

Note: When the I, L pre-assembled pipe fillet weldment and pressure vessel are combined, the surface bead must be left in its original state and must not be ground and repaired!

Precautions:

1. The combination spot welding of components can use any one of the four methods shown in the figure. Corner intersections allow continuous spot welding.
2. Auxiliary tools such as C-clamps or magnetic blocks can be used in combination spot welding, but they should be removed before formal welding.
3. Spot welding can only be performed on the outside of the container. I, L two plates and tubes are individually spot-welded into a group and sent to the referee for inspection. After stamping, they can be pre-welded in the specified welding position to complete the part scoring.
4. Pieces F, G, H, M, N, O are combined to form the upper cover. Welding can only be carried out after confirming spot welding with the pressure vessel body under the supervision of a referee.
5. Offenders' water pressure test is counted as zero points.
6. While welding is in progress, the weldment can only rotate around the Z axis or move up and down to perform welding and grinding according to the illustrated welding method. It must not be reversed. All PH tube welding termination points must be at 12 o'clock.
7. All fillets are 10mm (+ 2.0mm / -0 mm) in length unless otherwise specified.
8. Corner welds should be fillet welded (take a judgment score).
9. It is forbidden to use anti-spatter during the welding process. After the welding is completed, all bead surfaces and end surfaces shall not be cleaned with a grinding wheel, except with a steel brush. Abrasive paper, file, or other method sufficient to change the topography of the bead surface.
10. After the spot welding cap is inspected by the referee, no spot welding operation can be performed any more. The water pressure test of the offender is counted as zero.
11. Time allowance 9 hrs.


ALL DIMENSIONS IN MM

WELDING PROCESSES

ISO 4063	AWS A3.0
111	MMAW
135	GMAW
136	FCAW-G
141	GTAW

Test Project for the 28th NationSkills
Competition in Thailand 2019



Skill:10, Welding			Projection		
Scale N.T.S.	Date :	Paper :A3	ISO 5456-2		
Drawing by: P.Phanupong		Approve: W. Jirawat		Drawing No.TP10_28NSC DAY2_GENERIC	
Description:Pressure Vessel - Part List Assambly 2			Rev:00		Page: