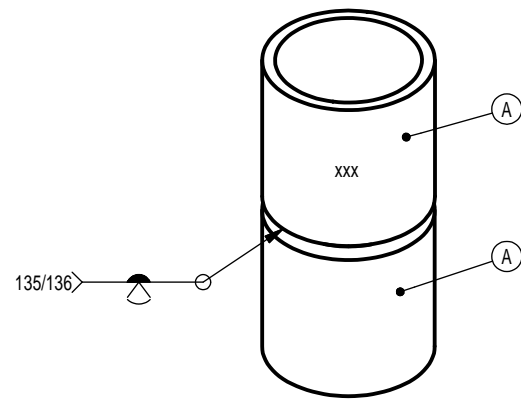


MATERIAL: CARBON STEEL PIPE
2 PCS Ø114.3 X 8.0 WALL X 115 LONG

NOTE:
THE NUMBER OF TACKS IS TO BE
LIMITED WITH A MAXIMUM 4 TACKS.

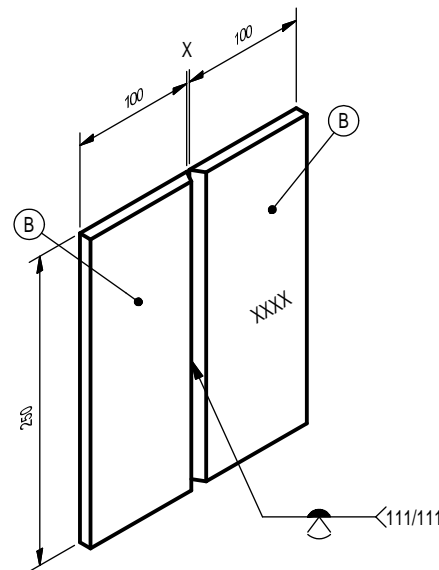


FILL & CAP: _____136_(FCAW)_____

1. VISUAL
2. X-RAY ENTIRE WELD JOINT

MATERIAL: CARBON STEEL PLATE
THICKNESS: 10 mm.

X = YOUR CHOICE

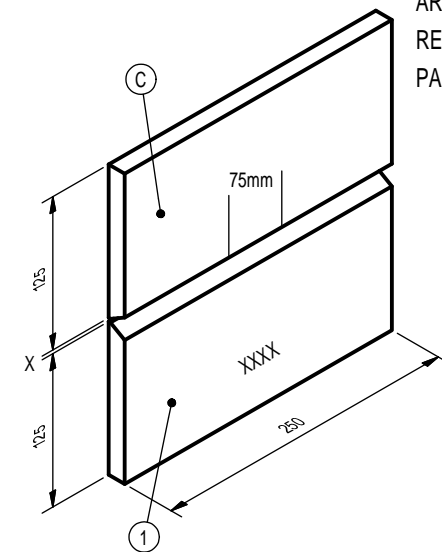


FILL & CAP: 111(SMAW)

1. VISUAL
2. X-RAY ENTIRE WELD JOINT

MATERIAL: CARBON STEEL PLATE
THICKNESS: 16 mm.

X = YOUR CHOICE



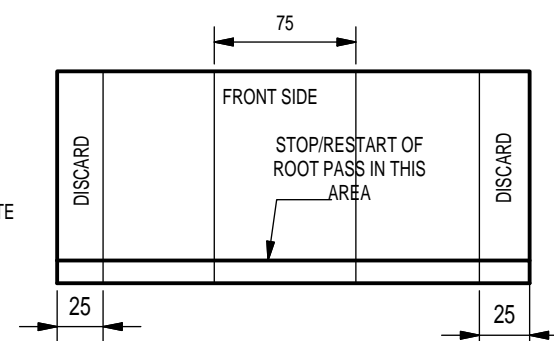
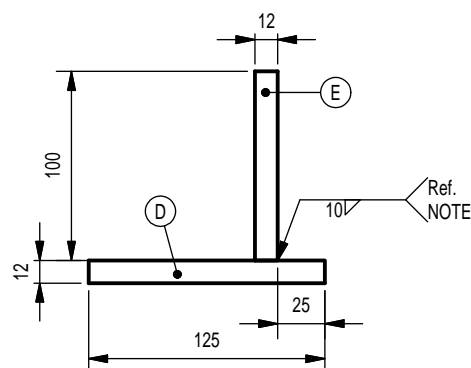
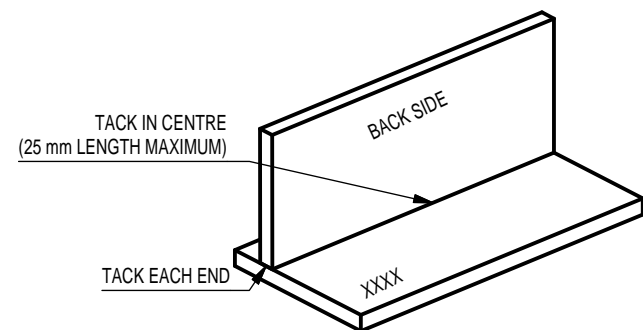
HOLD POINT
AREA OF STOP AND
RESTART IN FINAL CAP
PASS

FILL & CAP: ____135(GMAW)____

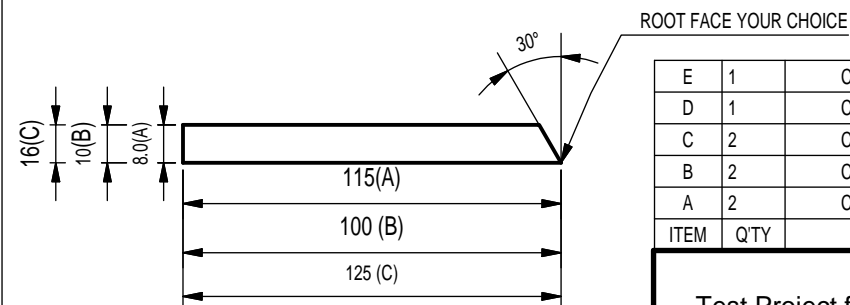
1. VISUAL
2. X-RAY ENTIRE WELD JOINT

WELDING PROCESS: 111(SMAW)
WELDING POSITION: PB(2F)

1. DEPOSIT A FILLET WELD ON THE FRONT SIDE OF THE JOINT WITH A 10 mm (+2.0/-0) mm LEG LENGTH.
2. WELD TO BE DEPOSITED WITH A MINIMUM OF 2 RUNS AND A MAXIMUM OF 3 RUNS.
3. EDGE PREPARATION MUST REMAIN AT 90° TO THE PLATE FACE. NO CHAMFER AND GAP ALLOWED.



1. ANY PROCESS AND ANY POSITION MAY BE USED FOR TACKWELDING.
2. ALL TACK WELDS EXCEPT CENTRE OF FILLET WELDS ARE TO BE NOT LONGER THAN 15 mm. A MAXIMUM OF 4 TACKS ARE TO BE MADE FOR TEST PIPE COUPON.
3. ALL PLATE OR PIPE COUPONS ARE TO BE TACKWELDED BEFORE ANY WELDING COMMENCES.
4. PROCESS INDICATED FOR ROOT WELD TO BE USED ONLY FOR ONE RUN, NOT FOR SECOND AND SUBSEQUENT PASSES.
5. ALL PLATE OR PIPE COUPONS MUST BE WELDED IN THE POSITION AS INDICATED FOR EACH TEST.
6. GRINDING IS **NOT** ALLOWED FOR THE CLEANING OF THE FINAL SURFACES OF BOTH CAP AND ROOT WELDS.
7. XXXX= COMPETITOR'S I.D.



DETAIL OF MILLED BEVEL

ALL DIMENSIONS IN MILLIMETRES
BUT DO NOT SCALE DRAWING

NTS = NOT TO SCALE

E	1	CARBON STEEL	PLATE 250 X 100 X 12	
D	1	CARBON STEEL	PLATE 250 X 125 X 12	
C	2	CARBON STEEL	PLATE 250 X 125 X 16	30 deg. MILLED BEVEL
B	2	CARBON STEEL	PLATE 250 X 100 X 10	30 deg. MILLED BEVEL
A	2	CARBON STEEL	PIPE OD 114.3 X 8.0 WALL X 115 LONG	30 deg. TURNED BEVEL
ITEM	Q'TY	MATERIAL	DESCRIPTIONS	REMARKS

Test Project for the 43rd WorldSkills
Competition in São Paulo, Brazil 2015
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Skill: 10. Welding, Schweissen, Soudage, Soldagem

Scale: N. T. S	Date: 08. Aug. 2015
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Date: 08. Aug. 2015	Paper: A3
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Paper: A3



OR



Designed/Drawn by: Chih-Peng Chen TW

Drawing No: TP10_43BR_DAY1_GENERIC

Description: Module I--Test Coupons (Plates/Pipe/Fillet)

Rev. 3

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