C :	-10%
+300°C	-	+400°C :	-25%

- The transport rings must not be used at temperatures above or below these values.
- The selection of the transport ring depends on the angles of the used slings.
- The eye must move freely to adapt the sling angle.
- The force applied on the transport rings cannot be higher than the WLL mentioned in the catalogue. The WLL corresponds to the worst condition, i.e. α = 90°.



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If you have further questions, please do not hesitate to contact us.
Kind regards,

Van Beest Product Management