



ITEM	QUANT.	MATERIAL	DIMENSIONS	REMARKS
L	1	Plate of stainless steel AISI 304	120 x 87,4 x 2	Hole ϕ 10 centered – purge plate
J	1	Pipe of stainless steel AISI 304	ϕ 60 x 50 x 2	
I	1	Plate of stainless steel AISI 304	120 x 100 x 3	
H	1	Plate of stainless steel AISI 304	150 x 85 x 2	
G	1	Plate of stainless steel AISI 304	150 x 60 x 2	
F	1	Plate of stainless steel AISI 304	120 x 90 x 2	See drawing
E	1	Plate of stainless steel AISI 304	120 x 60 x 2	
D	1	Plate of stainless steel AISI 304	150 x 60 x 2	
C	1	Plate of stainless steel AISI 304	150 x 60 x 2	See drawing
B	1	Plate of stainless steel AISI 304	120 x 75 x 2	
A	1	Plate of stainless steel AISI 304	145 x 145 x 2	

INSTRUCTIONS TO COMPETITORS:

- Tack welds and welding process: TIG-141
- Complete all welding with base A in the flat position
- All butt and corner joints should have full penetration
- Cleaning, grinding, wire brushing or quimical cleaning is NOT permitted after the welds. The structure shall be presented in the "weld condition"
- All fillet leg size: 3 (-0/+1)
- Outside corner weld radius: 2 (-1+1)
- ① - The purge plate L should be tacked only. Not welded, It shall be removed after the welding of the structure is finished

ALL DIMENSIONS IN MILIMETERS

Test Project for 4 EuroSkills
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Skill:10 - WELDING			ISO E
Scale: 1:2.5	Date: June 2014	Paper: A 3	
Drawn / Design by: Álvaro Santos			Drawing No: ES2014_TP10_PT_M4_A3
Description: M 4 - STAINLESS STEEL STRUCTURE			Rev: 0 Page: 1 of 1