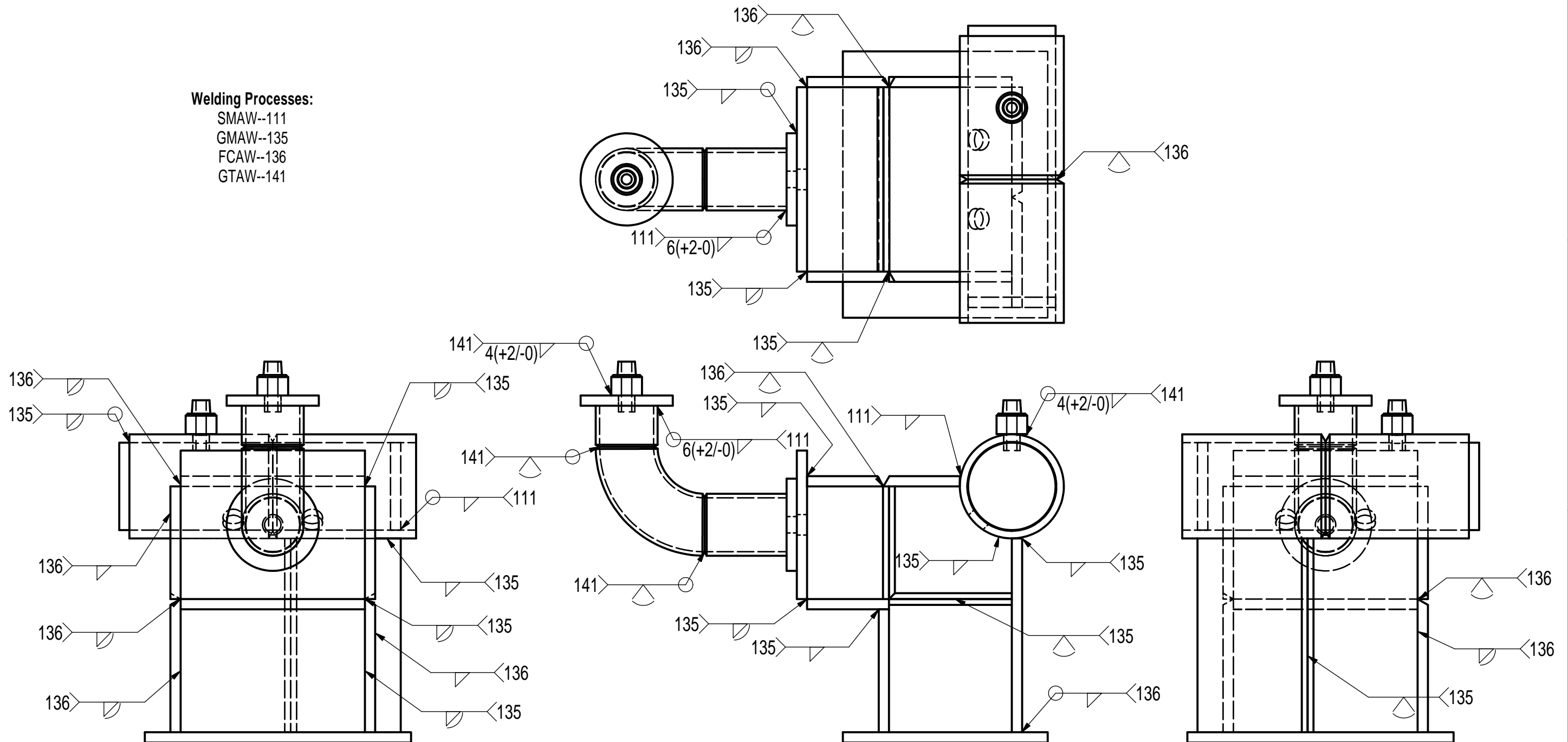


Welding Processes:

SMAW--111
GMAW--135
FCAW--136
GTAW--141





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_SYMBOLS_ISO A		
Description: Pressure Vessel-Symbols			Rev: 3		Page:
			Appd:		Sign: