

M	1	OD 60X25X3.0, AA 5154 ALUMINIUM PIPE
L	1	200X120X3.0, AA 5154 ALUMINIUM SHEET
K	1	160X105.56X3.0, AA 5154 ALUMINIUM SHEET
J	1	160X48.76X3.0, AA 5154 ALUMINIUM SHEET
I	1	160X56.26X3.0, AA 5154 ALUMINIUM SHEET
H	1	160X45.56X3.0, AA 5154 ALUMINIUM SHEET
G	1	160X60X3.0, AA 5154 ALUMINIUM SHEET
F	2	140X80X3.0, AA 5154 ALUMINIUM SHEET
E	2	100X50X3.0, AA 5154 ALUMINIUM SHEET
D	2	131.21X110X60.5X3.0, AA 5154 ALUMINIUM SHEET, AS PER SKETCH
C	2	110X110X3.0 AA 5154 ALUMINIUM SHEET, TRIANGLE, AS PER SKETCH
B	2	110X60X3.0 AA 5154 ALUMINIUM SHEET
A	1	200X130X3.0, AA 5154 ALUMINIUM SHEET
Item.	Q'ty	Descriptions

INSTRUCTIONS TO COMPETITORS

1. WELDING PROCESS:ISO 4063-141 (AWS A3.0 GTAW)
2. WELDING POSITIONS: ALL EXCEPT VERTICAL DOWN.
3. NO GAPS ARE ALLOWED ON THE BUTT & CORNER WELD JOINTS.
4. ALL BUTT & CORNER WELDS SHALL HAVE FULL PENETRATIONS.
5. ALL THE WELDING TO BE CARRIED OUT WITH BASE PLATE "A" IN THE FLAT POSITION.
6. ALL LEG SIZES OF FILLET WELDS: 4.0 mm WITH TOLERANCE (+2.0 mm/-0.0 mm).
7. OUTSIDE CORNER WELD RADII TO BE JUDGEMENT ASSESSED WITH GRADE (0,1,2,3).
8. ALL WELDS SHALL BE COMPLETED IN ONLY ONE PASS WITH FILLER ROD ADDED.
9. NO PENETRATION AND REINFORCEMENT OF WELD TO BE MEASURED BETWEEN ITEM I&J.

NOTE: ALL DIMENSTIONS IN MILLIMETRE

Test Project for the 45th WorldSkills
Competition in Kazan, Russia 2019.
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Skill: 10. Сварочные технологии, Welding, Schweißen, Soudage

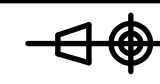
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Drawn/Designed by: Chih-Peng Chen TW/ Kamyar Sadeghi IR

Description: Aluminium-Assembly



OR



Drawing No:WSC2019_TP10_IR_AL_ASSEMBLY_ISO E

Rev: 3

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