
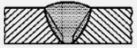



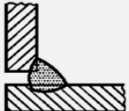



| ISO 15614-1  |                    |  |      |     |  |     |  |       |                    | ISO 15614-2   |                    |     |   |      |   |  |
|--|--------------------|--|------|-----|--|-----|--|-------|--------------------|---|--------------------|-----|---|------|---|--|
| A tope   |                    |  |      |     | En Ángulo  |     |  |       |                    | A tope  |                    |     | En Ángulo   |      |   |  |
| <br>Pasada simple |                    | <br>Pasada Múltiple |      |     |  |     | <br>Pasada simple |       |                    |  |                    |     |  |      |  |  |
| Espeor   | Espeor cualificado |  |      |     | Espeor cualificado   |     | Garganta   |       | Espeor cualificado |   | Espeor cualificado |     | Garganta  |      |   |  |
| 1  | 0.5                | 2  | 0.5  | 2   | 0.7  | 2   | 0.8  | 1.5   | 0.5                | 2   | 0.5                | 2   | 0.8   | 1.5  |   |  |
| 1.5  | 0.75               | 3  | 0.75 | 3   | 1.05   | 3   | 1.1  | 2.3   | 0.75               | 3   | 0.75               | 3   | 1.1   | 2.3  |   |  |
| 2  | 1                  | 4  | 1    | 4   | 1.4  | 4   | 1.5  | 3.0   | 1                  | 4   | 1                  | 4   | 1.5   | 3.0  |   |  |
| 2.5  | 1.25               | 5  | 1.25 | 5   | 1.75   | 5   | 1.9  | 3.8   | 1.25               | 5   | 1.25               | 5   | 1.9   | 3.8  |   |  |
| 3  | 1.5                | 6  | 1.5  | 6   | 2.1  | 6   | 2.3  | 4.5   | 1.5                | 6   | 1.5                | 6   | 2.3   | 4.5  |   |  |
| 4  | 3                  | 5.2  | 3    | 8   | 3  | 8   | 3.0  | 6.0   | 3                  | 8   | 3                  | 8   | 3.0   | 6.0  |   |  |
| 5  | 3                  | 6.5  | 3    | 10  | 3  | 10  | 3.8  | 7.5   | 3                  | 10  | 3                  | 10  | 3.8   | 7.5  |   |  |
| 6  | 3                  | 7.8  | 3    | 12  | 3  | 12  | 4.5  | 9.0   | 3                  | 12  | 3                  | 12  | 4.5   | 9.0  |   |  |
| 8  | 4                  | 10.4   | 3    | 16  | 3  | 16  | 6.0  | 12.0  | 3                  | 16  | 3                  | 16  | 6.0   | 12.0 |   |  |
| 10   | 5                  | 13   | 3    | 20  | 3  | 20  | 7.5  | 15.0  | 3                  | 20  | 3                  | 20  | 7.5   | inf  |   |  |
| 12   | 6                  | 15.6   | 3    | 24  | 3  | 24  | 9.0  | 18.0  | 3                  | 24  | 3                  | 24  | 7.5   | inf  |   |  |
| 15   | 7.5                | 16.5   | 7.5  | 30  | 3  | 30  | 11.3   | 22.5  | 3                  | 30  | 3                  | 30  | 7.5   | inf  |   |  |
| 20   | 10                 | 22   | 10   | 40  | 3  | 40  | 15.0   | 30.0  | 3                  | 40  | 3                  | 40  | 7.5   | inf  |   |  |
| 25   | 12.5               | 27.5   | 12.5 | 50  | 3  | 50  | 18.8   | 37.5  | 20                 | inf   | 20                 | inf | 7.5   | inf  |   |  |
| 30   | 15                 | 33   | 15   | 60  | 5  | inf | 22.5   | 45.0  | 24                 | inf   | 24                 | inf | 7.5   | inf  |   |  |
| 40   | 20                 | 44   | 20   | 80  | 5  | inf | 30.0   | 60.0  | 32                 | inf   | 32                 | inf | 7.5   | inf  |   |  |
| 50   | ----               | ----   | 25   | 100 | 5  | inf | 37.5   | 75.0  | 40                 | inf   | 40                 | inf | 7.5   | inf  |   |  |
| 100  | ----               | ----   | 50   | 200 | 5  | inf | 75.0   | 150.0 | 80                 | inf   | 80                 | inf | 7.5   | inf  |   |  |

| Diámetro | Diámetro cualificado |  | Diámetro cualificado    |    |
|----------|----------------------|--|-------------------------|----|
| 0...25   | $\geq 0.5 D$         |  | 0.5D                    | 2D |
| >25      |                      |  | $\geq 0.5 D$ (min 25mm) |    |

12mm si hay requisitos de impacto y no se han realizado los ensayos