



INSTRUCTIONS TO COMPETITORS:

- Tack welds shall be maximum 15 mm on the structure outside only
- Welding process: 141 – TIG
- Complete all welding with base A in the flat position
- Cleaning, grinding, wire brushing or quimical cleaning is NOT permitted after the welds. The structure shall be presented in the "weld condition"
- All fillet welds are to be a leg size 4 (- 0 /+2)
- All corner welds are to be radius 3 (-1 / +1)

ALL DIMENSIONS IN MILLIMETERS

ITEM	QUANT.	MATERIAL	DIMENSIONS	REMARKS
J	1	Pipe of Aluminium N° 5052	∅ 60 x 50 x 3	
I	1	Plate of Aluminium N° 5052	120 x 100 x 3	
H	1	Plate of Aluminium N° 5052	150 x 85 x 3	
G	1	Plate of Aluminium N° 5052	150 x 60 x 3	
F	1	Plate of Aluminium N° 5052	120 x 90 x 3	See drawing
E	1	Plate of Aluminium N° 5052	120 x 60 x 3	
D	1	Plate of Aluminium N° 5052	150 x 60 x 3	
C	1	Plate of Aluminium N° 5052	150 x 60 x 3	See drawing
B	1	Plate of Aluminium N° 5052	120 x 75 x 3	
A	1	Plate of Aluminium N° 5052	145 x 145 x 3	

Test Project for 4 EuroSkills
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Skill:10 - WELDING

Scale: 1:2.5 | Date: June 2014 | Paper: A 3

ISO E

Drawn / Design by: Álvaro Santos | Drawing No: ES2014_TP10_PT_M3_A3

Description: M 3 - ALUMINIUM STRUCTURE | Rev: 0 | Page: 1 of 1