Claims

1. ~~Box~~Crane girder ~~(1), in particular crane girder,~~in the form of a box girder having two side plates ~~(2a, 2b)~~ spaced apart from each other, at least one chord plate ~~(2c, 2d)~~ connecting the two side plates ~~(2a, 2b)~~ to each other and at least one transverse plate ~~(5)~~ that is arranged between the side plates ~~(2a, 2b)~~ connecting the side plates ~~(2a, 2b)~~ to each other, wherein a welded joint is provided between the respective chord plate ~~(2c, 2d)~~ and the side plates ~~(2a, 2b)~~, wherein at least one form-fitting connection, in particular plug-in connection, is provided between the transverse plate ~~(5)~~ and each of the two side plates ~~(2a, 2b)~~, characterized in that at least one form-fitting connection, in particular plug-in connection, is also provided between the transverse plate ~~(5)~~ and the chord plate ~~(2c)~~.

2. Crane~~Box~~ girder ~~(1)~~ as claimed in claim 1, characterized in that for producing the respective form-fitting connection a plug-in portion ~~(5ab, 5ac)~~ of the transverse plate ~~(5)~~ is received by a corresponding receiving aperture ~~(2e, 2f)~~ of the respective side plate ~~(2a, 2b)~~ and/or the respective chord plate ~~(2c)~~, each receiving aperture ~~(2e, 2f)~~ having a substantially complementary shape relative to the respective plug-in portion ~~(5ab, 5ac)~~.

3. Crane ~~Box~~ girder ~~(1)~~ as claimed in any one of the preceding claims, characterized in that the plug-in portion ~~(5ab, 5ac)~~ is formed as a protrusion of an outer edge of the transverse plate ~~(5)~~, in particular with the protrusion having a rectangular shape.

4. Crane ~~Box~~ girder ~~(1)~~ as claimed in any one of the preceding claims, characterized in that at least one of the plug-in portions ~~(5ab)~~ is designed to form a support element ~~(5b)~~ extending through the corresponding receiving aperture ~~(2e)~~ and being configured so that a crane equipment element, in particular a power supply line and/or a platform for personnel, is attachable to the support element ~~(5b)~~.

5. Crane ~~Box~~ girder ~~(1)~~ as claimed in any one of the preceding claims, characterized in that in addition to the form-fitting connection a further force-transmitting connection is provided between the transverse plate ~~(5)~~ and the respective side plate ~~(2a, 2b)~~ and/or between the transverse plate ~~(5)~~ and the respective chord plate ~~(2c)~~, with the further connection preferably being a welded joint, in particular of the fillet or the plug

weld type.

6. Crane~~Box~~ girder ~~(1)~~ as claimed in any one of the preceding claims, characterized in that it is configured so that each chord plate ~~(2c, 2d)~~ can alternatively form an upper chord ~~(3)~~ in a first orientation of the box girder ~~(1)~~ or a lower chord ~~(4)~~ in a second orientation of the box girder ~~(1)~~, wherein, independently from the orientation of the box girder ~~(1)~~, a running surface for wheels ~~(6)~~ of a crane trolley is provided on the same chord plate ~~(2d)~~.

7. Crane having a ~~box~~crane girder ~~(1)~~ in the form of a box girder as claimed in any one of the preceding claims and a lifting gear that is arranged on the box girder ~~(1)~~, in particular with the lifting gear being movable along the box girder ~~(1)~~ and on its upper chord ~~(3)~~ or lower chord ~~(4)~~ by means of a crane trolley.

8. Manufacturing method for a crane~~box~~ girder in the form of a box girder~~(1), in particular crane girder,~~ having two side plates ~~(2a, 2b)~~ spaced apart from each other, at least one chord plate ~~(2c, 2d)~~ connecting the two side plates ~~(2a, 2b)~~ to each other and at least one transverse plate ~~(5)~~ that is arranged between the side plates ~~(2a, 2b)~~ connecting the side plates ~~(2a, 2b)~~ to each other, wherein a welded joint is produced between the respective chord plate ~~(2c, 2d)~~ and the side plates ~~(2a, 2b)~~, wherein at least one form-fitting connection, in particular plug-in connection, is produced between the transverse plate ~~(5)~~ and each of the two side plates ~~(2a, 2b)~~ before the welded joint between the respective chord plate ~~(2c, 2d)~~ and the side plates ~~(2a, 2b)~~ is produced, characterized in that at least one form-fitting connection, in particular plug-in connection, is also produced between the transverse plate ~~(5)~~ and the chord plate ~~(2c)~~ before the welded joint between the respective chord plate ~~(2c, 2d)~~ and the side plates ~~(2a, 2b)~~ is produced.

9. Manufacturing method as claimed in the preceding claim, characterized in that the respective form-fitting connection is produced by plugging a plug-in portion ~~(5ab, 5ac)~~ of the transverse plate ~~(5)~~ into a corresponding receiving-aperture ~~(2e, 2f)~~ of the respective side plate ~~(2a, 2b)~~ and/or the respective chord plate ~~(2c, 2d)~~, each receiving aperture ~~(2e, 2f)~~ having a substantially complementary shape relative to the respective plug-in portion ~~(5ab, 5ac)~~.

10. Manufacturing method as claimed in any one of the preceding claims, characterized in that in addition to the form-fitting connection a further force-transmitting connection is produced between the transverse plate ~~(5)~~ and the respective side plate ~~(2a, 2b)~~ and/or between the transverse plate ~~(5)~~ and the respective chord plate ~~(2c)~~, with the further force-transmitting connection preferably being a welded joint, in particular of the fillet or the plug weld type.