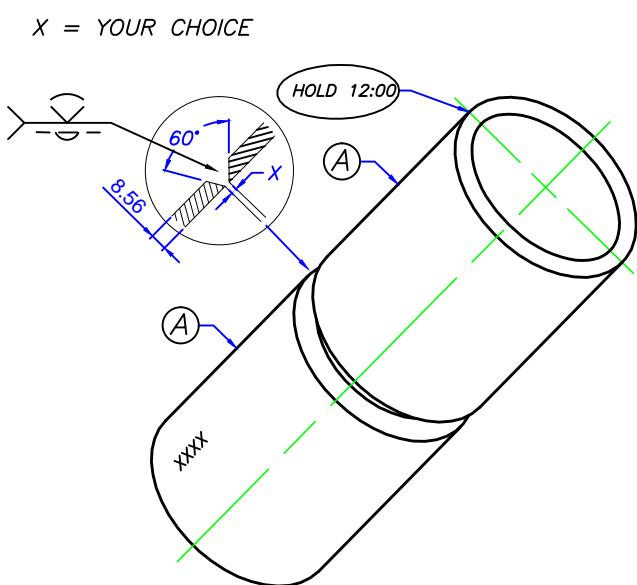


A

A

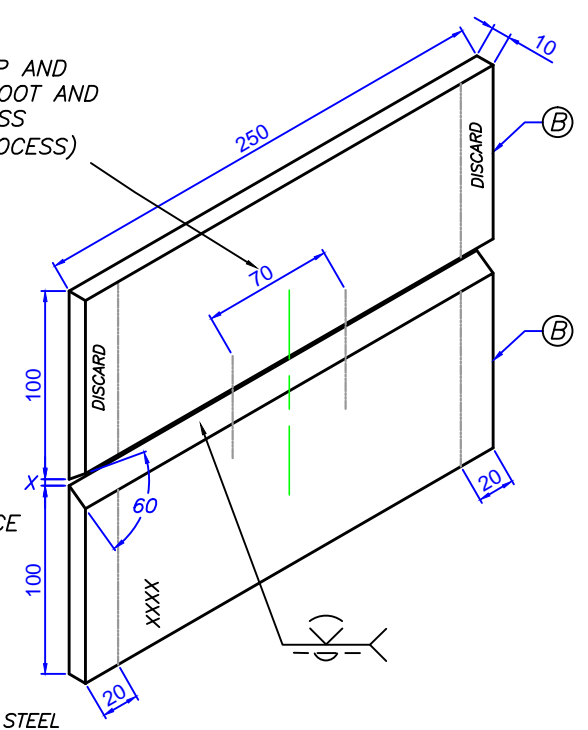


**TEST PIPE 1A:**  
 MATERIAL: CARBON STEEL PIPE  
 2 PCS @ 114.3 OD x 8.56 WALL x 120 LONG

ASSESSMENT:  
 VISUAL and X-RAY TEST

WELDING POSITION: \_\_\_\_\_  
 ROOT PASS: \_\_\_\_\_  
 FILL and CAP: \_\_\_\_\_

**HOLD POINT**  
 AREA OF STOP AND RESTART IN ROOT AND FINAL CAP PASS (FOR MAG PROCESS)



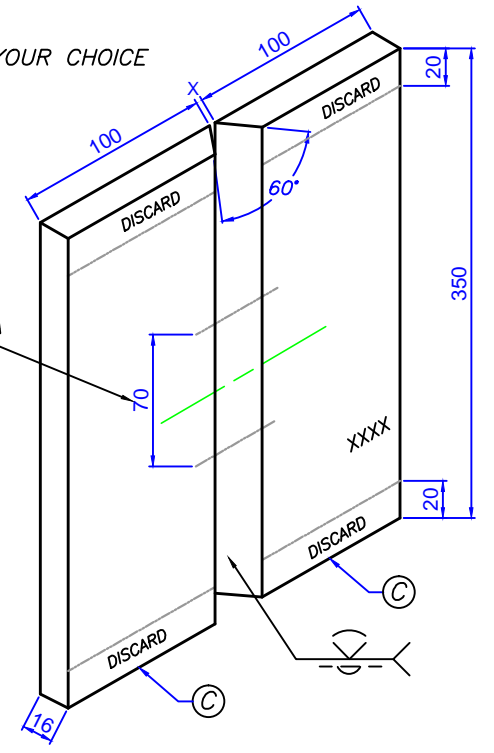
**TEST PLATE 1B:**  
 MATERIAL: CARBON STEEL  
 THICKNESS: 10mm

ASSESSMENT:  
 VISUAL and X-RAY TEST  
 (DISCARD 20mm OF EACH END)

WELDING POSITION: \_\_\_\_\_  
 ROOT PASS: \_\_\_\_\_  
 FILL and CAP: \_\_\_\_\_

X=YOUR CHOICE

**HOLD POINT**  
 AREA OF STOP AND RESTART IN FINAL CAP PASS  
 MAG ALSO REQUIRES A STOP/RESTART IN ROOT



**TEST PLATE 1C:**  
 MATERIAL: CARBON STEEL  
 THICKNESS: 16mm

ASSESSMENT:  
 VISUAL and X-RAY TEST  
 (DISCARD 20mm OF EACH END)

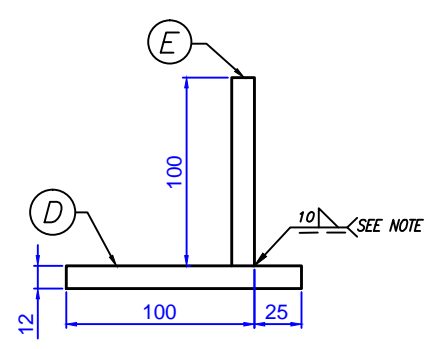
WELDING POSITION: \_\_\_\_\_  
 ROOT PASS: \_\_\_\_\_  
 FILL and CAP: \_\_\_\_\_

C

C

D

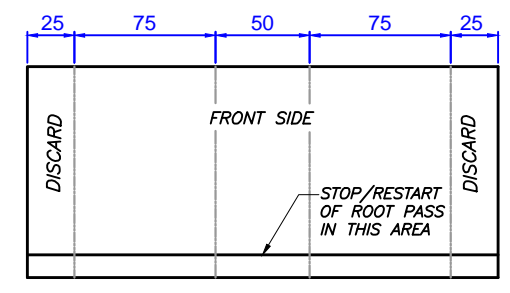
D



**TEST PLATE 1D:**  
 MATERIAL: CARBON STEEL  
 THICKNESS: 12mm

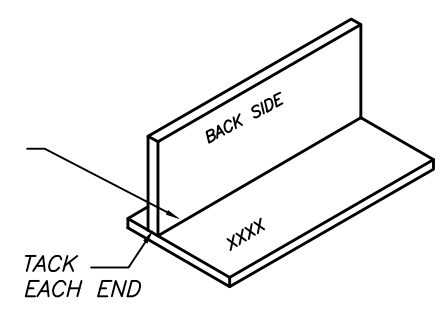
WELDING POSITION: \_\_\_\_\_  
 PROCESS: \_\_\_\_\_

ASSESSMENT:  
 VISUAL and BREAK TEST  
 (DISCARD 25mm OF EACH END)



**NOTE:**  
 -DEPOSIT A FILLET WELD ON THE FRONT SIDE OF THE JOINT WITH 10mm -0/+2 LEG LENGTH.  
 -WELD TO BE DEPOSITED WITH A MINIMUM OF 2 RUNS AND A MAXIMUM OF 3 RUNS.  
 -EDGE PREPARATION MUST REMAIN AT 90° TO THE PLATE FACE. NO GAP ALLOWED.

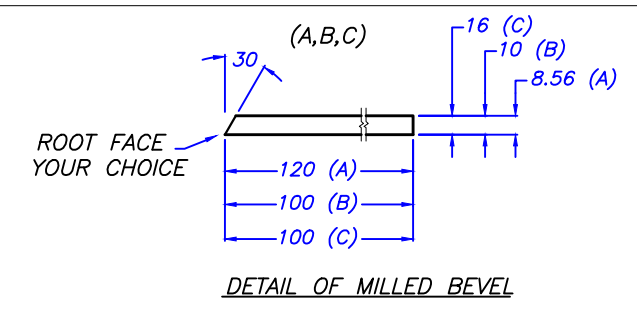
TACK WITH 25mm LENGTH MAXIMUM



**NOTES:**

1. ANY PROCESS AND ANY POSITION MAY BE USED FOR TACKWELDING.
2. MAXIMUM LENGTH OF TACKS: 15mm
3. ALL PLATES OR PIPES ARE TO BE TACKWELDED BEFORE ANY WELDING COMMENCES.
4. TEST PLATES OR PIPES MUST BE WELDED IN THE POSITION AS INDICATED FOR EACH TEST.
5. PROCESS INDICATED FOR ROOT WELD TO BE USED ONLY FOR ONE RUN, NOT FOR SECOND AND SUBSEQUENT PASSES.
6. NO GRINDING OR FINISHING OF ANY KIND AFTER WELDING IS COMPLETED.
7. XXXX = CONTESTANT'S I.D.

DO NOT SCALE DRAWING



ALL MATERIAL CARBON STEEL (CS) and ALL DIMENSIONS IN MILLIMETRES

Item	Qty.	Material	Description	Notes
E	1	CS	Plate 12 x 100 x 250	
D	1	CS	Plate 12 x 125 x 250	
C	2	CS	Plate 16 x 100 x 350	MILLED BEVEL
B	2	CS	Plate 10 x 100 x 250	MILLED BEVEL
A	2	CS	Pipe x Ø114.3 x 8.56 wall x 120	MILLED BEVEL

Test Project for 4th EuroSkills Competition in Lille, France 2014.  
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F

F

Skill:10 - WELDING			ISO E	
Scale:	Date: June 2014	Paper: A 3		
Drawn by: Álvaro Santos			Drawing No: ES2014_TP10_M1wp_A3	
Description: M 1 - TEST PLATES / PIPE welding plan			Rev: 0	Page: 1 of 1