Claims

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

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

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

4. Crane girder as claimed in any one of the preceding claims, characterized in that at least one of the plug-in portions is designed to form a support element extending through the corresponding receiving aperture 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.

5. Crane girder 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 and the respective side plate and/or between the transverse plate and the respective chord plate, with the further connection preferably being a welded joint, in particular of the fillet or the plug weld type.

6. Crane girder as claimed in any one of the preceding claims, characterized in that it

is configured so that each chord plate can alternatively form an upper chord in a first orientation of the box girder or a lower chord in a second orientation of the box girder, wherein, independently from the orientation of the box girder, a running surface for wheels of a crane trolley is provided on the same chord plate.

7. Crane having a crane girder 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, in particular with the lifting gear being movable along the box girder and on its upper chord or lower chord by means of a crane trolley.

8. Manufacturing method for a crane girder in the form of a box girder having two side plates spaced apart from each other, at least one chord plate connecting the two side plates to each other and at least one transverse plate that is arranged between the side plates connecting the side plates to each other, wherein a welded joint is produced between the respective chord plate and the side plates, wherein at least one form-fitting connection, in particular plug-in connection, is produced between the transverse plate and each of the two side plates before the welded joint between the respective chord plate and the side plates is produced, characterized in that at least one form-fitting connection, in particular plug-in connection, is also produced between the transverse plate and the chord plate before the welded joint between the respective chord plate and the side plates 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 of the transverse plate into a corresponding receiving-aperture of the respective side plate and/or the respective chord plate, each receiving aperture having a substantially complementary shape relative to the respective plug-in portion.

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 and the respective side plate and/or between the transverse plate and the respective chord plate, with the further force-transmitting connection preferably being a welded joint, in particular of the fillet or the plug weld type.