

# W-ABA

## Weld-On Load Ring



### Product Features:

- Large WLL range 0.8 t – 31.5 t
- Can be loaded on all sides
- Forged from a single piece, no rattling noise or shaking even with strong vibrations or shock loads, easy hinging of the lifting means possible
- The weld arrangement (circular fillet weld) fulfills the requirements of DIN EN 1090, i.e. the endless weld seam prevents the formation of contact/crevice corrosion (thus suitable for outdoor constructions)
- Safety factor 4:1
- Patented wear markings inside and out
- Tempered main body, making it more wear resistant



### PRODUCT DETAILS

Forged from a single piece



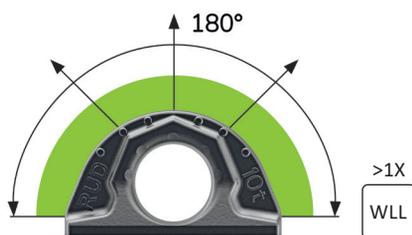
Clear marking of the minimum WLL



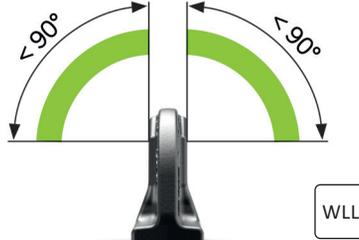
Circular fillet weld



WLL angle in load ring plane



WLL angle for side loading



Patented wear marker

Ready to be discarded      New



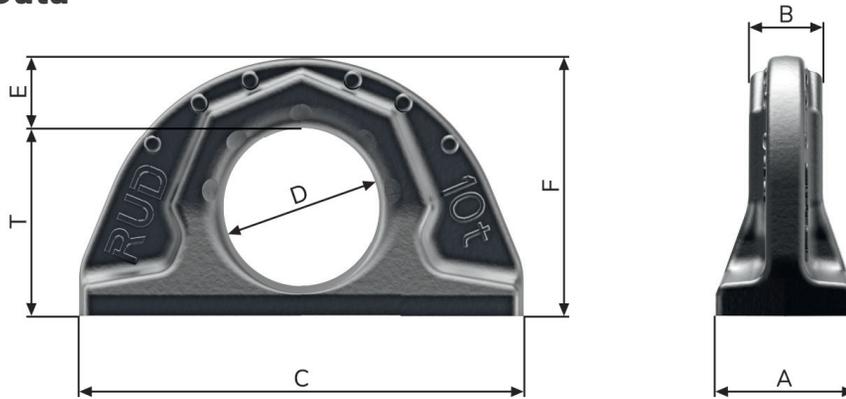
### How do you choose the correct RUD lifting point?

Let Caldwell's Regional Sales Manager and RUD expert Jay Schroeder explain how to select the right RUD lifting point in this short video.



# W-ABA

## Technical Data



### W-ABA

Type	WLL (t)	Weight (kg/unit)	T (mm)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	Welding Seam	Model Number	
W-ABA 0.8t	0.8 (2) <sup>1</sup>	0.2	38	22	12	70	32	12	50	a3	7907698	
W-ABA 1.6t	1.6 (4) <sup>1</sup>	0.45	42	30	16	100	35	16	57	a4	7900352	
W-ABA 3.2t	3.2 (9) <sup>1</sup>	1.15	59	41	23	137	50	21	80	a6	7900353	
W-ABA 5t	5 (12) <sup>1</sup>	2.26	72	51	27	172	60	28	99	a7	7900354	
W-ABA 10t	10 (20) <sup>1</sup>	5.37	95	70	38	228	80	35	130	a8	7900355	
W-ABA 20t	20	10.72	135	90	52	272	115	40	175	a12	7902174	
W-ABA 31.5t	31.5	18.33	154	108	64	320	130	50	204	a15	7902175	

<sup>1</sup> ( ) = Higher WLL with load in load ring plane.  
Subject to technical changes!

# RUD ROV... ASAP!

*Subsea rigging just got easier, safer, and more efficient.*

**EASIER:** Hook can be operated by all commonly used ROV manipulators and the twin trigger mechanism makes unintentional opening and loss of loads impossible.

**SAFER:** The outward-opening safety latch and smooth outer profile eliminate the risk of load shedding, snagging, and accidental rigging, protecting the load ... and your subsea operation.

**MORE EFFICIENT:** The hook design and operation minimize the time the ROV takes to attach or detach the load, saving you time and money.



# Weld-On Lifting Point - loadable from any side > W-ABA <



## Safety instructions

This safety instruction has to be kept on file for the whole lifetime of the product and forwarded with the product.

TRANSLATION OF THE ORIGINAL SAFETY INSTRUCTION



W-ABA



**RUD Ketten**  
**Rieger & Dietz GmbH u. Co. KG**  
73432 Aalen  
Tel. +49 7361 504-5438  
sling@rud.com  
www.rud.com

RUD-Art.-Nr.: 7900958-EN V09 / 05.025

**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  
W-ABA

Folgende harmonisierten Normen wurden angewandt:

<u>DIN EN 1677-1 : 2009-03</u>	<u>DIN EN ISO 12100 : 2011-03</u>
_____	_____
_____	_____
_____	_____

Folgende nationalen Normen und technische Spezifikationen wurden außerdem angewandt:

<u>DGUV-R 109-017 : 2020-12</u>	_____
_____	_____
_____	_____
_____	_____

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

Aalen, den 29.11.2023      Hermann Kolb, Bereichsleitung MA *Hermann Kolb*

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  
W-ABA

The following harmonized norms were applied:

<u>DIN EN 1677-1 : 2009-03</u>	<u>DIN EN ISO 12100 : 2011-03</u>
_____	_____
_____	_____
_____	_____

The following national norms and technical specifications were applied:

<u>DGUV-R 109-017 : 2020-12</u>	_____
_____	_____
_____	_____
_____	_____

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

Aalen, den 29.11.2023      Hermann Kolb, Bereichsleitung MA *Hermann Kolb*

Name, function and signature of the responsible person



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

## 1 Safety instructions



### ATTENTION

Wrong assembled or damaged weld-on lifting points W-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 W-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 W-ABA.
- 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 W-ABA must never be utilised.

## 2 Intended use of the W-ABA

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

They are intended to be hinged into lifting means.

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

Loading from any side is permitted.

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

## 3 Assembly- and instruction manual



### HINT

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

### 3.1 General information

- Capability 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 exceeding 400°C are prohibited!

The lifting points W-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 W-ABA must not be used with aggressive chemicals such as acids, alkaline solutions and their vapours.
- The reuse of cut-off W-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

Basically essential:

- 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, ect.

The material of the lifting point for welding is 1.6541 (23MnNiCrMo52)

- 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 5* - permissible WLL at different loading 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
two leg	2
three / four leg	3

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



### HINT

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.



#### HINTS

*A plan welding surface must be guaranteed.*

*Weld all seams in the same temperature.*

1. Fasten provisionally, resp. start welding in the middle of the plate.
2. 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.
3. Weld fillet weld continuous at the base plate of the lifting point.

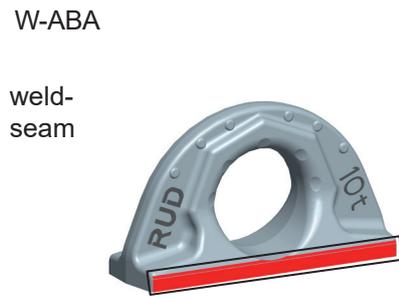


#### HINT

*Due to the (forged) shape of the W-ABA (sizes 0.8 t - 31.5 t), 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

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



#### HINT

*By the position of the weld-seam (continuous fillet weld seam) the following requirements will be observed: DIN 18800 steel constructions requires: 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

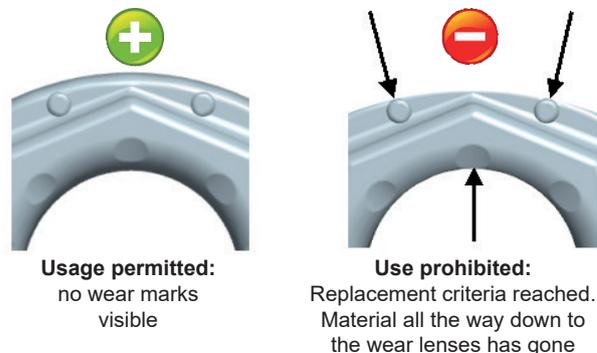
- Check frequently and before each initial operation the whole weld-on lifting point W-ABA in regard of linger ability as a lifting mean, regarding corrosion, wear, deformation etc. (see chapter 4 *Inspection / repair / disposal*).



#### 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 down. 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):



Pic. 3: Wear indicators

- Please note that the lifting mean must be free moveable within the weld-on lifting point W-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 W-ABA are used exclusively for lashing, the value of the working load limit can be doubled:  $LC = 2 \times WLL$



#### HINT

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

## 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.

#### 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.

Method of lift												
Number of legs	1	1	1	2	2	2	2	2	2	3 / 4	3 / 4	3 / 4
Angle of inclination	0°	90°	90°	0 °	90°	90°	0-45°	>45-60°	Un-symm.	0-45°	>45-60°	Un-symm.
Factor	1	1	1	2	2	2	1.4	1	1	2.1	1.5	1
Type	For the max. total load weight >G< in metric tons											
W-ABA 0.8 t	2	0.8	2	4	1.6	4	1.12 (2.8)	0.8 (2)	0.8 (2)	1.7 (4.25)	1.18 (3)	0.8 (2)
W-ABA 1.6 t	4	1.6	4	8	3.2	8	2.2 (5.6)	1.6 (4)	1.6 (4)	3.4 (8.4)	2.4 (6)	1.6 (4)
W-ABA 3.2 t	9	3.2	9	18	6.4	18	4.5 (12.6)	3.2 (9)	3.2 (9)	6.7 (18.9)	4.8 (13.5)	3.2 (9)
W-ABA 5 t	12	5	12	24	10	24	7 (16.8)	5 (12)	5 (12)	10.5 (25.2)	7.5 (18)	5 (12)
W-ABA 10 t	20	10	20	40	20	40	14 (28)	10 (20)	10 (20)	21.2 (42)	15 (30)	10 (20)
W-ABA 20 t	20	20	20	40	40	40	28	20	20	42	30	20
W-ABA 31.5 t	31.5	31.5	31.5	63	63	63	45	31.5	31.5	67	47.5	31.5
	At a lift with one strand and two parallel strands where the inclination angles are at the max. ± 7°, the lifting method can be assumed as a vertical lift.						When lifting with two, three or four leg lifting means, inclination angles of less than 15° shall be avoided, if possible (Risk of instability).					

Table 2: WLL overview

WLL Y = Nominal Working Load

( ) = WLL X planar to the ring

<sup>>1x</sup>  
 = Loading at ring plane

= Loading from the side

#### Example W-ABA 10 t | 2-leg 0-45° (see Table 2):

WLL x Faktor:  
 10 t x 1.4 = **14 t**

WLL x Faktor (Bracket value):  
 20 t x 1.4 = **28 t**

	Europe, USA, Asia, Australia, Africa
	Baustähle, niedrig legierte Stähle EN 10025-2 Mild steels, low alloyed steel EN 10025-2
<b>MIG / MAG (135)</b> Gas shielded wire welding	DIN EN ISO 14341: G4Si1 (G3Si1) z.B. PEGO G4Si1
<b>E-Hand Gleichstrom (111, =)</b> Stick Electrode direct current	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> Stick Electrode alternating current	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> Tungsten arc welding	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



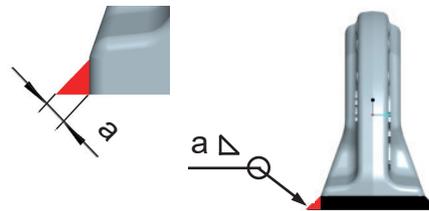
### HINT

Please note the corresponding user hint in regard of the welding filler materials and the drying requirements\*. For welding the W-ABA 20 t & W-ABA 31.5 t the preheat temperature has to be between 150° and 170° C.

Table 3: Welding procedure and Welding filler metals

Type	size fillet weld	length	volume
W-ABA 0.8 t	a = 3	177 mm	1.593 cm <sup>3</sup>
W-ABA 1.6 t	a = 4	251 mm	4.016 cm <sup>3</sup>
W-ABA 3.2 t	a = 6	344 mm	12.38 cm <sup>3</sup>
W-ABA 5 t	a = 7	431 mm	21.1 cm <sup>3</sup>
W-ABA 10 t	a = 8	576 mm	36.86 cm <sup>3</sup>
W-ABA 20 t	a = 12	697 mm	100.3 cm <sup>3</sup>
W-ABA 31.5 t	a = 15	824 mm	185.4 cm <sup>3</sup>

Table 4: Weld seam

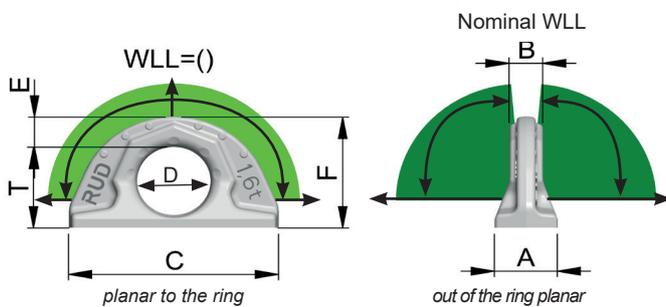


Pic. 4: Welding seam position

Type	WLL [t]	A [mm]	B [mm]	C [mm]	D [mm]	E [mm]	F [mm]	T [mm]	weight [kg/pc.]	Ref.No.
W-ABA 0.8 t	0.8	22	12	70	32	12	50	38	0.20	7907698
W-ABA 1.6 t	1.6	30	16	100	35	16	57	41.5	0.45	7900352
W-ABA 3.2 t	3.2	41	23	137	50	21	80	59	1.1	7900353
W-ABA 5 t	5	51	27	172	60	27.5	99	71.5	2.3	7900354
W-ABA 10 t	10	70	38	228	80	35	130	95	5.3	7900355
W-ABA 20 t	20	90	52	272	115	40	175	135	10.7	7902174
W-ABA 31.5 t	31.5	108	64	320	130	50	204	154	18.3	7902175

Table 5: Dimensioning

Subject to technical alterations



Pic. 5: Dimensioning - Permitted loading directions