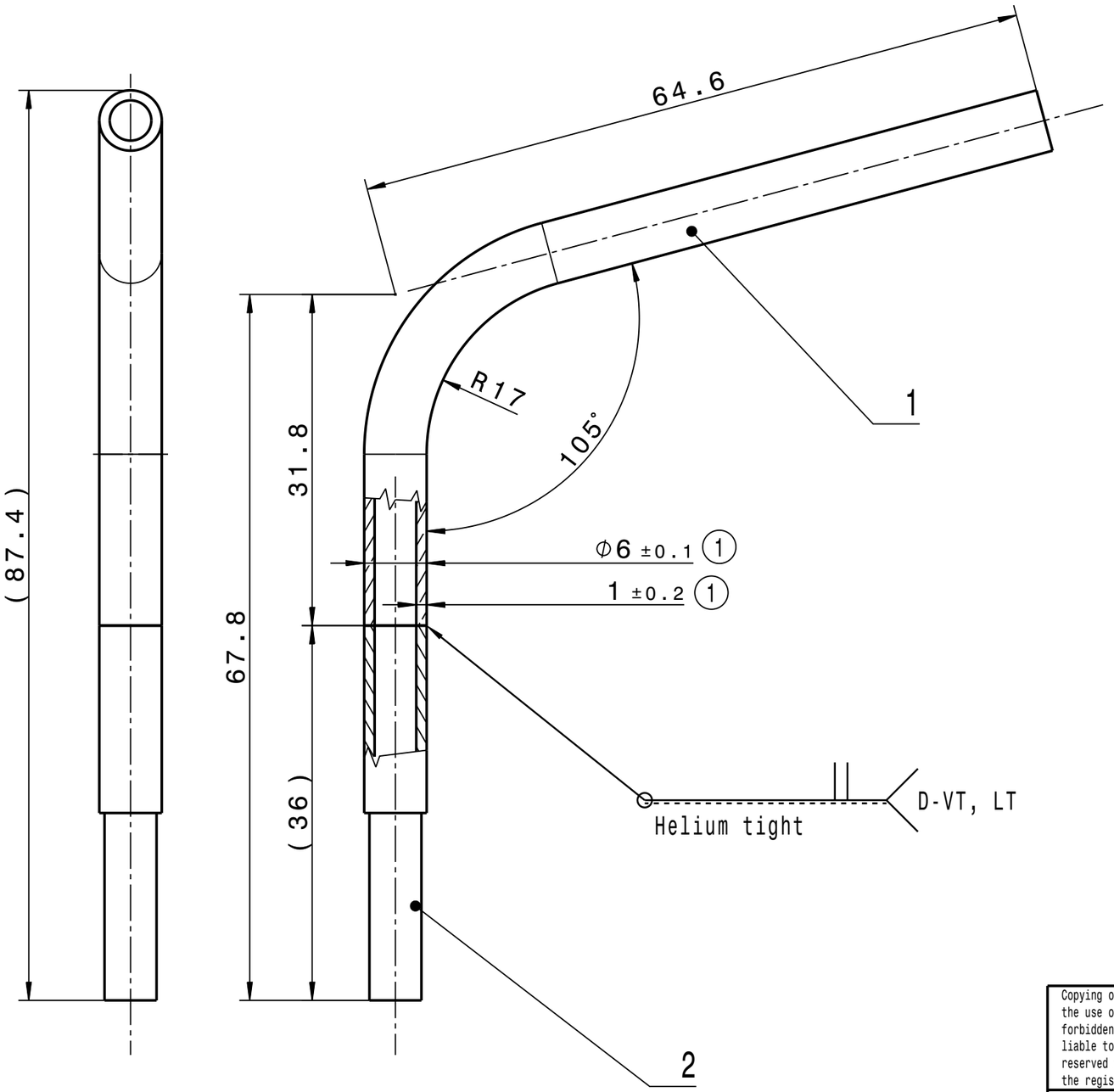


Prüfverfahren / test procedure

helium tight — D-VT, LT

T= Load-bearing seam (Tragende Naht)
N= Non-load-bearing seam (Nichttragende Naht)
D= Seal seam (Dichtnaht)

ZfP-Prüfverfahren / test procedure:

VT = Visual Testing (Visuelle Prüfung)
RT = Radiographfic Testing according to AD2000 HP0/HP100R
(Durchstrahlungsprüfung)
LT = Leakage Testing (Leckageprüfung)

Helium tight welding
Helium tight at 20 bar (Design pressure)
Operating temperature 4K (-269°C)
Design and manufacturing of pressure equipment according to Pressure Vessel Regulations AD 2000 , specification sheet HP 0

Position 1 stretched length: ~92
Alternative material:
1.4306, 1.4541, 1.4311, 1.4335, 1.4429,
1.4435, 1.4436, 1.4438, 1,4466, 1.4563

(1) According to DIN EN 10216-5 / EN ISO 1127 D4/T3
Acceptance test certificate according to DIN EN 10204/3.1
Acceptance according to AD 2000-W2/W10

Welding classification DIN EN ISO 5817	Quality level
Helium weldings	-B-

Edges ISO 13715 +0.3 -0.3 -0.1 Rz 25

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Projection

Surfaces
DIN EN ISO 1302:2002

Change Number

----Approved----

Helmholtzzentrum für Schwerionenforschung GmbH
Planckstrasse 1, 64291 Darmstadt

Dimensions without tolerance indication
DIN ISO 2768-1-m
DIN ISO 2768-2-K:1991
DIN EN ISO 13920-BF

Weight 0 kg
Material

Scale 2:1

	Date	Name
Drawn	29.09.2025	PDOLL
Checked	02.10.2025	FGARNICA
Approved	06.10.2025	ZURKAN

Description: Helium pipe out- VC

Size A3

Drawing No. MG-1553085-A-000

Rev. -

Sheet 1 of 1

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