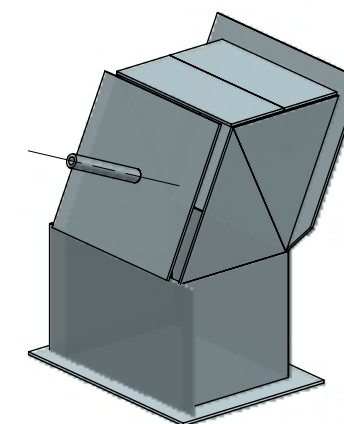
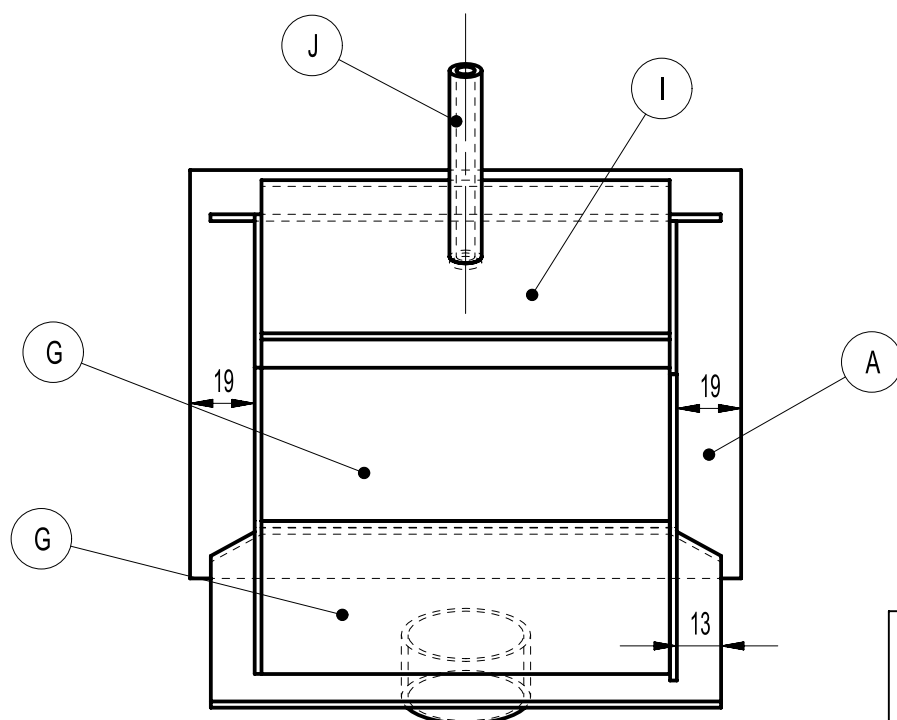
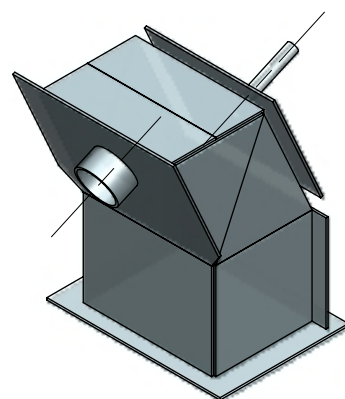


Note: I, J for purging only and to be removed after welding




Warning

1. After joining the welding point at any position as shown, use argon welding (141, GTAW) for welding.
2. Can be welded by A-plate as the bottom plate and rotated around the vertical axis (Z axis). They must not be reversed. The vertical welding must be in the welding position PF / PH (pipe).
3. Butt and corner welding requires back drilling and does not need to penetrate the back.
4. Welding of parts by purging. Welding of pieces I, J will return to blow the first two spot welding equipment. Take out with the components for inspection by the judges. You can use adhesive tape or welding points and temporarily weld the welding parts when you actually do the welding. However, a single solder joint cannot be greater than 10 mm.
5. Welding rod length 3 mm (tolerance 1 mm / -0 mm)
6. Welding angle (welding angle) must be a full angle. (Use points to decide)
7. Except that the sheet can be treated before welding first, after welding, the surface including beads and metal bases should be kept as welded. Do not use any cloth and sandpaper to wipe and brush, iron wheel or file to cut.
8. After submitting the combined spot welding for inspection and printing, it must not be disassembled, then the spot welding or spot welding is removed by grinding machine (except for the pieces I and J).
9. Only one welding bead must be used for every welding bead and will not allow secondary welding again. The offender is counted to zero.
9. Time allowance 2.5 hrs.

ALL DIMENSIONS IN MM

Test Project for the 28th NationSkills
Competition in Thailand 2019



Skill:10, Welding			Projection ISO 5456-2	
Scale .N.T.S.	Date :	Paper :A3		
Drawing by: P. Phanupong		Approve: W. Jirawat	Drawing No.TP10_28NSC DAY2_GENERIC	
Description:Stainless steel Strue-Assembly			Rev:00	Page: