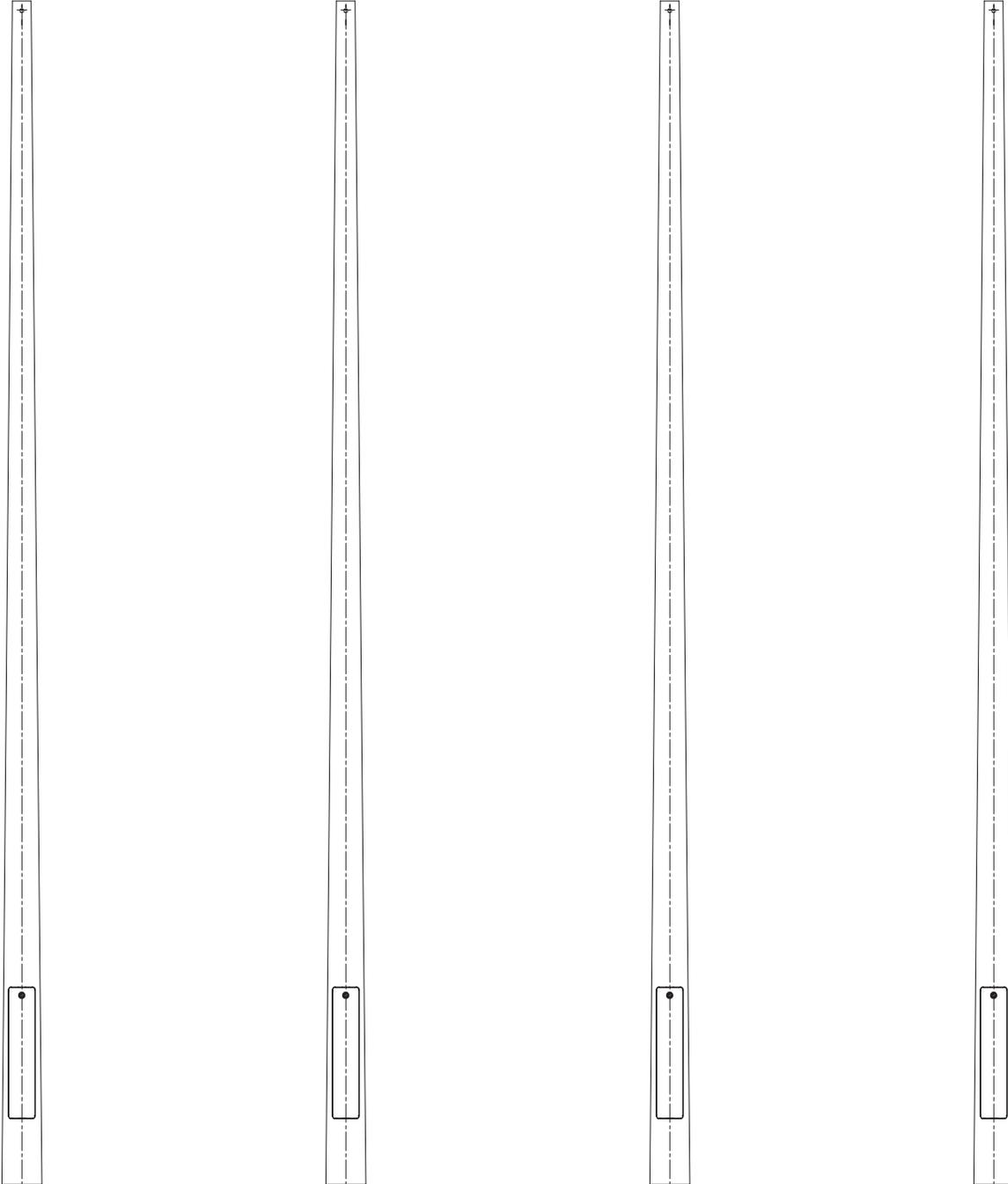


eWO



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Types of  
conical poles

WELDING PROCESS

The trapezoidal sheet metal is subjected to truncated cone forming using bending presses served by numerically controlled automatic manipulators. The edges of the truncated cone are then joined longitudinally by means of automatic and manual welding procedures.

The welds are carried out following Welding Procedure Specifications (WPS) compliant with the UNI EN ISO 15609-2 standards and adopting qualified procedures (WPAR) compliant with the UNI EN ISO 15614-1 standards. The welding is subjected to a visual inspection (VT) performed by qualified personnel in compliance with the UNI EN 473 standard.



Raised weld seam	YES
Presence of defects	YES
Mechanical performance	Standard
Examples	MKF / MKF-F
Price	Standard

LAMINATION PROCESS

The pole is obtained by hot rolling a S235J0 UNI EN 10025 steel tube welded at high frequency (ERW - Electric Resistance Welding). Lamination takes place at a temperature of 700° C and the processing, entirely managed by numerical control, is aimed at increasing the mechanical characteristics of the pole: the increase in thickness (from the base to the top) due to hot rolling gives the pole superior performance. The lamination process also generates an aesthetically very valuable product given the absence of external welding, showing a perfectly uniform surface.

From a quality control point of view, the processing tolerances comply with the UNI EN 40-2 standard and each processing phase is subject to constant inspection by the employees who work under the supervision of the department manager, who reports directly to the Quality Control office.



Raised weld seam	NO
Presence of defects	NO
Mechanical performance	Superior
Examples	MKG / MKG-F
Price	Higher