

ArcelorMittal Europe - Long Products  
Sections and Merchant Bars



ArcelorMittal

## WELD PREPARATION OF JUMBO BEAMS



ArcelorMittal beam finishing centre C3P offers complete range of fabrication and finishing operations to improve the technical capabilities from our partners, steel fabricators and general contractors: cold sawing, drilling, cambering, bending, oxyacetylene cutting, flame cutting, robotic plasma cutting.

In addition, we provide value added service such as weld preparation of JUMBO profiles, with exceptional cutting tolerances and quality workmanship.

### Main advantages :

- **Product is supplied in ready-to-install conditions**
- **Increased processing capability of heavy sections**
- **Time and cost saving for steel fabricators**

The joint design and the joint preparation are two of the most important factors which affects the quality and cost of the completed weld. Time spent in preparing the joint properly is more than compensated by higher welding speeds and better quality welds.

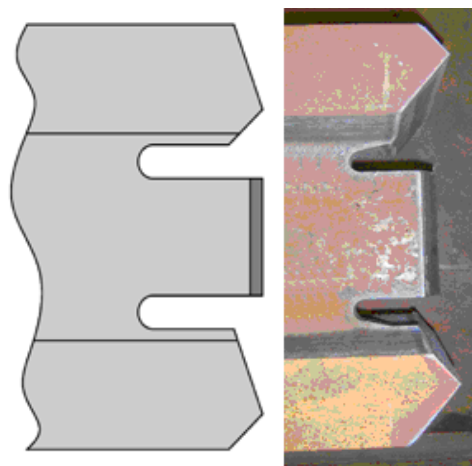
Correct and accurate edge preparations are essential for the production of sound, defect-free welds.

Edge preparations are required to achieve full penetration to the root of the joint helping the welder to produce defect free joints.

All weld access holes required to facilitate welding operations shall have a length (l) from the toe of the weld preparation not less than 1-1/2 times the thickness of the material in which the hole is made.

The height (h) of the access hole shall be adequate for deposition of sound weld metal in the adjacent plates and provide clearance for weld tabs for the weld in the material in which the hole is made, but not less than the thickness of the material.

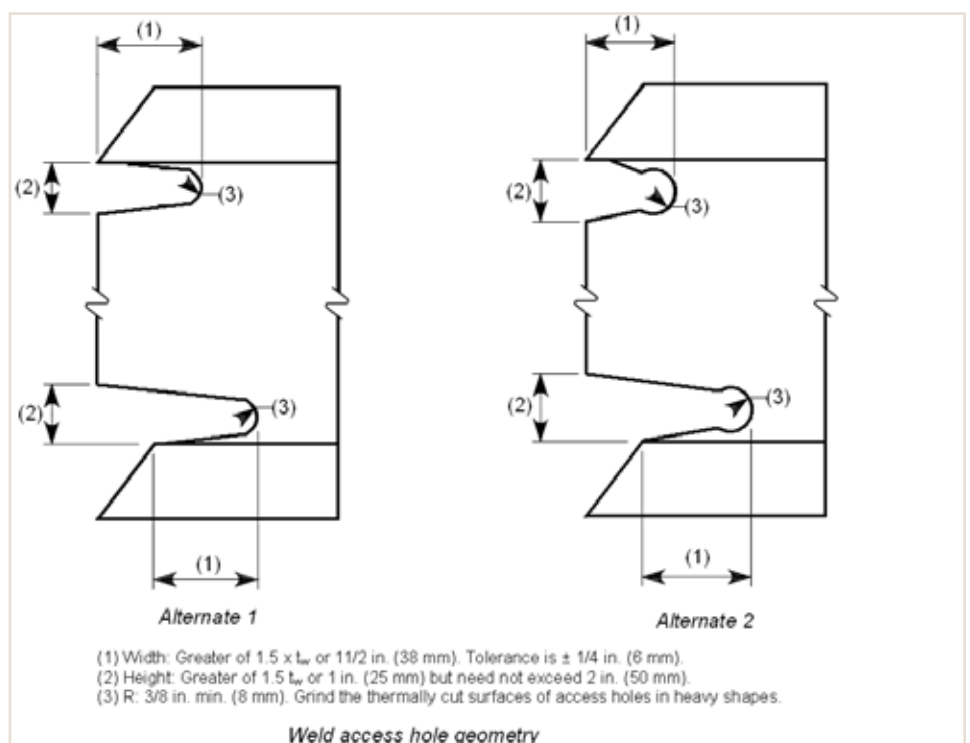
In structural shapes all beam copes and weld access holes shall be shaped free of notches or sharp reentrant corners.



Bevel example

### DELIVERY CONDITIONS

- Drawings to be supplied by the customer and subject to agreement
- Weld preparation of steel sections with flange thickness up to 140mm
- Surface quality according EN 1090-2 / ISO 9013 and AISC
- The thermally cut surfaces of beam copes and weld access holes are being ground to bright metal and inspected by either magnetic particle or dye penetrant methods, if specified



### ArcelorMittal Commercial Sections

66, rue de Luxembourg | L-4221 Esch-sur-Alzette | Luxembourg

T +352 5313 3010 | F +352 5313 2799 | sections.tecom@arcelormittal.com | [sections.arcelormittal.com](http://sections.arcelormittal.com)