

Built-up Beam with various dimensions and base materials are fabricated by WEST COAST ENGINEERING (WCE). We are able to customize to various customer's design and processing need.

▶ CUSTOMIZED DIMEN-

We fabricate customized dimensions upon customer's requirement and raw material available in the market. Our product range covers a variety of the most popular dimensions and lengths of

▶ HIGH DIMENSIONAL ACCU-

Our products are made from modern CNC plasma cutting machine, assembly and welding machine from Japan operated by certified welders (JIS Z3841), production process management and quality assurance system comply with JSA .M-

▶ RELIABLE WELD QUALITY

We manufacture Built-up Beam by Submerge Arc Welding (SAW) with automatic electrode wire feeder and automatic positioning control as well as welding bead measurement (AWS D.1.1) ensuring that the size and position of the welding

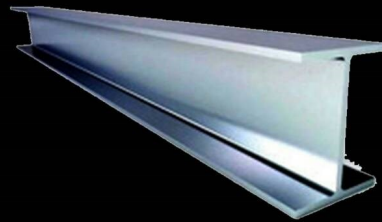
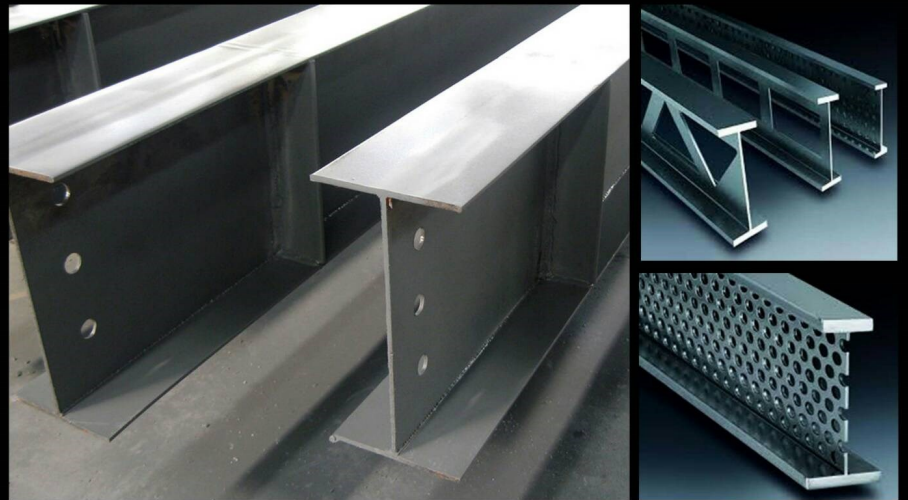
▶ Built-up Beam

▶ VALUES

- High Quality & Safety
- Flexibility in Design
- Cost-Effective

▶ FEATURES

- Customized dimensions meeting various design needs
- High dimensional accuracy
- Reliable Weld Quality



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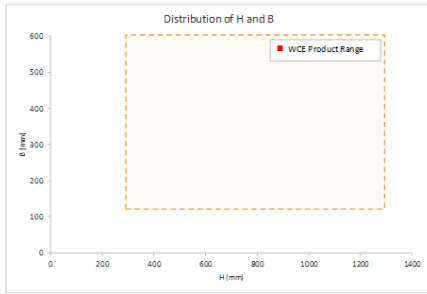
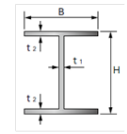
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▶ Product Specification

1. **Raw Material:** TIS, JIS, ASTM, AISI, ASME, API, BS, EN, DIN, AS, NZS Carbon Steel Strip, Plate or other Raw Material standard upon customer's requirement.

2. Product Range:	125-600 mm
Web Height (BH)	300-1,300 mm
Web Height (BT)	100-1,300 mm
Flange Thickness	6-55 mm
Web Thickness	6-30 mm
Length	2,000 – 18,000 mm.

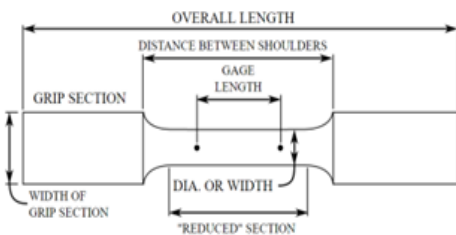


Manufacturing Range (mm)

B	Min. 300	Max. 1300
H	Min. 125	Max. 500
t1	Min. 6	Max. 30
t2	Min. 6	Max. 55

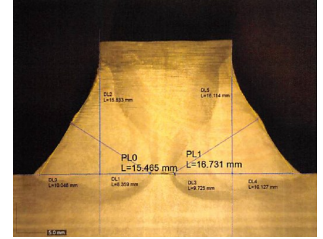
3. Quality of Weld

The quality of weld between web and flange is a critical element of the Built-up Beam. WCE Built-up Beam are made by welding at the optimum welding conditions. The fabrication procedure shall be submitted and mutually agreed with the customer prior to the production. The Tensile Strength Test and Macro and Micro Structure result ensuring the quality of weld by 3rd party shall be provided upon the customer's requirement.



Macro and Micro Structure

Macroscopic test with dilute nitric acid is performed to confirm the weld of web and flange structural fusion.



4. Tolerance of shape and dimensions:

Macroscopic test with dilute nitric acid is performed to confirm the weld of web and flange structural fusion.

Item	Range	Tolerance		Remarks		
		JIS G 3136	JIS G 3192			
Width (B)	B ≤ 400	± 2.0				
	400 < B	± 2.0				
Depth (H)	H < 800	B ≤ 400	± 2.0			
		400 < B	± 3.0			
	800 ≤ H	± 3.0				
Thickness	Flange (t ₂)	6 ≤ t ₂ < 16	+ 1.7 - 0.3		± 1.0	
		6 ≤ t ₂ < 25	+ 2.3 - 0.7		± 1.5	
		25 ≤ t ₂ < 40			± 1.7	
	Web (t ₁)	40 ≤ t ₂	+ 2.5 - 1.5		± 2.0	
		t ₁ < 16			± 0.7	
		16 ≤ t ₁ < 25			± 1.0	
		25 ≤ t ₁ < 40			± 1.5	
40 ≤ t ₁			± 2.0			
Length (L)	L ≤ 7000	± 40.0 - 0				
	7000 < L	+ tolerance increases 5 mm for the increment of every 1 m. or fraction thereof				
Flange Out-of-Squareness (T)	H ≤ 300	≤ 0.01 B The minimum tolerance shall be 1.5 mm.				
	300 < H	≤ 0.012 B The minimum tolerance shall be 1.5 mm.				
Bend (t)	B ≤ 400	0.15% of b and ≤ 1.5				
Web-of-Center (S)	B ≤ 400	± 2.0				
	400 < B	± 3.5				
Ends Out-of-Square (e)	-	≤ 0.016 H or ≤ 0.016 B The minimum tolerance shall be 3.0 mm.				
Camber of Web (δ)	H ≤ 350	≤ 2				
	350 < H < 550	≤ 2.5				
	550 ≤ H	≤ 3				

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