

וְהָיָה כִּי יֵרָאֶה אֶת-בְּנֵי הָעַם וְלֹא יִשְׁמַח בָּם וְלֹא יִשְׂכַּח לֵב מִן-הָעָם וְלֹא יִסְתַּחֲפֹק עֲלֵיהֶם וְלֹא יִשְׁטָף עֲלֵיהֶם וְלֹא יִשְׁתַּחֲוֶה לָהֶם וְלֹא יִשְׁתַּחֲוֶה לְבָנֵי הָעַם וְלֹא יִשְׁתַּחֲוֶה לְבָנֵי הָעַם וְלֹא יִשְׁתַּחֲוֶה לְבָנֵי הָעַם

- ಗಿಂತ: 12.5% ಕ್ಕೆ ಅಧಿಕ: 1.5%:

- ١) قاع ورق جميع الأجزاء المدفونة (Embedded Parts).
- ٢) أعمال اللحام والتفتيش للأجزاء المدفونة (Embedded Parts).
- ٣) عمل مناشية أو لبنة للصقل إلى السطح المعبري للزوايا وإزالة كافة الصدأ والبقع القديمة.
- ٤) قياس سمك الصاج باستخدام جهاز Ultrasonic Thickness لجميع الأجزاء المدفونة للزوايا.
- ٥) توريد وتركيب طلاءات جديدة.
- ٦) عمل مناشية حتى SA2.5.
- ٧) توريد وعمل طبقة دهان كامل لجان الصيانة.
- ٨) توريد وتركيب كوابل التبريد (Rubber Seals) لجميع الزوايا.
- ٩) أعمال رفع كفاءة وإعادة منظرية مجموعة الهيكلية للزوايا المشغلة.
- ١٠) توريد وتركيب عدد (٢) منبج موضع الزوايا (Position Indicator) ميكانيكي/إلكتروني.

מִי־יִשְׁמַח בְּיָמָיו וְיִשְׁמַח בְּיָמָיו:

[illegible]

གཞི: ༡༥ | ༡༦:

أعمال رفع الكافة لعدد (٧) بوابة متحركة (Slide Gate) و (٣) بوابة صلبة (Shield Gate) تابعة لمرور وسلاسل التحميل الخاصة بهم لنبينا جيران أسوان القديم.

Ἰησοῦς ὁ υἱὸς τοῦ ἀνθρώπου

ਸਤਿਨਾਮੁ ॥ ਸ੍ਰੀਗੰਧਰਵੇ ਨਮੋ ॥ ਜਪਿਆ ॥ ਗੁਣਗੰਧਰਵੇ ਨਮੋ ॥ - ਸਤਿਨਾਮੁ ॥ ਸ੍ਰੀਗੰਧਰਵੇ ਨਮੋ ॥





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على من أتمهته لكامل يدق بنو إلى معالج سطح الصلح SA2.5 الأخرى المتخلفة لعمود (١-٢)

[illegible]

المدينة المنورة في شهر ربيع الثاني سنة ١٢٨٠ هـ

[illegible]

॥ श्रीगणेशाय नमः ॥ ॐ नमो भगवते वासुदेवाय ॥

السلام عليكم ورحمة الله وبركاته

الحمد لله الذي هدانا لهذا الذي كنا لنهتدي لولا أن هدانا الله. والحمد لله رب العالمين.

[illegible]

॥ अथ श्रीगणेशाय नमः ॥

॥ श्रीगणेशाय नमः ॥

אשר יצאנו ממצרים ואת כל אשר עשה לנו בדרך

تاريخ قاضي فاضل محمد بن ابي اسحاق علي وعمل كاتبا في دار السلطنة في سنة ١٢٠٤ هـ

[illegible]

مستخلصات المعالجة بالكلور في حالات التآكل والوقود في العمل المختص في ذات التآكل في المختبر من مستخلصات المعالجة بالكلور

1. 2. 3. 4. 5. 6. 7. 8. 9. 10. 11. 12. 13. 14. 15. 16. 17. 18. 19. 20. 21. 22. 23. 24. 25. 26. 27. 28. 29. 30. 31. 32. 33. 34. 35. 36. 37. 38. 39. 40. 41. 42. 43. 44. 45. 46. 47. 48. 49. 50. 51. 52. 53. 54. 55. 56. 57. 58. 59. 60. 61. 62. 63. 64. 65. 66. 67. 68. 69. 70. 71. 72. 73. 74. 75. 76. 77. 78. 79. 80. 81. 82. 83. 84. 85. 86. 87. 88. 89. 90. 91. 92. 93. 94. 95. 96. 97. 98. 99. 100. 101. 102. 103. 104. 105. 106. 107. 108. 109. 110. 111. 112. 113. 114. 115. 116. 117. 118. 119. 120. 121. 122. 123. 124. 125. 126. 127. 128. 129. 130. 131. 132. 133. 134. 135. 136. 137. 138. 139. 140. 141. 142. 143. 144. 145. 146. 147. 148. 149. 150. 151. 152. 153. 154. 155. 156. 157. 158. 159. 160. 161. 162. 163. 164. 165. 166. 167. 168. 169. 170. 171. 172. 173. 174. 175. 176. 177. 178. 179. 180. 181. 182. 183. 184. 185. 186. 187. 188. 189. 190. 191. 192. 193. 194. 195. 196. 197. 198. 199. 200. 201. 202. 203. 204. 205. 206. 207. 208. 209. 210. 211. 212. 213. 214. 215. 216. 217. 218. 219. 220. 221. 222. 223. 224. 225. 226. 227. 228. 229. 230. 231. 232. 233. 234. 235. 236. 237. 238. 239. 240. 241. 242. 243. 244. 245. 246. 247. 248. 249. 250. 251. 252. 253. 254. 255. 256. 257. 258. 259. 260. 261. 262. 263. 264. 265. 266. 267. 268. 269. 270. 271. 272. 273. 274. 275. 276. 277. 278. 279. 280. 281. 282. 283. 284. 285. 286. 287. 288. 289. 290. 291. 292. 293. 294. 295. 296. 297. 298. 299. 300. 301. 302. 303. 304. 305. 306. 307. 308. 309. 310. 311. 312. 313. 314. 315. 316. 317. 318. 319. 320. 321. 322. 323. 324. 325. 326. 327. 328. 329. 330. 331. 332. 333. 334. 335. 336. 337. 338. 339. 340. 341. 342. 343. 344. 345. 346. 347. 348. 349. 350. 351. 352. 353. 354. 355. 356. 357. 358. 359. 360. 361. 362. 363. 364. 365. 366. 367. 368. 369. 370. 371. 372. 373. 374. 375. 376. 377. 378. 379. 380. 381. 382. 383. 384. 385. 386. 387. 388. 389. 390. 391. 392. 393. 394. 395. 396. 397. 398. 399. 400. 401. 402. 403. 404. 405. 406. 407. 408. 409. 410. 411. 412. 413. 414. 415. 416. 417. 418. 419. 420. 421. 422. 423. 424. 425. 426. 427. 428. 429. 430. 431. 432. 433. 434. 435. 436. 437. 438. 439. 440. 441. 442. 443. 444. 445. 446. 447. 448. 449. 450. 451. 452. 453. 454. 455. 456. 457. 458. 459. 460. 461. 462. 463. 464. 465. 466. 467. 468. 469. 470. 471. 472. 473. 474. 475. 476. 477. 478. 479. 480. 481. 482. 483. 484. 485. 486. 487. 488. 489. 490. 491. 492. 493. 494. 495. 496. 497. 498. 499. 500. 501. 502. 503. 504. 505. 506. 507. 508. 509. 510. 511. 512. 513. 514. 515. 516. 517. 518. 519. 520. 521. 522. 523. 524. 525. 526. 527. 528. 529. 530. 531. 532. 533. 534. 535. 536. 537. 538. 539. 540. 541. 542. 543. 544. 545. 546. 547. 548. 549. 550. 551. 552. 553. 554. 555. 556. 557. 558. 559. 560. 561. 562. 563. 564. 565. 566. 567. 568. 569. 570. 571. 572. 573. 574. 575. 576. 577. 578. 579. 580. 581. 582. 583. 584. 585. 586. 587. 588. 589. 590. 591. 592. 593. 594. 595. 596. 597. 598. 599. 600. 601. 602. 603. 604. 605. 606. 607. 608. 609. 610. 611. 612. 613. 614. 615. 616. 617. 618. 619. 620. 621. 622. 623. 624. 625. 626. 627. 628. 629. 630. 631. 632. 633. 634. 635. 636. 637. 638. 639. 640. 641. 642. 643. 644. 645. 646. 647. 648. 649. 650. 651. 652. 653. 654. 655. 656. 657. 658. 659. 660. 661. 662. 663. 664. 665. 666. 667. 668. 669. 670. 671. 672. 673. 674. 675. 676. 677. 678. 679. 680. 681. 682. 683. 684. 685. 686. 687. 688. 689. 690. 691. 692. 693. 694. 695. 696. 697. 698. 699. 700. 701. 702. 703. 704. 705. 706. 707. 708. 709. 710. 711. 712. 713. 714. 715. 716. 717. 718. 719. 720. 721. 722. 723. 724. 725. 726. 727. 728. 729. 730. 731. 732. 733. 734. 735. 736. 737. 738. 739. 740. 741. 742. 743. 744. 745. 746. 747. 748. 749. 750. 751. 752. 753. 754. 755. 756. 757. 758. 759. 760. 761. 762. 763. 764. 765. 766. 767. 768. 769. 770. 771. 772. 773. 774. 775. 776. 777. 778. 779. 780. 781. 782. 783. 784. 785. 786. 787. 788. 789. 790. 791. 792. 793. 794. 795. 796. 797. 798. 799. 800. 801. 802. 803. 804. 805. 806. 807. 808. 809. 810. 811. 812. 813. 814. 815. 816. 817. 818. 819. 820. 821. 822. 823. 824. 825. 826. 827. 828. 829. 830. 831. 832. 833. 834. 835. 836. 837. 838. 839. 840.

[illegible]

יְהוָה אֱלֹהֵינוּ יְהוָה אֱלֹהֵינוּ

- التفتيت
التي تكون مسامير التفتيت مكوّنة من سبائك خاصة من الألومنيوم والتيتانيوم (X22 Cr Ni 17) والتي

[illegible]

والله اعلم بالصواب

١٠٨٩
١٠٩٠

المستطيلات الخاصة بالمتوازيات، وتلبيح القول قبل البدء في عمل تخطيط الكونكريت المسلح للخرابطة (Scaling Frame) التركيبي (أول الخرج) الخرجية الخاصة بالسطح الأسفلح الخرجي (الخارج من الخرابة)

الاصول والاصول.

[illegible][illegible]

התוצאות של המחקר מוצגות בטבלה 1. (א) המחקר הראשון הראה כי 75% מהמשתתפים הצליחו לזהות את המיקום של המבצע. (ב) המחקר השני הראה כי 80% מהמשתתפים הצליחו לזהות את המיקום של המבצע.

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| الكمية | الوصف | العدد | النوع |
|------------------|----------------------------|-------|--|
| ١ | *5200 mm * 8mm قطر 152.4mm | ١ | Link Rod (ST - 37) |
| ٢ | C10 | ٤ | Chackles C10 (DIN 82101) |
| ٣ | 135*30M*40*172 mm | ٥ | Threaded Pin M30 (X22 Cr Ni 17-V) with all Accessories |
| ٤ | 135*36M*50*177 mm | ١٥ | Threaded Pin M36 (X22 Cr Ni 17-V) with all Accessories |
| ٥ | A82 | ١٠ | Washer A82 (ST - 37 - 2) |
| ٦ | A31 | ٥ | Washer A31 (ST 37 - 2) |
| ٧ | A37 | ٥ | Washer A37 (ST 37 - 2) |
| ٨ | A52 | ٢ | Washer A52 (ST - 37) |
| ٩ | M80 | ٢٠ | NUT M80 * 4 |
| ١٠ | M36 | ٥ | NUT M36 |
| ١١ | M30 | ٥ | NUT M30 |
| ١٢ | Ø80/42 * 20 mm | ١٠ | Spacer (ST 37 - 2) |
| ١٣ | 10*65 mm | ٢ | Cotter Pin (ST - 37) |
| ✓ Valve Assembly | | | |
| ١٤ | Ø (80/70)*70 mm | ١ | Bushing (G.Sn.Pp.Bz5) With Threaded Pin M5*10 |
| ١٥ | Ø 90*15/50 | ١ | Shim (RST 44-2) |
| ١٦ | A16 | ٤ | Spring Washer (Spring Steel) |
| ١٧ | M16 | ٤ | NUT M16 |
| ١٨ | M16 * 55 | ٤ | Bolt |
| ١٩ | 20*12*120 mm | ٢ | Key (ST 60) |
| ٢٠ | 100/71*8 mm | ١ | Spacer (MS 63) |
| ٢١ | 10*70 mm | ١٢ | Toper Pin (ST - 12) |
| ٢٢ | 6*45 mm | ٢٤ | Cotter Pin (ST - 12) |
| ٢٣ | Ø(45*31)*4 mm | ٢٤ | Spacer (MS 63) |
| ٢٤ | Ø(45*31)*5 mm | ٢٤ | Plate Spacer (ST 44-2) |
| ٢٥ | 10*65 mm | ١٢ | Cotter Pin (ST - 12) |
| ٢٦ | 75/51*6 mm | ١٨ | Spacer (MS 63) |
| ٢٧ | 80/51*5 mm | ١٢ | Plate Spacer (ST 44-2) |
| ✓ Flab | | | |
| ٢٨ | 21 | ١٢ | Washer 21 |
| ٢٩ | M20 | ١٢ | NUT M20 |
| ٣٠ | M20 * 80 | ١٢ | Bolt |

بإدارة (١) بوزارة الموارد المائية والري
بإدارة (١) بوزارة الموارد المائية والري
بإدارة (١) بوزارة الموارد المائية والري



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وزارة الموارد المائية والري
الهيئة العامة للمياه والري
الإدارة العامة للمياه والري

[illegible]

| | | | |
|---------------|-----|----------------------------|---|
| 90*15*2250 mm | 1 | Attachment Bar (ST-44) | 1 |
| 50*20*2220 mm | 4 | Attachment Bar (ST-44) | 4 |
| 50*20*3775 mm | 4 | Attachment Bar (ST-44) | 4 |
| 50*20*3675 mm | 4 | Attachment Bar (ST-44) | 4 |
| 50*20*3420 mm | 4 | Attachment Bar (ST-44) | 4 |
| M16 | 4.0 | Cop Nut M16 (X22 Cr Ni 17) | 4 |
| M16*140 | 5 | Bolt (X22 Cr Ni 17) | 5 |
| M16 | 4.0 | Nut (X22 Cr Ni 17) | 4 |
| M16*100 | 4.0 | Bolt (X22 Cr Ni 17) | 4 |

שִׁמְרָה:

[illegible][illegible][illegible]

(A-8-B)



| الرمز | العدد | الوصف |
|--------|-------|------------------------------|
| M20*50 | ٤ | Bolt (X22 Cr Ni 17) |
| A20 | ٤ | Spring Washer (Spring Steel) |
| M24*80 | ٤ | Bolt (X22 Cr Ni 17) |

| | | |
|--------|----|-------------------------------------|
| A17 | ٩٠ | Washer (ST 00 Galvanized 80 micron) |
| M24*90 | ٩٥ | Bolt (X22 Cr Ni 17) |
| M24 | ٩٥ | Nut (X22 Cr Ni 17) |
| M16*90 | ٨٠ | Bolt (X22 Cr Ni 17) |
| M16*60 | ٤ | Bolt (X22 Cr Ni 17) |

| | | |
|---|---------------------------|--------|
| • | Net Length | = 1.42 |
| • | Net Weight | = 4 |
| • | Outer Cylinder Diameter Ø | = 3.8 |
| • | Inner Cylinder Diameter Ø | = 3.3 |
| • | Piston Rod | = 1.8 |
| • | Stroke | = 3.8 |
| • | Max Stroke | = 3.3 |
| • | Pressure Work | = 4 |
| • | Test Pressure | = 3.8 |
| • | Lifting Load | = 1 |
| • | Lowering Load | = 0.8 |

(4-4)

2/8/10

[illegible]

הַיְיטִים הַזֵּהִם הַזֵּהִם:

[illegible]

١٤٣٥

{IX} (X1) & (X2) {X} {Y} {Z}

[illegible]

- الخط الأنابيب (X2) بأبعاد (3 mm) * (Ø30) وبطول مسجل وبطول مسجل على الأسفل (أي الأسطر ذاتية) والهندسة وليكونية.
• الخط الأنابيب (X1) بأبعاد (3 mm) * (Ø25) وبطول مسجل وبطول مسجل على الأسفل (أي الأسطر ذاتية) والهندسة وليكونية.

(X1)&(X2) حسب الرسومات الهندسية المرفقة لتويات التفتيش من مادة استئصال رية ١٠٤٥٧١
استئصال استئصال مادة من جديدة جدي الهيدروليك الزيت الخطوط صبغة انابيب خطوط بطون ويزيد

جاءت الأصول والابتداء في صفات المصطفى عليه السلام في كتابه الأول والأخير

[illegible]

(4-1)

•

18/10/20

[illegible][illegible][illegible]

[illegible]

০/ জাতি জগত জগৎ, জগৎ

တရားရုံးချုပ်၊ ရန်ကုန်၊ မြန်မာနိုင်ငံ

بسم الله الرحمن الرحيم

الأسئلة على العملية.

طريقة القياس: أساس العمل التحصيل والتفصيل للأجزاء المدفوعة (Embedded Parts) ما لم يذكر خلاف ذلك في قائمة الكميات والقيمة شاملة المصنوعات والمعدات والعدد والأيوان وكافة ما يلزم لتتبع الأصول

[illegible]

ॐ/ कान कनक नमः । नमः ।
कनक नमः कनक नमः । नमः ।

۱۲۸۵

১৪/৮/১০

[illegible]

4. $\frac{1}{2}$ of the total population is () of the total population.

التي لا يرقى إليها نظر وفاء القاص، الرقعة على أن يتم الجدول حسب الأسفل في التفسير. التفسيرات حسب أسسها يتناول المقاول بتحديد أسسها:



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ה'תשס"ו
ה'תשס"ז

ဤစာချုပ်ကို ရက်စွဲ ၁၉၈၈ ခုနှစ်၊ ဇူလိုင်လ ၁၀ ရက်နေ့တွင် ရန်ကုန်မြို့၊ ဝန်ကြီးရုံးတွင် ရုပ်သိမ်းခဲ့ပါသည်။

חסדו ורחמי
 וחסדו ורחמי
 וחסדו ורחמי



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ဤစာချုပ်ကို ရက်စွဲ၊ နေရာ၊ နာမည်၊ နှစ်ရပ်ကို ဖြည့်စွက်ရန် ဖော်ပြပါ နေရာများတွင် ဖြည့်စွက်ရန် လိုအပ်ပါသည်။

အကျဉ်းချုပ်: ဤစာတမ်းသည် မြန်မာနိုင်ငံတော်၏ နိုင်ငံရေး၊ ဖွဲ့စည်းပုံအခြေခံဥပဒေနှင့် ပတ်သက်သည့် အဓိက အချက်အလက်များကို ဖော်ပြထားပါသည်။



2/5/2020

ᐱᕈᑦ ᓂᕈᑦ ᐱᕈᑦ ᐱᕈᑦ ᐱᕈᑦ ᐱᕈᑦ

ጥያቄ: የፍትሕ ምክር ቤት ማህተም:

- 21 -

21/5/2020

[illegible][illegible]

အကျဉ်းချုပ်: ဤစာအုပ်သည် မြန်မာ့သမိုင်းနှင့် နိုင်ငံရေး အကျိုးအမြတ်များကို ဖော်ပြထားပါသည်။



[illegible]

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1. אברהם אבינו
 2. יצחק אבינו
 3. יעקב אבינו
 4. משה אבינו
 5. דוד אבינו
 6. ישוע אבינו
 7. מרדכי אבינו
 8. נח אבינו
 9. שמואל אבינו
 10. שלמה אבינו
 11. חנוך אבינו
 12. יונה אבינו
 13. יחזקאל אבינו
 14. יוחנן אבינו
 15. יוחנן אבינו
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 22. יוחנן אבינו
 23. יוחנן אבינו
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تأدية الكميات وبيان الأعمال المنجزة في إطار مشروع إنشاء سد أسوان

ملحق: قائمة الكميات وبيان الأعمال:

وزارة الموارد المائية والري
الهيئة العامة للسد العالي وجران أسوان
الإدارة العامة لصيانة جدران أسوان



Ministry of Water Resources and Irrigation
High and Aswan Dams Authority
General Directorate of Old Aswan Dam Maintenance

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1. References

In a general manner and in all matters that do not modify or contradict the scope of the conditions that are described below, the provisions of the following codes, instructions and official standards shall apply to the works included in this design:

- AISC - American Institute of Steel Construction, such as:**
- AISC S329: 85 Allowable Stress Design Specification for Structural Joints Using ASTM A325 or A490 Bolts with Commentary.
 - AISC S335: 89 Specifications for Structural Steel Buildings Allowable Stress Design and Plastic Design
 - AISC S341: 92 Seismic Provisions for Structural Steel Building
 - AISC S342: 93 Load and Resistance Factor Design Specification for Structural Steel Buildings
- ANSI - American National Standards Institute, such as:**
- AISI S6 - 673: 89 Specifications for the Design of Cold-Formed Steel Structural Members
 - AISI S6 - 913: 91 Load and Resistance Factor Design Specification for Cold-Formed Steel Structural Members.
- ASTM - American Society for Testing and Materials, such as:**
- ASTM A 6M: 89 Standard Specification for General Requirements for Rolled Steel Plates, Shapes, Sheet Piling, and Bars for Structural Use.
 - ASTM A 36M: 89 Standard Specification for Structural Steel
 - ASTM A 148M: 89 Standard Specification for Steel Castings High Strength, for Structural Purposes
 - ASTM A 242M: 89 Standard Specification for High-Strength Low-Alloy Structural Steel
 - ASTM A 307: 89 Standard Specification for Carbon Steel Bolts and Studs, 60000 PSI Tensile Strength
 - ASTM A 325M: 89 Standard Specification for High-Strength Bolts for Structural Steel Joints [Metric]
 - ASTM A 354: 89 Standard Specification for Quenched and Tempered Alloy Steel Bolts, Studs, and Other Externally Threaded Fasteners.
 - ASTM A 441M: 89 High-Strength Low-Alloy Structural Manganese Vanadium Steel
 - ASTM A 446M: 89 Standard Specification for Steel Sheet, Zinc-Coated by the Hot-Dip Process, Structural Quality.
 - ASTM A 449: 89 Standard Specification for Quenched and Tempered Steel Bolts and Studs
 - ASTM A 490M: 89 Standard Specification for High-Strength Steel Bolts, Classes 10.9 and 10.9.3, for Structural Steel Joints [Metric].
 - ASTM A 500: 89 Standard Specification for Cold-Formed Welded and Seamless Carbon Steel Structural Tubing in Rounds and Shapes.
 - ASTM A 501: 89 Standard Specification for Hot-Formed Welded and Seamless Carbon Steel Structural Tubing.
 - ASTM A 514M: 89 Standard Specification for High-Yield-Strength, Quenched and Tempered Alloy Steel Plate, Suitable for Welding.
 - ASTM A 529M: 89 Standard Specification for Structural Steel with 42 ksi [290 MPa] Minimum Yield Point (1/2 in. [13 mm] Maximum Thickness).
 - ASTM A 570M: 88 Standard Specification for Steel, Sheet and Strip, Carbon, Hot-Rolled, Structural Quality.
 - ASTM A 572M: 88 Standard Specification for High-Strength Low-Alloy Columbium-Vanadium Steels of Structural Quality.
 - ASTM A 588M: 88a Standard Specification for High-Strength Low-Alloy Structural Steel with 50 ksi [345 MPa] Minimum Yield Point to 4 in. [100 mm] Thick.



- ASTM A 606: 85 Standard Specification for Steel, Sheet and Strip, High-Strength, Low-Alloy, Hot-Rolled and Cold-Rolled, with Improved Atmospheric Corrosion Resistance.
- ASTM A 607: 85 Standard Specification for Steel, Sheet and Strip, High-Strength, Low-Alloy, Columbium or Vanadium, or Both, Hot-Rolled and Cold-Rolled.
- ASTM A 611: 89 Standard Specification for Steel, Sheet, Carbon, Cold-Rolled, Structural Quality.
- ASTM A 618: 89 Standard Specification for Hot-Formed Welded and Seamless High-Strength Low-Alloy.
- ASTM A 633M: 88 Standard Specification for normalized High-Strength Low-Alloy Structural Steel
- ASTM A 678M: 89 Standard Specification for Quenched-and-Tempered Carbon-Steel and High-Strength Low-Alloy Steel Plates.
- ASTM A 715: 89 Standard Specification for Steel Sheet and Strip, High-Strength, Low-Alloy, Hot-Rolled, and Steel Sheet, Cold-Rolled, High-Strength, Low-Alloy, with Improved Formability.
- ASTM A 792: 89 Standard Specification for Steel Sheet, Aluminum-Zinc Alloy-Coated by the Hot-Dip Process, General Requirements.
- ASTM E 94: 93 Standard Guide for Radiographic Testing.
- ASTM E 142: 92 Standard Method for Controlling Quality of Radiographic Testing
- ASTM E 164: 08 Standard Practice for Ultrasonic Contact Examination of Weldments ASTM E 165: 95
- Standard Test Method for Liquid Penetrate Examination.
- ASTM E 709: 95 Standard Guide for Magnetic Particle Examination.

EN - European Standard, such as:

- EN 1090-2 Standard Guide for Execution of Steel Structures.

USACE - United States Army Corps of Engineer, such as:

- EM 1110-2 (Last version) Standard Guide for Design of Hydraulic Steel Structures and Gates.
- EM 1110-2-2610 Standard Guide for Structural design of steel gates.

These references given alignment, tolerance guide, sealing performance & operational requirement of Hydraulic steel Gates under water head.

AWS - American Welding Society, such as:

- AWS A5.1: 91 Specification for Carbon Steel Electrodes for Shielded Metal Arc Welding
- AWS A5.5: 96 Specification for Low - Alloy Steel Electrodes for Shielded Metal Arc Welding
- AWS A5.18: 93 Specification for Carbon Steel Electrodes and Rods for Gas Shielded Arc Welding
- AWS A5.20: 95 Specification for Carbon Steel Electrodes for Flux Cored Arc Welding
- AWS A5.28: 96 Specification for Low - Alloy Steel Electrodes and Rods for Gas Shielded Arc Welding
- AWS A5.29: 89 Specification for Low Alloy Steel Electrodes for Flux Cored Arc Welding.
- SSPC Steel Structures Painting Council.

ISO - International Organization for Standardization, such as:

- ISO 13920 Standard Guide for Steel Structures Tolerance for Welding.
- ISO 12944 part (2,4,5,7) Standard Guide for Surface Protection (Painting).
- ISO 8501/8503 Standard Guide for Surface Preparation before Painting.
- ISO 4413 Standard guide for hydraulic fluid power - General rules & safety requirements for systems & their components.

All Codes, instructions and standards compulsory by law, in any of their aspects, at the time the contract is awarded are considered included in this particular specification sheet to all effects and purposes, regardless of whether they have verbally quoted or not.

All standards shall be applied together with the manufacturer's recommendations for Hydraulic equipments, where requirements differ between standards the most conservative (stringent) requirement shall apply.

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II. Fabrication

1. Preparation of Materials

All rolling burr will be removed from all sections and plates used in the construction. The rolling embossed marks on points of contact with another element in the connections of the structure will be also removed. The smoothing and straightening of plates and sections will be carried out with a press or a roll machine preferably in cold conditions. Local and permanent deformations will not exceed, at any point, 2.5% of the initial dimension, unless the cold deformed pieces are later subjected to a normalizing annealing. Moreover, in cold bending and folding operations dents will be prevented from appearing in the web or in the compression flange of the bent section. Cracks will be prevented from appearing in the tension surface during deformation. Hot bending, straightening and forming operations (or others that may be necessary) will be carried out at the temperature of light cherry red (about 950 °C) interrupting the operation when temperature drops below dark red (around 700 °C) and reheating the piece afterwards. The direct use of below torches is forbidden in forming and straightening operations. All necessary precautions should be taken to avoid the alteration of the structure of the material or introducing residual stresses during the heating and cooling phases. If possible, heating should be carried out in a furnace. Cooling should be performed in calm, open air, without artificial acceleration. Where the taken precautions are not sufficient to eliminate completely the residual deformations due to welding operations, and such deformations are inadmissible for the service or for good appearance of the structure, they may be cold corrected, with press or roll machine, as long as in this operation, the above-mentioned limits of deformation are not exceeded and the piece corrected is subjected to a careful examination to detect any fissures. that may have appeared in the welding material or in the transition area of the base material.

2. Lay-out

Before making the lay-out, a check shall be made to determine that the different plates and sections have the exact desired shape, and that they are free of twisting. The lay-out will be carried out by qualified personnel in strictly compliance with the dimensions on the drawings. The maximum admissible tolerance is according to previously studied and approved methods of fabrications. No punch marks should be left that are not eliminated by later operations.

3. Cutting of Material

Cutting may be carried out with saw, shears or flame cutting. Burrs, grooves or uneven edges, shall be ground subsequently. Electric arc cutting is strictly forbidden. Moreover, the following stipulations shall be observed:

- a) Shear cutting is only allowed up to a maximum thickness of 15 mm.
- b) When using flame cutting, special precautions will be taken to avoid introducing thermal stress.
- c) Shear or torch cut edges located near joints will be machined with emery stone, groove with ground rear, in order to remove the entire layer of altered metal. Machining shall be performed up to a minimum distance of 30 mm to 0 the end of weld. The operation is not necessary when the edge have to be melted, to that depth, during the welding process.
- d) All cutting unevenness and irregularities on edges to be welded will be eliminated.

4. Holes

Holes for bolts shall always be made with a drill.

5. Preparation of Components for Welding

Unless specified otherwise here in or as noted on the design drawings, welding conform with the AISI Specifications. The selection of the most suitable method of preparing the edges, in each case, will be made by the Contractor according to the machine tools available, deformations expected in the pieces, economic factors, etc.

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8. Choice of Welding Units

The Contractor should bear in mind the different types of electrodes when choosing the welding machines to be used.

9. Butt Welds

Butt welds will always be continuous and of complete penetration. While meeting this condition, all necessary measures will be taken to avoid craters at the beginning and end of beads. When joints of this type are made between two pieces of different cross section, and the thickness of one of them is over 1.25 times that of the other, the end of the piece with the largest section will be beveled on all faces in which it is necessary, with a gradient of not over 1/5.

The beveling of the face of greater thickness will be machined. It is not recommended that this be done by torch, but in case in which a torch is used the surface will be cleaned to 3 to 5 mm in depth with a pneumatic grind wheel machine, leaving a completely smooth and flat surface.

The root will be dressed before depositing the sealing bead, or the first bead of the rear face.

When access by the rear face is not possible the weld will be made with a back plate in order to achieve complete penetration.

In all butt welds, the beads will be extended at the ends, outside of the pieces to be welded, in order to achieve a real effective length.

10. Fillet Welds

In fillet welds, the throat "a" is the height of the maximum isosceles triangle, whose equal sides are contained within the faces of the two pieces to be joined, inscribed in the cross section of the weld.
The thickness of bead "a" will be in direct function of the thickness of the components to be welded, in accordance with AWS D1.1.

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