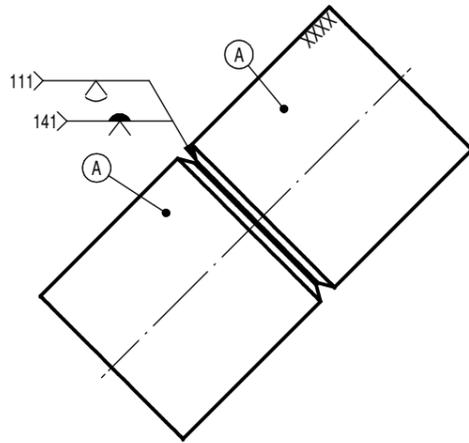


**PIPE TEST COUPON 1A:**

MATERIAL: CARBON STEEL PIPE  
2 PCS  $\phi 114.3 \times 8.6$  WALL X 115 LONG

**NOTE:**  
THE NUMBER OF TACKS IS TO BE LIMITED WITH A MAXIMUM 4 TACKS AND MINIMUM 3 TACKS.



**WELDING PROCESSES/POSITION: PH-L045(6G)**

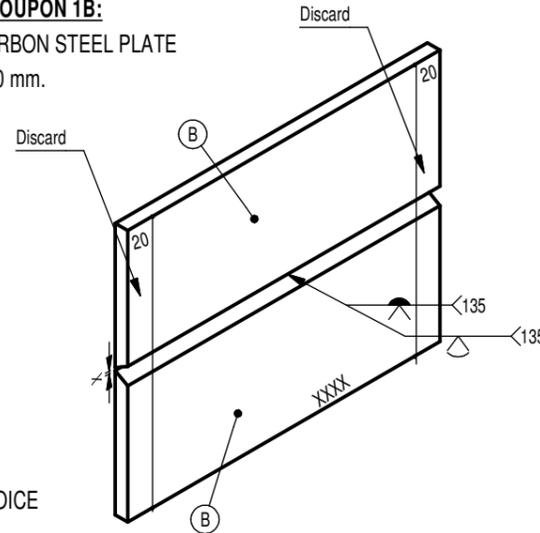
ROOT PASS: 141 GTAW  
FILL & CAP: 111 SMAW

**EVALUATION:**

1. VISUAL
2. X-RAY ENTIRE WELD JOINT

**TEST PLATE COUPON 1B:**

MATERIAL: CARBON STEEL PLATE  
THICKNESS: 10 mm.



X = YOUR CHOICE

**WELDING PROCESSES/POSITION: PC(2G)**

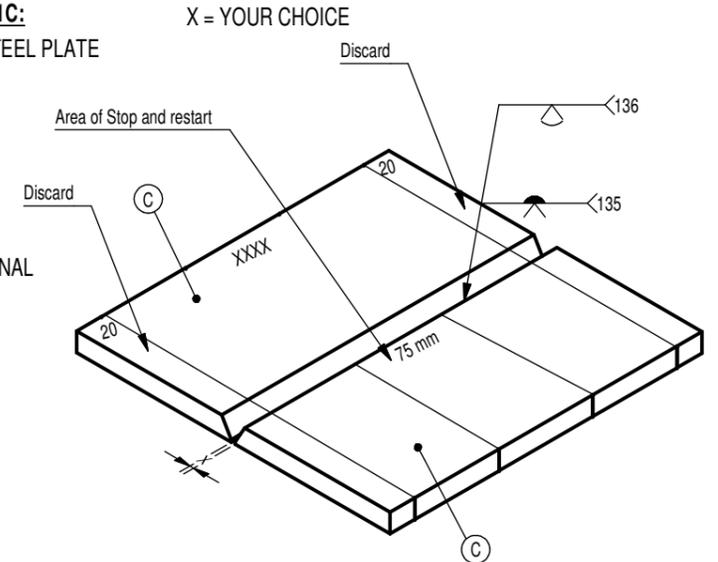
ROOT PASS: 135  
FILL & CAP: 135

**EVALUATION:**

1. VISUAL
2. X-RAY ENTIRE WELD JOINT

**TEST PLATE COUPON 1C:**

MATERIAL: CARBON STEEL PLATE  
THICKNESS: 16 mm.



**HOLD POINT**

AREA OF STOP AND RESTART IN ROOT & FINAL CAP PASS

**WELDING PROCESSES/POSITION: PA(1G)**

ROOT PASS: 135  
FILL & CAP: 136

**EVALUATION:**

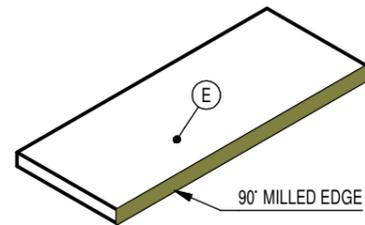
1. VISUAL
2. X-RAY ENTIRE WELD JOINT

**FILLET WELD COUPON-1:**

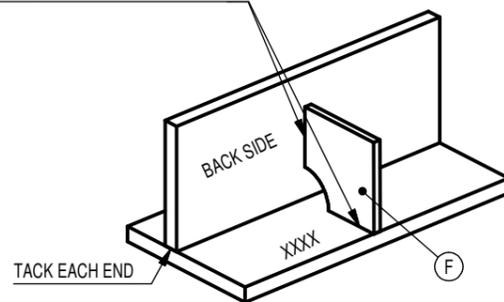
MATERIAL: CARBON STEEL PLATE  
THICKNESS: 12 mm  
WELDING PROCESS: 135  
WELDING POSITION: PF(3F)

**FILLET WELD COUPON-2:**

MATERIAL: CARBON STEEL PLATE  
THICKNESS: 12 mm  
WELDING PROCESS: 136  
WELDING POSITION: PB(2F)



TWO TACKS (MAX. 25 mm) IN ONE SIDE OF BRACKET

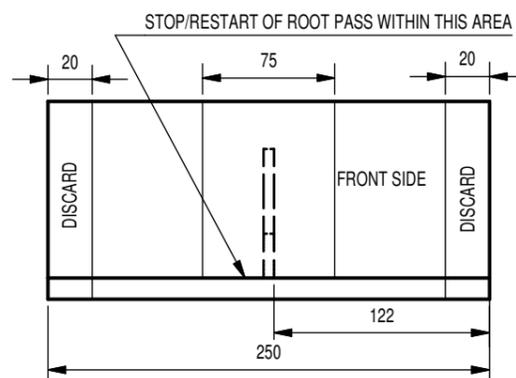
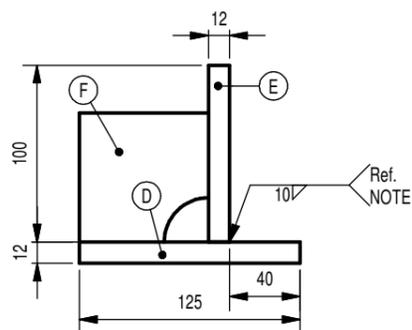


**NOTE:**

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 ARE ALLOWED.

**EVALUATION:**

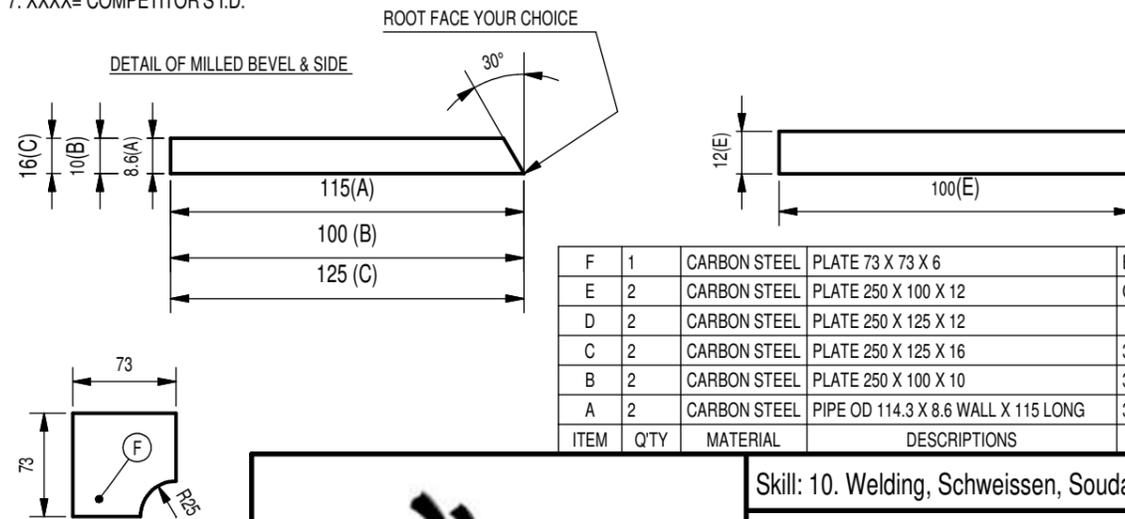
1. VISUAL
2. BREAK TEST



ALL DIMENSIONS IN MILLIMETRES  
BUT DO NOT SCALE DRAWING

**NOTE:**

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.



NTS = NOT TO SCALE

ITEM	Q'TY	MATERIAL	DESCRIPTIONS	REMARKS
F	1	CARBON STEEL	PLATE 73 X 73 X 6	BRACKET FOR TEMPORARY BACKING
E	2	CARBON STEEL	PLATE 250 X 100 X 12	ONE 90 deg. MILLED EDGE AS PER SKETCH
D	2	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 8.6 WALL X 115 LONG	30 deg. TURNED BEVEL



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Competition Special Edition 2022  
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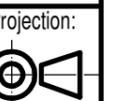
Skill: 10. Welding, Schweißen, Soudage

Designed by: Chih-Peng Chen TW

Last Update: 14.10.2022 Scale: NTS Paper: A3 Page:

Drawing Number: WSC 2022SE\_TP10\_TP\_ASS&SYMBOLS\_ISO A Rev: 02

Description: Module I--Test Coupons Assembly & Symbols Drawing



Drawn by: Chih-Peng Chen TW