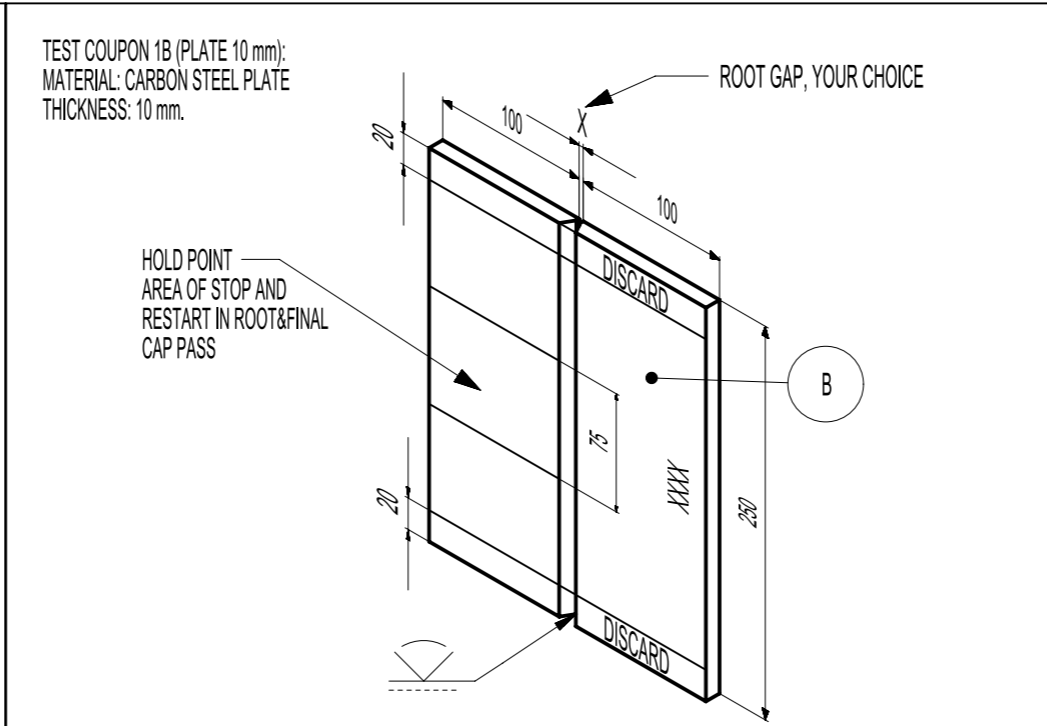


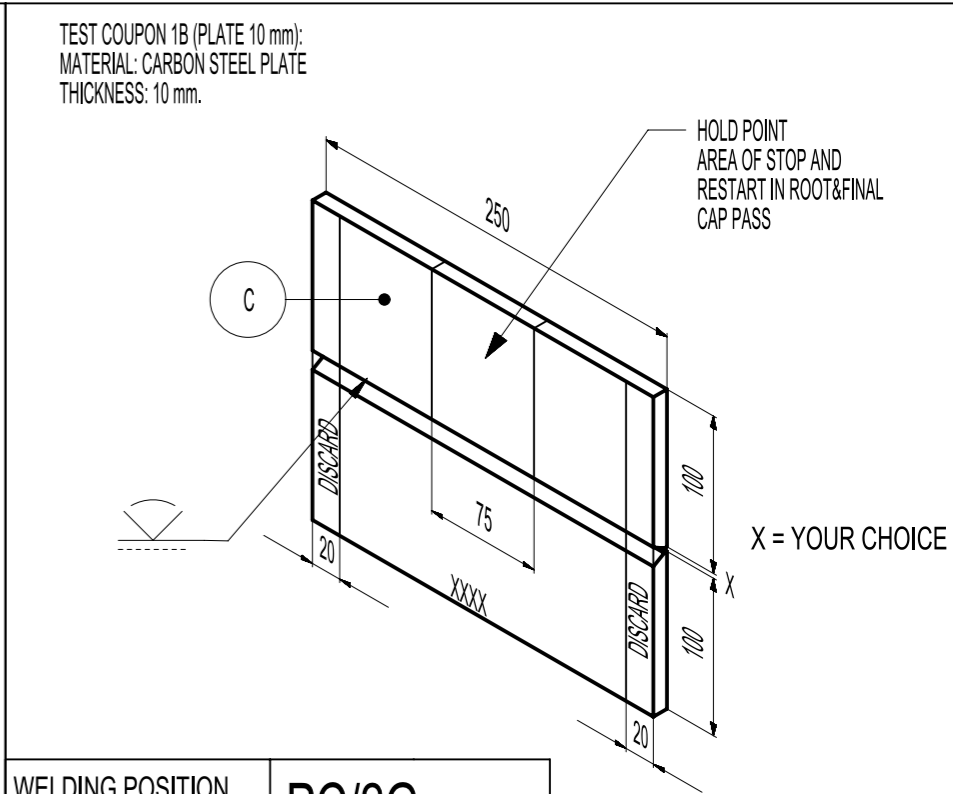
WELDING POSITION ISO 6947/AWS A3.0	H-LO45/6G	
WELDING PROCESSES ISO 4063 / AWS A3.0	ROOT PASS	(141)GTAW
	FILL& CAP	(111)MMAW

EVALUATION:
1. VISUAL
2. X-RAY ENTIRE WELD JOINT



WELDING POSITION ISO 6947/AWS A3.0	PF/3G	
WELDING PROCESSES ISO 4063 / AWS A3.0	ROOT PASS	(135)GMAW
	FILL& CAP	(135)GMAW

EVALUATION:
1. VISUAL
2. X-RAY ENTIRE WELD JOINT
3. BEND TEST

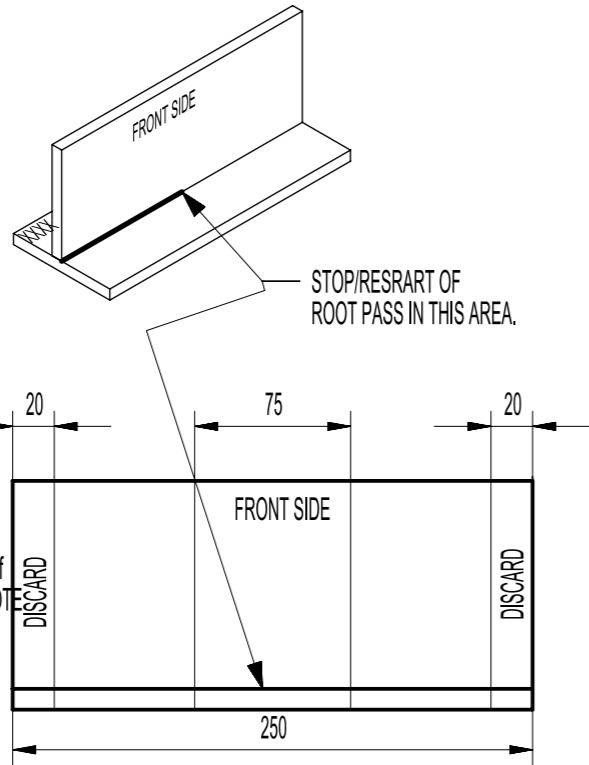


WELDING POSITION ISO 6947/AWS A3.0	PC/2G	
WELDING PROCESSES ISO 4063 / AWS A3.0	ROOT PASS	(111)MMAW
	FILL& CAP	(136)FCAW

EVALUATION:
1. VISUAL
2. X-RAY ENTIRE WELD JOINT

TEST COUPON 1D (FILLET WELD 10 mm):
MATERIAL: CARBON STEEL PLATE
THICKNESS: 10 mm.

NOTE:
1. EDGE PREPARATION MUST REMAIN AT 90~ TO THE PLATE FACE. NO CHAMFER AND NO GAP ALLOWED.
2. TACK WELD ON EACH END OF THE COUPON FRONT SIDE AND BACK SIDE TRACKING IS NOT ALLOWED
3. DEPOSIT A FILLET WELD ON THE FRONT SIDE OF THE JOINT WITH A 10 mm (+2.0/-0) mm LEG LENGTH. THE ROOT PASS SHALL STOP&RESTART WITHIN THE AREA SHOWN AS THE SKETCH.
4. WELD TO BE DEPOSITED WITH A MINIMUM OF 2 RUNS AND A MAXIMUM OF 3 RUN



FILLET WELD	COUPON- I
WELDING POSITION ISO 6947/AWS A3.0	PB/2F
WELDING PROCESSES ISO 4063 / AWS A3.0	(136)FCAW

EVALUATION:
1. VISUAL
2. FRACTURE TEST.

- NOTE:
1. ANY PROCESS AND ANY POSITION MAY BE USED FOR TACKWELDING.
2. ALL TACK WELDS EXCEPT TWO TACKS ON TEMPORARY BRACKET FOR FILLET COUPON ARE TO BE NOT LONGER THAN 15 mm.
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/OR 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.
8.TIME ALLOWANCE 6 HRS.

ALL DIMENSIONS IN MILLIMETRES
BUT DO NOT SCALE DRAWING

D	2	CARBON STELL	PLATE 250X100X10	ONE 90 deg.MILLED EDGE AS PER
C	2	CARBON STELL	PLATE 250X100X10	30 deg MILLED BEVEL
B	2	CARBON STELL	PLATE 250X100X10	30 deg MILLED BEVEL
A	2	CARBON STELL	PIPE Ø 168.2X 7.1 WALL X 125 LONG	30 deg TURNED BEVEL
ITEM	QTY	MATERIAL	DESCRIPTION	REMARKS

Test Project for the 28th NationSkills
Comperition in Thailand 2019



Skill:10, Welding	Projection ISO 5456-2	
Scale: N.T.S.	Date :	
Drawing by: P. Phanupong	Approve: W. Jirawat	
Description Module 1 Test Coupons (Plate//Pipe/Fillet):	Rev:00	Page: 1 of 1