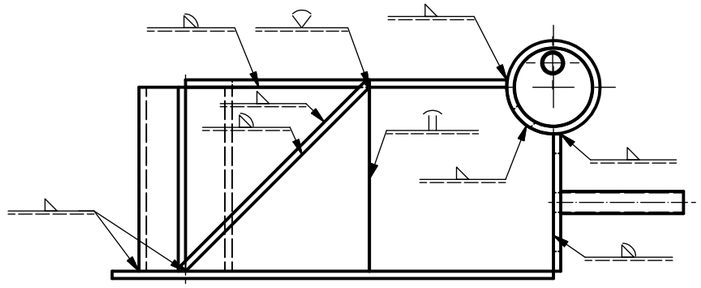
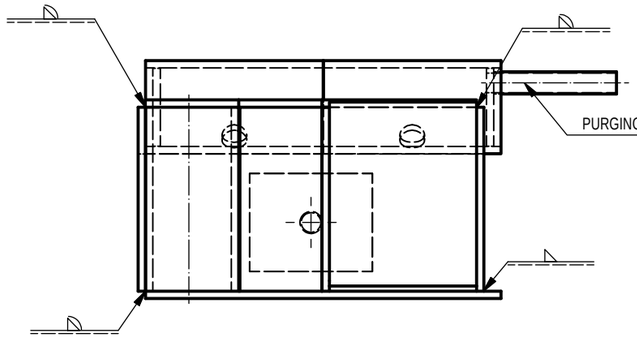
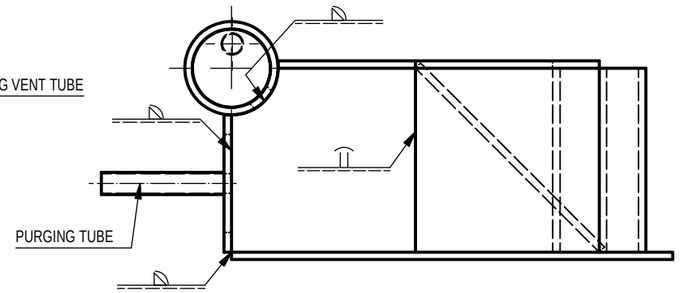
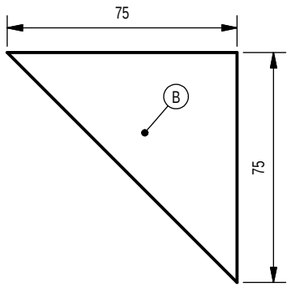
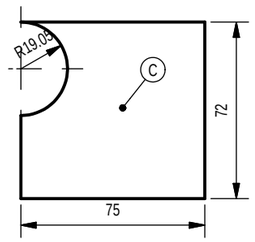
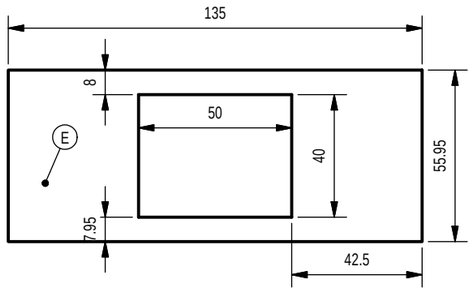


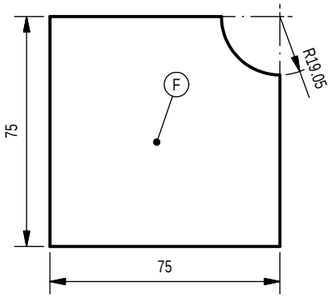


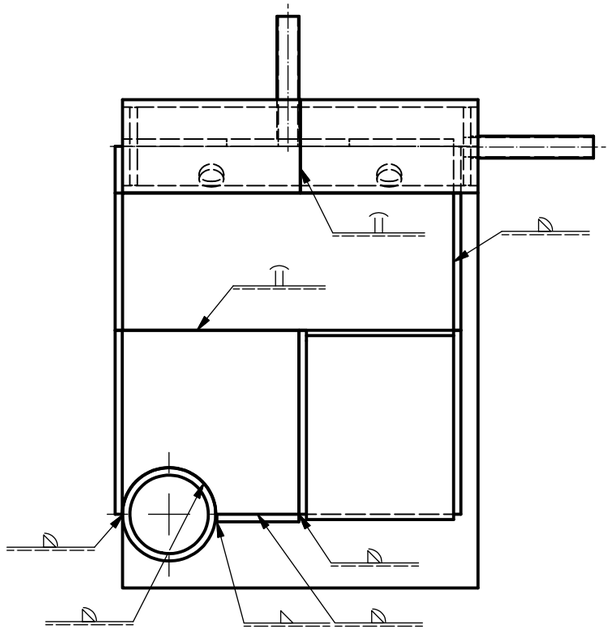


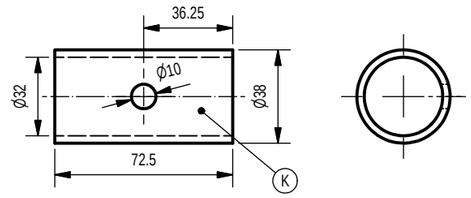


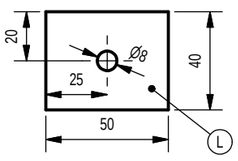


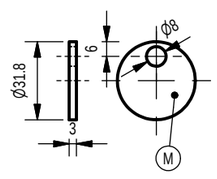


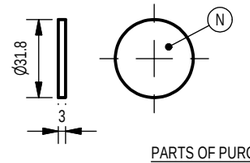


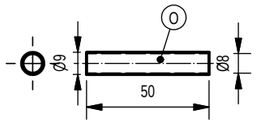




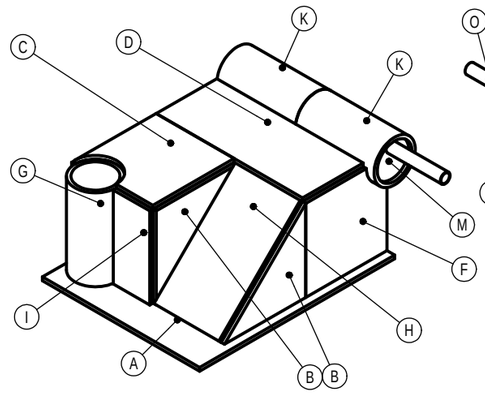


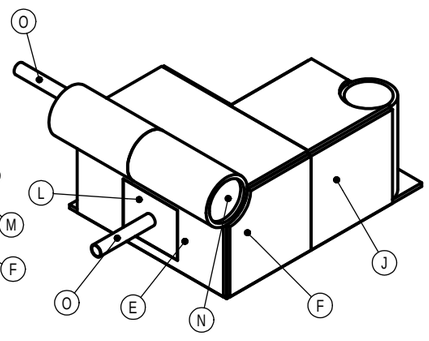






PARTS OF PURGING APPARATUS





INSTRUCTIONS

1. TACK WELDS CAN BE MADE IN ANY POSITION WITH GTAW (141) PROCESS IN THE MOST LOGIACL SEQUENCE FOR STRUCTURAL SQUARENESS AND JOINT ACCESS. ALL TACK WELDS ARE TO BE MADE NO LONGER THAN 10 mm AND PLACED ON THE OUTSIDE OF THE STRUCTURE ONLY. ALL WELDS ARE TO BE MADE AS INDICATED ON DRAWING.

2. ALL FILLET WELDS ARE TO BE 3.0 mm (+1.0/0 mm) IN LEG LENGTH.

3. NO GRINDING WILL BE ALLOWED.

4. NO POST CLEANING.

5. GTAW(141):AWS A 5.9 ER 308L WITH 100% ARGON SHIELDED AND PURGING.

Item	Title	Material	Quantity
O	Purging & Vent Tubes OD 9.0 X 0.5 X50 as per sketch	AISI 304 Stainless Steel	2
N	Horizontal Pipes Plug OD 31.8 X3.0	AISI 304 Stainless Steel	1
M	Horizontal Pipes Plug OD 31.8 X3.0 with 0.8 mm Hole as per sketch	AISI 304 Stainless Steel	1
L	Back Seal Plate for Purging 50X40X3.0 as per sketch	AISI 304 Stainless Steel	1
K	Horizontal Pipes 1.5"X0.083" SS Tube or OD 38 mm X 3.0 mm X 72.5 SS Tube	AISI 304 Stainless Steel	2
J	Pipe Side Front Plate 75X75X3.0	AISI 304 Stainless Steel	1
I	Front Plate 75X33.5X3.0	AISI 304 Stainless Steel	1
H	Front Angled Plate 106.07X60X3.0	AISI 304 Stainless Steel	1
G	Vertical Tube 1.5"X0.083" SS Tube or OD 38 mm X 3.0 mm X75 SS Tube	AISI 304 Stainless Steel	1
F	Back Side Plates 75X75X3.0 as per sketch	AISI 304 Stainless Steel	2
E	Back Plate 135X55.95X3.0 as per sketch	AISI 304 Stainless Steel	1
D	Top Back Plate 135X55.95X3.0	AISI 304 Stainless Steel	1
C	Top Front Plate 75X72X3.0 as per sketch	AISI 304 Stainless Steel	1
B	Large Triangle 75X75X3.0 as per sketch	AISI 304 Stainless Steel	2
A	Base Plate, 180X145X3.0	AISI 304 Stainless Steel	1

ALL DIMENSIONS IN MILLIMETRES (UNLESS NOTED OTHERWISE)

Test Project for the 43rd WorldSkills Competition in Saõ Paulo, Brazil 2015
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worldskills

Skill: 10. Welding, Schweissen, Soudage, Soldagem

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

OR

Designed by Nick Peterson US/ Drawn by Chih-Peng Chen TW

Drawing No: TP10_43BR_DAY4_SS-US-ISO E

Description: Module IV--Stainless Steel (Rostfreier Stahl, Inoxydable L'acier)

Rev. 2