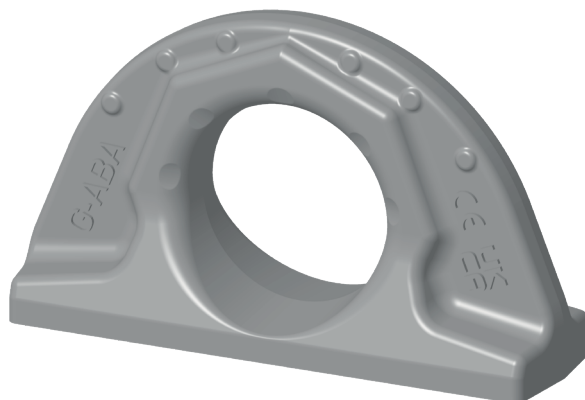


# Galvanisable Weld-on Lifting Point loadable from any side > G-ABA <



## Safety instructions

This safety instruction must be kept on file for the entire lifetime of the product and forwarded with the product.

- TRANSLATION OF THE ORIGINAL SAFETY INSTRUCTION -



**RUD Ketten**  
**Rieger & Dietz GmbH u. Co. KG**  
73432 Aalen  
Tel. +49 7361 504-1370  
slings@rud.com  
www.rud.com

RUD-Art.-Nr.: 7912401-EN V01 / 12.024

**G-ABA**  
**Galvanisable**



### EG-Konformitätserklärung

entsprechend der EG-Maschinenrichtlinie 2006/42/EG, Anhang II A und ihren Änderungen

Hersteller: **RUD Ketten**  
**Rieger & Dietz GmbH u. Co. KG**  
Friedensinsel  
73432 Aalen

Hiermit erklären wir, dass die nachfolgend bezeichnete Maschine aufgrund ihrer Konzipierung und Bauart, sowie in der von uns in Verkehr gebrachten Ausführung, den grundlegenden Sicherheits- und Gesundheitsanforderungen der EG-Maschinenrichtlinie 2006/42/EG sowie den unten aufgeführten harmonisierten und nationalen Normen sowie technischen Spezifikationen entspricht.  
Bei einer nicht mit uns abgestimmten Änderung der Maschine verliert diese Erklärung ihre Gültigkeit.

**Produktbezeichnung:** Anschlagpunkt starr G-ABA

Folgende harmonisierten Normen wurden angewandt:

DIN EN 1677-1 : 2009-03 DIN EN ISO 12100 : 2011-03

Folgende nationalen Normen und technische Spezifikationen wurden außerdem angewandt:

DGUV-R 109-017 : 2020-12

Für die Zusammenstellung der Konformitätsdokumentation bevollmächtigte Person:  
Michael Betzler, RUD Ketten, 73432 Aalen

Aalen, den 06.05.2024

Hermann Kolb, Bereichsleitung MA

Name, Funktion und Unterschrift Verantwortlicher



### EC-Declaration of conformity

According to the EC-Machinery Directive 2006/42/EC, annex II A and amendments

Manufacturer: **RUD Ketten**  
**Rieger & Dietz GmbH u. Co. KG**  
Friedensinsel  
73432 Aalen  
Germany

We hereby declare that the equipment sold by us because of its design and construction, as mentioned below, corresponds to the appropriate, basic requirements of safety and health of the corresponding EC-Machinery Directive 2006/42/EC as well as to the below mentioned harmonized and national norms as well as technical specifications.  
In case of any modification of the equipment, not being agreed upon with us, this declaration becomes invalid.

**Product name:** Lifting point rigid G-ABA

The following harmonized norms were applied:

DIN EN 1677-1 : 2009-03 DIN EN ISO 12100 : 2011-03

The following national norms and technical specifications were applied:

DGUV-R 109-017 : 2020-12

Authorized person for the configuration of the declaration documents:  
Michael Betzler, RUD Ketten, 73432 Aalen

Aalen, 06.05.2024

Hermann Kolb, Head of division MA

Name, function and signature of the responsible person



Before initial usage of the RUD weld-on lifting point G-ABA, please read carefully the safety instructions. Make sure that you have understood all subjected matters. Failure to follow can lead to serious personal injuries and material damage and eliminates warranty.

## 1 Safety instructions



### ATTENTION

Wrong assembled or damaged weld-on lifting points G-ABA as well as improper use can lead to injuries of persons and damage of objects when load drops.

Please inspect all lifting points before each use.

- Remove all body parts (fingers, hands, arms, etc.) out of the hazard area (danger of crushing or squeezing) during the lifting process.
- RUD weld-on lifting points G-ABA must only be used by instructed and competent persons considering DGUV-rules 109-017 and outside Germany noticing the country specific statutory regulations.
- No technical alterations must be implemented on the G-ABA.
- The rated WLL at the G-ABA must not be exceeded.
- No people may stay in the danger zone.
- Detention under a floating load is forbidden.
- Jerky lifting (strong impacts) should be prevented.
- Always ensure a stable position of the load when lifting. Swinging must be prevented.
- Damaged or worn G-ABA must never be utilised.

## 2 Intended use

RUD weld-on lifting points G-ABA must only be used for the assembly at the load or at lifting means.

They are intended to be connected into lifting means.

RUD weld-on lifting points G-ABA can also be used as lashing points to attach lashing means.

Loading from any side is permitted.

RUD weld-on lifting points G-ABA must only be used in the hereby described operation purpose.

## 3 Assembly- and instruction manual



### NOTE

The manufacturer RUD guarantees the overall conformity of the G-ABA only after complete and correct implementation of the assembly and welding specifications!

## 3.1 General information



### NOTE

The lifting points G-ABA can be galvanised and hot-dip galvanised, together with the load (e.g. welded construction). Ensure that the design and surface are suitable for galvanisation.

Other possible coating processes are Zinc flake coating and diffusion galvanising (sheradising).

- Effects of temperature usage:

When used at higher temperatures the working load limit (WLL) of the lifting point must be reduced as follows:

- -40°C up to 200°C → no reduction
- 200°C up to 300°C → minus 10 %
- 300°C up to 400°C → minus 25 %

Temperatures above 400°C (725°F) are prohibited.

The lifting points G-ABA can be stress-relieved one-time in an unloaded condition, together with the load (e.g. welded construction): Temperature < 600°C / 1100°F (one hour maximum).

- RUD weld-on lifting points G-ABA must not be used under chemicals influences such as acids, alkaline solutions and vapours.
- The reuse of cut-off G-ABAs is not permitted.
- Please mark mounting position of lifting point with a coloured contrast paint for better visibility.

## 3.2 Hints for the assembly

- The material construction to which the lifting point will be attached should be of adequate strength to withstand forces during lifting without deformation.

The weld-on material must be suitable for welding and the contact areas must be free from impurities, oil, colour, etc.

The material of the lifting point for welding is S355J2 (1.0577+N)

- The position of the lifting points must be carried out in such a way that unintended movement like turning or flipping will be avoided:
  - **For single leg lifts** - the lifting point should be vertically above the centre of gravity of the load.
  - **For two leg lifts** - the lifting points must be equidistant to/or above the centre of gravity of the load.
  - **For three and four leg lifts** - the lifting points should be arranged symmetrical around the centre of gravity, in the same plane if possible.
- Position weld-on lifting points into the load force direction (compare Pic. 5 and Table 2 - permissible WLL for different load directions).
- Symmetry of loading:
 

Determine the necessary WLL of each lifting point for a symmetrical load by using the following physical calculation formula:

$$W_{LL} = \frac{G}{n \times \cos \beta}$$

$W_{LL}$  = necessary WLL (kg) of lifting point / single strand  
 $G$  = weight of load (kg)  
 $n$  = number of load bearing strands  
 $\beta$  = inclination angle of single strand

Number of load bearing strands:

	symmetric	unsymmetric
two leg	2	1
three / four leg	2	1

Table 1: Load bearing strands (compare to Table 2)



#### NOTE

At unsymmetrical loads, even if several lifting points are used, the WLL of a single lifting point must be at least equal to the load weight or ask the manufacturer.

- Check finally the correct assembly (see chapter 4 *Inspection / repair / disposal*).

### 3.3 Hints for the welding

The welding should only be carried out according to ISO 9606-1 or AWS Standards by an authorized welder.

Verifications of suitability of the used weld-on material must be checked with the supplier of the welding electrodes.



#### NOTE

A plane welding surface must be guaranteed.

Weld all seams in the same temperature.

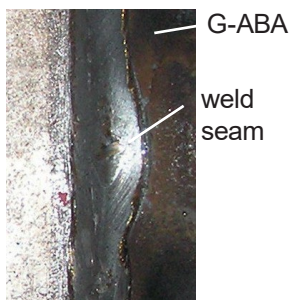
Please note the corresponding user hint in regard of the welding filler materials see Table 3).

- Fasten provisionally, resp. start welding in the middle of the plate.
- Before the closure weld is carried out, make sure that the bottom and all interlayers are cleaned carefully. Remove all visible flaw spots of the root and at the interlayers.
- Weld fillet weld continuous at the base plate of the lifting point.



#### NOTE

Due to the (forged) shape of the G-ABA there will be a weld-seam changeover in the marked area (see Pic. 1 and Pic. 2). This has no impact on the strength of the construction part!



Pic. 1: weld-seam



Pic. 2: area of the weld-seam changeover

- Please check by a competent person after welding the ongoing usage of the weld-on lifting point (see chapter 4 *Inspection / repair / disposal*).



#### NOTE

By the position of the weld-seam (continuous fillet weld seam) the following requirements will be observed: DIN 18800 steel constructions require: at outdoor buildings or when strong corrosion must be expected weld seams must be carried out as continuous fillet weld seams.

### 3.4 User instructions

- Check frequently and before each initial operation the whole weld-on lifting point G-ABA in regard of linger ability as a lifting means, regarding corrosion, wear, deformation etc. (see chapter 4 *Inspection / repair / disposal*).



#### ATTENTION

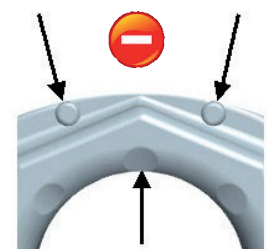
Wrong positioned or damaged weld-on lifting points as well as improper use can lead to injuries of persons and damage at property, when load falls.

Please check all lifting points carefully before every usage.

- RUD components are designed according to DIN EN 818 and DIN EN 1677 for a dynamic load of 20,000 load cycles.
  - Keep in mind that several load cycles can occur with a lifting procedure
  - Keep in mind that, due to the high dynamic stress with high numbers of load cycles, that there is a danger that the product will be damaged.
  - The BG/DGUV recommends: For higher dynamic loading with a high number of load cycles (continuous operation), the working load stress must be reduced according to the driving mechanism group 1Bm (M3 in accordance with DIN EN 818-7). Use a lifting point with a higher working load limit.
- Please check carefully the wear indicator markings of the weld-on lifting point (see Pic. 3):



**Usage permitted**  
no wear marks visible



**Use prohibited**  
Replacement criteria reached.  
Material all the way down to the wear lenses has gone

Pic. 3: Wear indicators

- Please note that the lifting mean must be free moveable within the weld-on lifting point G-ABA. When lifting means (sling chains) are hinged or unhinged, no pinching, shearing or joint spots must occur during the handling.

- Avoid damage of lifting means resulting from sharp edges.
- If the weld-on lifting point G-ABA are used exclusively for lashing, the value of the working load limit can be doubled:  $LC = 2 \times WLL$



#### NOTE

*If the G-ABA used as a lashing point, with a force higher than the WLL, it must not be used as a lifting point afterwards. If the G-ABA used as a lashing point, up to the WLL only, it can still be used afterwards as a lifting point.*

- If possible, leave the immediate danger zone.
- Always supervise your suspended loads.

## 4 Inspection / repair / disposal

### 4.1 Hints for periodical inspections

The operator must determine and specify the nature and scope of the required tests as well as the periods of repeating tests by means of a risk assessment (see sections 4.2 and 4.3).

The continuing suitability of the anchor point must be checked at least 1x year by an expert.

Depending on the usage conditions, f.e. frequent usage, increased wear or corrosion, it might be necessary to check in shorter periods than one year. The inspection has also to be carried out after accidents and special incidents.

The inspection cycles must be specified by the operator.

### 4.2 Test criteria for the regular visual inspection by the user

- Completeness of the lifting point
- Complete, readable WLL statements as well as manufacturer sign
- Deformation at load bearing components like base body
- Mechanical damage, like strong notches, especially in areas where tensile stress occurs

### 4.3 Additional test criteria for the competent person / repair worker

- Reduction of cross-section due to wear >10 % (see *Pic. 3 Wear indicators*)
- Evidence of corrosion (Pitting)
- further checks may be required, depending on the result of the risk assessment (e.g. testing for cracks in load-bearing parts).

### 4.4 Disposal

Dispose worn out components / attachments or packaging according to the local waste removal requirements.

	<b>Europe, USA, Asia, Australia, Africa</b> Baustähle, niedrig legierte Stähle EN 10025-2 Mild steels, low alloyed steel EN 10025
<b>MIG / MAG (135)</b> <b>Gas shielded wire welding</b>	DIN EN ISO 14341: G4Si1 (G3Si1) z.B. PEGO G4Si1
<b>E-Hand Gleich- strom (111, =)</b> <b>Stick Electrode direct current</b>	DIN EN ISO 2560-A: E 42 6 B 3 2 H10 DIN EN ISO 2560-A: E 38 2 B 1 2 H10 z.B. PEGO B Spezial*/PEGO BR Spezial*
<b>E-Hand (Wechselstrom 111, ~)</b> <b>Stick Electrode alternating current</b>	DIN EN ISO 2560-A: E 38 2 RB 1 2 DIN EN ISO 2560-A: E 42 0 RC 1 1 z.B. PEGO RC 3 / PEGO RR B 7 Alternativ: DIN EN ISO 3581: E 23 12 2 L R 3 2 z.B. PEGO 309 MoL
<b>WIG (141) (TIG (141))</b> <b>Tungsten arc welding</b>	DIN EN ISO 636-A: W 3 Si 1 (W2 Si 1) DIN EN ISO 636-A: W 2 Ni 2 z.B. PEGO WSG 2 / PEGO WSG2Ni2



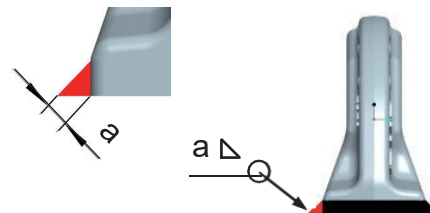
#### NOTE

Please note the corresponding user hint in regard of the welding filler materials and the drying requirements\*.

Table 3: Welding procedure and Welding filler metals

Type	size fillet weld	length	volume
G-ABA 1 t	a = 4	272 mm	4.357 cm³
G-ABA 2.5 t	a = 6	356 mm	12.830 cm³
G-ABA 4 t	a = 7	470 mm	23.092 cm³

Table 4: Weld seam



Pic. 4: Welding seam position

Type	WLL [t]	A [mm]	B [mm]	C [mm]	D [mm]	E [mm]	F [mm]	T [mm]	weight [kg/pc.]	Ref.No.
G-ABA 1 t	1	32	18	104	35	18	59	41,5	0,55 kg	7913870
G-ABA 2,5 t	2,5	41	29	137	50	21	80	59	1,36 kg	7913871
G-ABA 4 t	4	59	35	176	60	27,5	99	71,5	2,93 kg	7913872

Table 5: Dimensioning

Subject to technical alterations



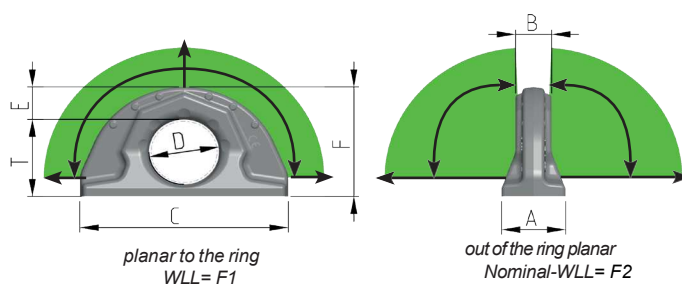
WORKING LOAD LIMITS (G - in tonnes)						
	Single Leg		2 , 3 or 4 Legs			Part number
						
			Maximum Included Angle			
Type	F1	F2	60°	90°	120°	
G-ABA 1 t	3.5	1	1.7	1.4	1	7913870
G-ABA 2.5 t	4	2.5	4.3	3.5	2.5	7913871
G-ABA 4 t	6	4	6.9	5.6	4	7913872

Table 6: Working Load Limit



Pic. 5: Dimensioning - Permitted loading directions