

Prüfbericht Nr: 16/655/0591-1-1

# Bewertungsbogen für Betonstahlschweißungen nach DIN EN ISO 17 660

☐ eingeschränkt

Besteller: Stahlbau Wegscheid GmbH

Schweißverfahren: 135 (Metall-Aktivgasschweißen (MAG))

Schweißaufsicht: Hr. Gottinger

Schweißzusatz: ISO 14341-A - G 42 3 M 4Si1

Schweißer: Hr. Alois Schwarz

Schweißdatum: 27.07.2016

| Probe Nr. | Probe n. Bild<br>EN 17660 | Schweißposition | Stahlsorte<br>(l,q,t) | Abmessung           |                     |        | Äußere Bewertung n. ISO 5817 | Bruchkraft |          | Bruchlage<br>(s,ü,g) | Scherfaktor-<br>klasse | Biegewinkel | Innere Bewertung<br>n. ISO 5817 | Bemerkung | Bewertung |
|-----------|---------------------------|-----------------|-----------------------|---------------------|---------------------|--------|------------------------------|------------|----------|----------------------|------------------------|-------------|---------------------------------|-----------|-----------|
|           |                           |                 |                       | Ø <sub>1</sub> [mm] | Ø <sub>2</sub> [mm] | t [mm] |                              | soll [kN]  | ist [kN] |                      |                        |             |                                 |           |           |
| S1        | C.1                       | PF              | I: B500B              | 20                  | ---                 | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| S2        | C.1                       | PF              | I: B500B              | 20                  | ---                 | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| S3        | C.1                       | PC              | I: B500B              | 20                  | ---                 | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| Ü1        | C.2                       | PA              | I: B500B              | 28                  | ---                 | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| Ü2        | C.2                       | PF              | I: B500B              | 28                  | ---                 | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| Ü3        | C.2                       | PC              | I: B500B              | 28                  | ---                 | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| L1        | C.3                       | PA              | I: B500B              | 28                  | 16                  | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| L2        | C.3                       | PF              | I: B500B              | 28                  | 16                  | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| L3        | C.3                       | PC              | I: B500B              | 28                  | 16                  | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| K1z       | C.4                       | PB              | I/q: B500B            | 16                  | 16                  | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| K2z       | C.4                       | PB              | I/q: B500B            | 16                  | 16                  | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| K3z       | C.4                       | PB              | I/q: B500B            | 16                  | 16                  | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| K1s       | C.5                       | PB              | I/q: B500B            | 8                   | 28                  | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| K2s       | C.5                       | PB              | I/q: B500B            | 8                   | 28                  | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| K3s       | C.5                       | PB              | I/q: B500B            | 8                   | 28                  | ---    | ---                          | ---        | ---      | ---                  | ---                    | ---         | ---                             | ---       | ---       |
| A1        | C.9c                      | PB              | I: B500B/ t: S235     | 8                   | ---                 | 8      | e                            | 27,19      | 32,5     | g                    | ---                    | ---         | ---                             | ---       | e         |
| A2        | C.9c                      | PB              | I: B500B/ t: S235     | 28                  | ---                 | 30     | e                            | 332,56     | >400     | ---                  | ---                    | ---         | ---                             | ---       | e         |
| A3        | C.9c                      | PB              | I: B500B/ t: S235     | 32                  | ---                 | 30     | e                            | 434,34     | 549,6    | g                    | ---                    | ---         | ---                             | ---       | e         |

Stahlsorte: l = Längsstab, q = Querstab, t = Blech Abmessung: Ø1 = zu prüfender Stab

Bruchlage: s = Schweißgut, ü = Übergangszone, g = Grundwerkstoff

Befund n. ISO 5817: o.B = ohne Beanstandung 301 (B) = Schlackeneinschluß  
100 (E) = Riss 401 (C) = Bindefehler  
2012 (Aa) = Pore 500 (F) = Einbrandkerbe  
2016 (Ab) = Schlauchpore

Bewertung: e = erfüllt, ne = nicht erfüllt

Fachkundliche Prüfung: erfüllt

Praktische Prüfung: erfüllt

Prüfstelle: GSI mbH NL SLV München

Sachbearbeiter / Datum: W.Schnabel / 15.09.2016

