

CAPABILITY SHEET

The hall, in numbers

Contract fabrication of welded steel structures in one hall in Slovakia. EXC2 to EN 1090-2, EN ISO 3834-2 welding, laser cutting to 20 mm, 400 t press brake.

Welding process	EN 1090-2	Maximum plate thickness, laser	Press brake force
MAG 135	EXC2	20 mm	400 t

CAPACITY ENVELOPE

CNC LASER CUTTING

Laser bed	2 000 x 4 000 mm
Laser power	3 200 W
Maximum plate thickness, laser	20 mm

CNC BENDING

Press brake force	400 t
Press brake table length	6 050 mm
Press brake stroke	365 mm

WELDING

Robotic welding track	14 m
Robot reach	R 2 008 mm
Welding process	MAG 135
Structural steel, certified thickness (ISO/TR 15608 group 1)	up to 40 mm
Austenitic stainless, certified thickness (ISO/TR 15608 group 8)	3 to 16 mm
Weld quality level (EN ISO 5817)	level C at EXC2

MACHINING

Horizontal boring mill travel X, Y, Z	6 200 x 3 000 x 1 600 mm
Rotary table and load	1 800 x 2 500 mm, 16 000 kg

MACHINING

Spindle diameter	160 mm
Horizontal boring mill travel X, Y, Z	3 500 x 2 500 x 1 600 mm
Rotary table and load	1 800 x 2 500 mm, 12 000 kg
Spindle diameter	130 mm
Horizontal mill travel X, Y, Z	8 000 x 3 000 x 1 500 mm
CNC lathe travel	X 285 mm, Z 890 / 1 590 mm
CNC lathe swing	550 mm over bed, 350 mm over cross slide
Vertical lathe, maximum diameter	1 100 mm, table 800 mm
Vertical lathe, maximum height and mass	765 mm, 2 500 kg
Gear hobbing, maximum wheel diameter	600 mm
Gear hobbing, module	m 2 to 13, currently 5.5 to 6.5
Gear hobbing, tooth width and count	110 mm, 5 to 120 teeth

BLASTING AND PAINTING

Blasting chamber	8 000 x 5 000 x 3 000 mm
Spray and curing booth	7 900 x 5 000 x 4 890 mm
Curing temperature	75 to 80 °C

INSPECTION

Dimensional measurement	6-axis measuring arm
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ASSEMBLY

Not published, confirmed per enquiry: Crane capacity in the hall · Maximum weldment length, width, height and mass · Largest piece on a standard truck versus oversize transport · Hall dimensions and door openings

MATERIALS

Structural steel, S235 and S355: up to 40 mm (ISO/TR 15608 group 1)

Austenitic stainless steel: 3 to 16 mm (ISO/TR 15608 group 8)

Aluminium is outside the certified welding scope and is not offered.

SURFACE TREATMENT

As welded, mill scale on, machined faces protected · In house

Blasted to EN ISO 8501-1 Sa 2½ · In house

Primer, to the drawing's paint specification · In house

Wet paint top coat, cured at 75 to 80 °C, to RAL · In house

Hot-dip galvanising, on request · On request

WHAT SHIPS WITH THE WORK

Welding procedure specifications (WPS) · Standard
Welding procedure qualification records (WPQR) · Standard

Welder qualification certificates · Standard

Visual weld inspection record · Standard

Dimensional inspection report · Standard

Material certificates 3.1 · On request

Supplementary NDT beyond visual (UT, MT, PT) · On request

Coating thickness report · On request

CERTIFICATES

EN ISO 3834-2:2006 · W348721 · PQM, s.r.o., Banská Bystrica

ISO 9001:2015 · Q648721 · PQM, s.r.o., Banská Bystrica

ISO 14001:2015 · E348721 · PQM, s.r.o., Banská Bystrica

A declaration of performance under EN 1090-1 is not offered on this site: the parent company publishes no EN 1090-1 factory production control certificate. Work is executed to EN 1090-2, execution class EXC2, under the certified EN ISO 3834-2 system.