

1 2 3 4 5 6

A

B

C

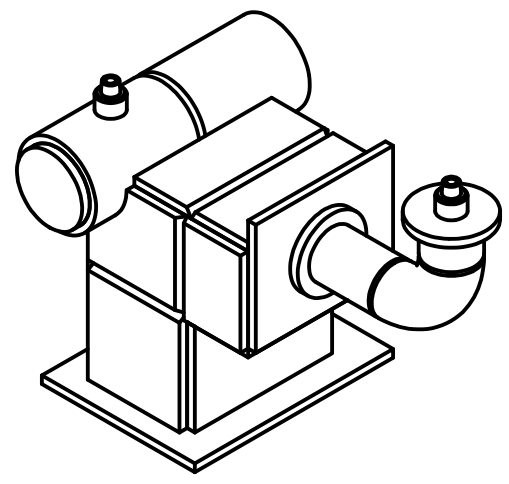
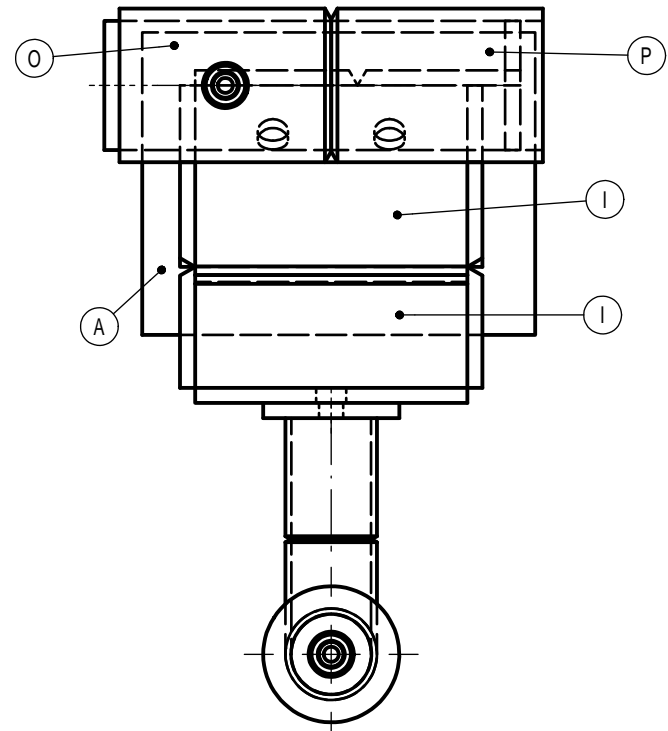
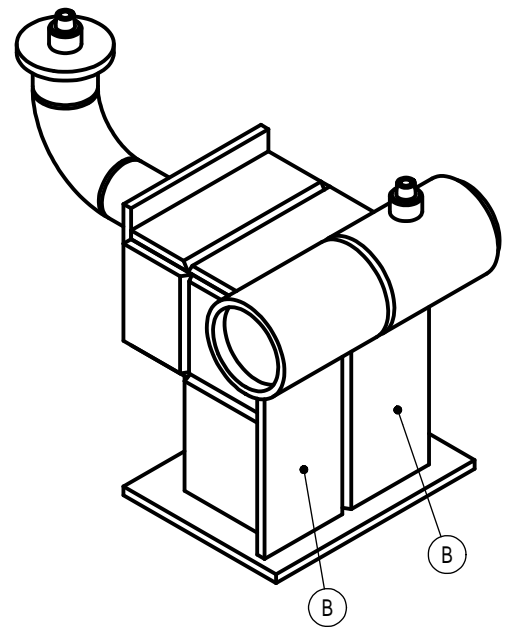
D

A

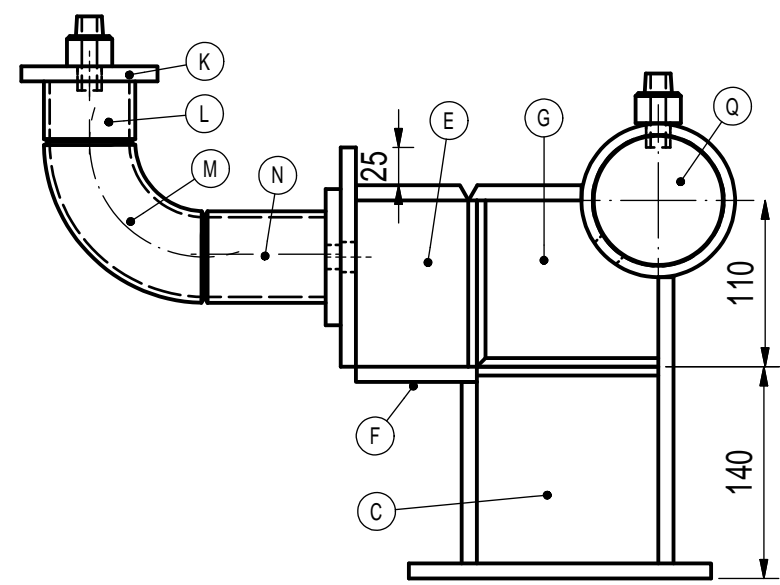
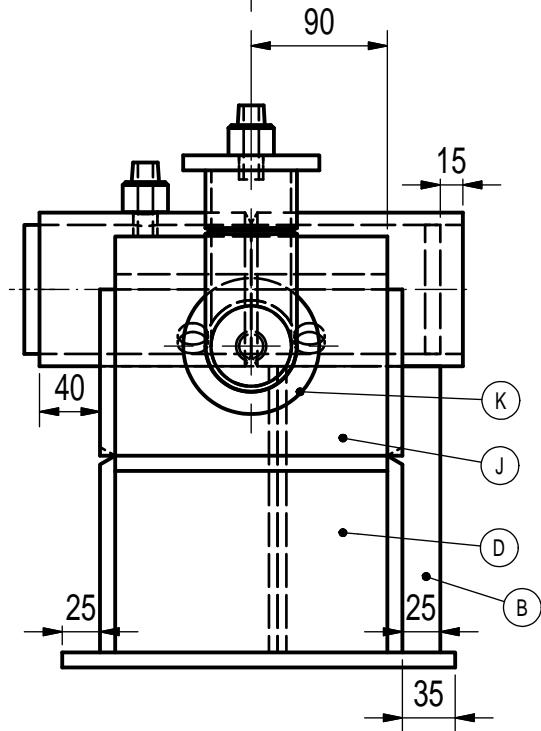
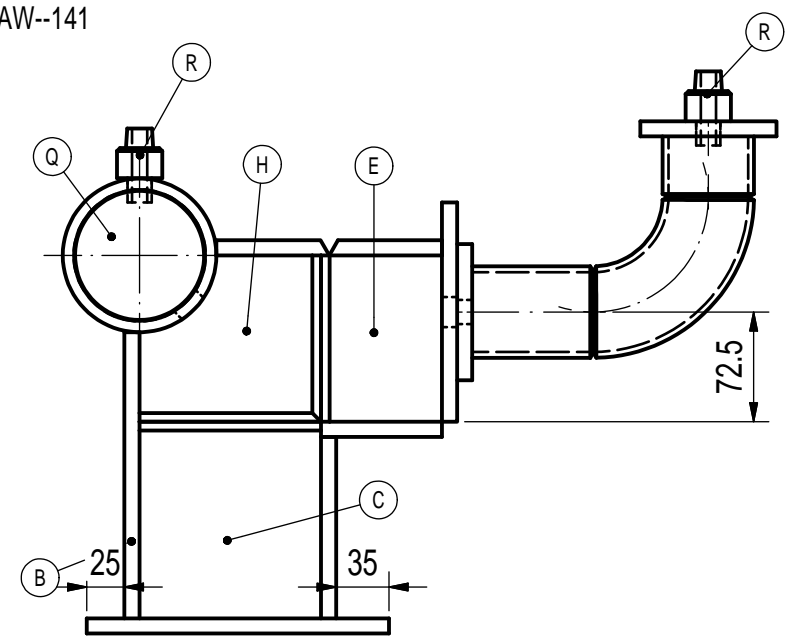
B

C

D



Welding Processes:
SMAW--111
GMAW--135
FCAW--136
GTAW--141



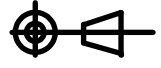

UNIT:mm

INSTRUCTIONS TO COMPETITORS

1. TACK WELDS SHOULD BE MADE IN ANY POSITIONS USING ANY PROCESSES LISTED ON THE DRAWING.
2. ALL TACK WELDS ARE TO BE MADE NOT LONGER THAN 15 mm AND SHALL BE MADE ONLY ON THE OUTSIDE OF THE VESSEL.
3. ALL FILLET WELDS SHALL HAVE A LEG SIZE OF 10 mm WITH TOLERANCE (+2.0 mm/-0.0 mm).
4. OUTSIDE CORNER WELD RADII: 10 mm WITH TOLERANCE (+1.0 mm/-0.9mm).
5. GRINDING SHOULD BE ALLOWED TO BE CARRIED OUT ONLY FOR TACK WELD, START/STOP AND INTERLAYER PASSES.OF THE WELDS.
6. FINAL CLEANING MAY BE CARRIED OUT BY USING WIRE BRUSH.

Test Project for the 43rd WorldSkills
Competition in São Paulo, Brazil, 2015.
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Skill: 10. Welding, Schweißen, Soudage, Soldagem			 OR 
Scale: N. T. S	Date: 08. Aug. 2015	Paper: A3	
Drawn/Designed by: Chih-Peng Chen TW			Drawing No:WSC2015_TP10_TW_PV_ASSEMBLY_ISO A
Description: Pressure Vessel-Assembly			Rev: 3
			Page:
			Appd:
			Sign:

1 2 3 4 5 6