

Finishing: Surface treatment & Welds

General code for recycling & handling-products:

FS (Finishing Specific)

-Welds according drawing
-Surface treatments according specifications

Welded shut

Product chute: continuously welded
Outside the product chute: intermittent welded

Product chute: continuously welded
Outside the product chute: welded shut

Product chute: continuously welded
Outside the product chute: continuously welded where possible

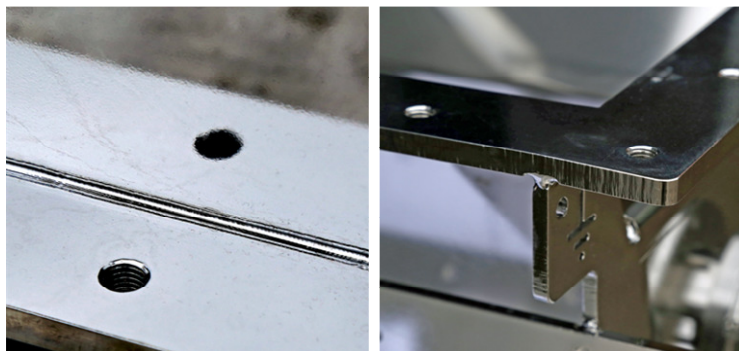
All welds: continuously welded

Product chute: continuously welded
Welds including finishing
Outside the product chute: continuously welded where possible

All welds: continuously welded
Welds inside product chute including finishing

Special weld instruction – to be described in article specifications

	WB	WE	WH	Wm	WM	Wt	WT	WZ	
Grit blasted Ra 3 µm (inside/outside)	S1	F1B	F1E	F1H	F1m	F1M	F1t	F1T	F1Z
Pickled and passivated Ra 0,8 µm (inside/outside, excluding welds / end faces)	S3	F3B	F3E	F3H	F3m	F3M	F3t	F3T	F3Z
Polished with vibratory finishing Ra 0,4 µm (inside/outside, excluding welds / end faces)	S5	F5B	F5E	F5H	F5m	F5M	F5t	F5T	F5Z
Electrolytic polished Ra 0,6 µm (inside/outside, excluding welds / end faces)	S7	F7B	F7E	F7H	F7m	F7M	F7t	F7T	F7Z
Hygienic wet blasted Ra 0,6 µm (inside/outside, excluding welds / end faces)	S8	F8B	F8E	F8H	F8m	F8M	F8t	F8T	F8Z
Manually polished Ra 0,4 µm (inside/outside, excluding welds / end faces outside product chute)	S9	F9B	F9E	F9H	F9m	F9M	F9t	F9T	F9Z
Special treatment/coating – To be described in article specifications	SZ	FZB	FZE	FZH	FZm	FZM	FZt	FZT	FZZ



Preference

Optional

Optional:
expensive,
long delivery

Improper choice

Hygienic version

- Excluding welds and end faces outside the product chute, means:
- on end faces some laser beam markings will remain
 - on welds some weld pool markings will remain