

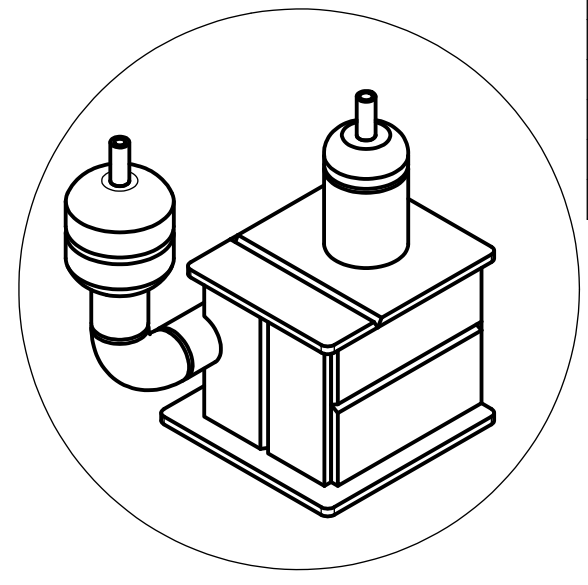
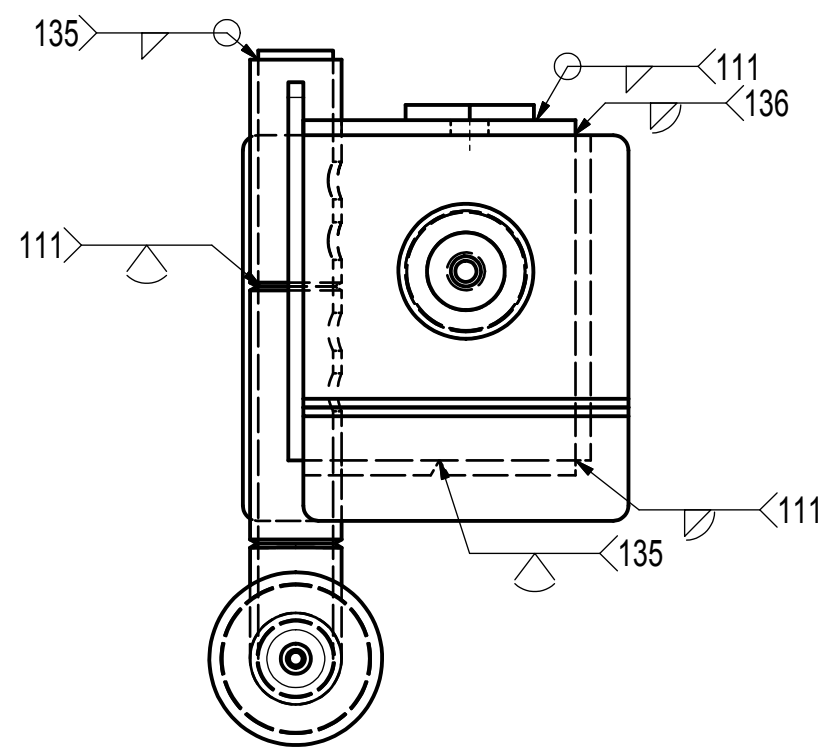
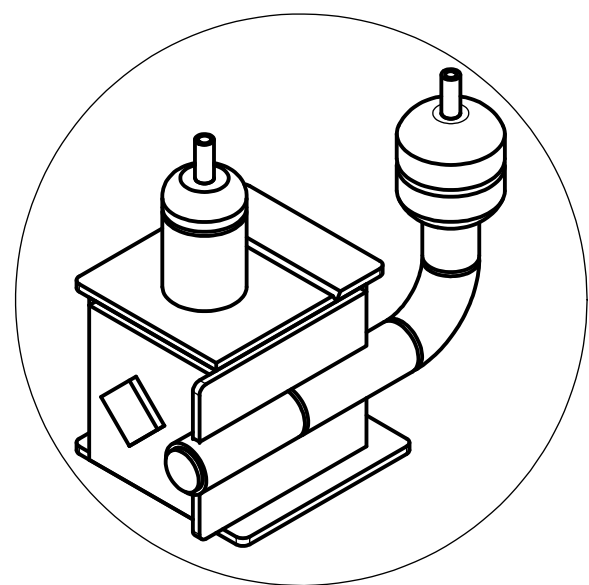
1 2 3 4 5 6

A

B

C

D



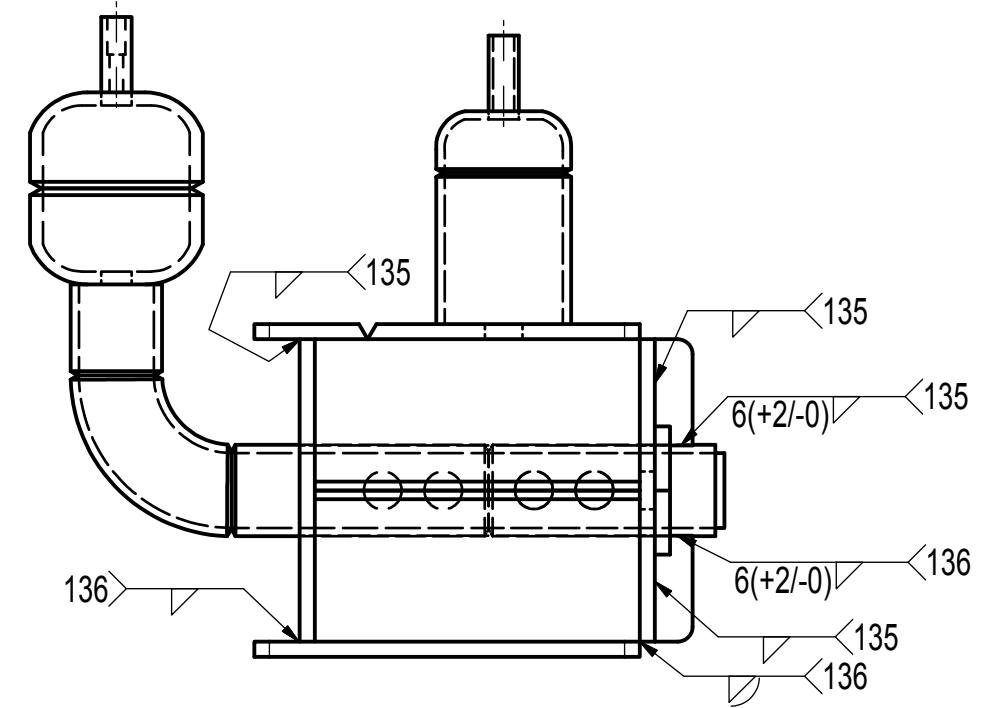
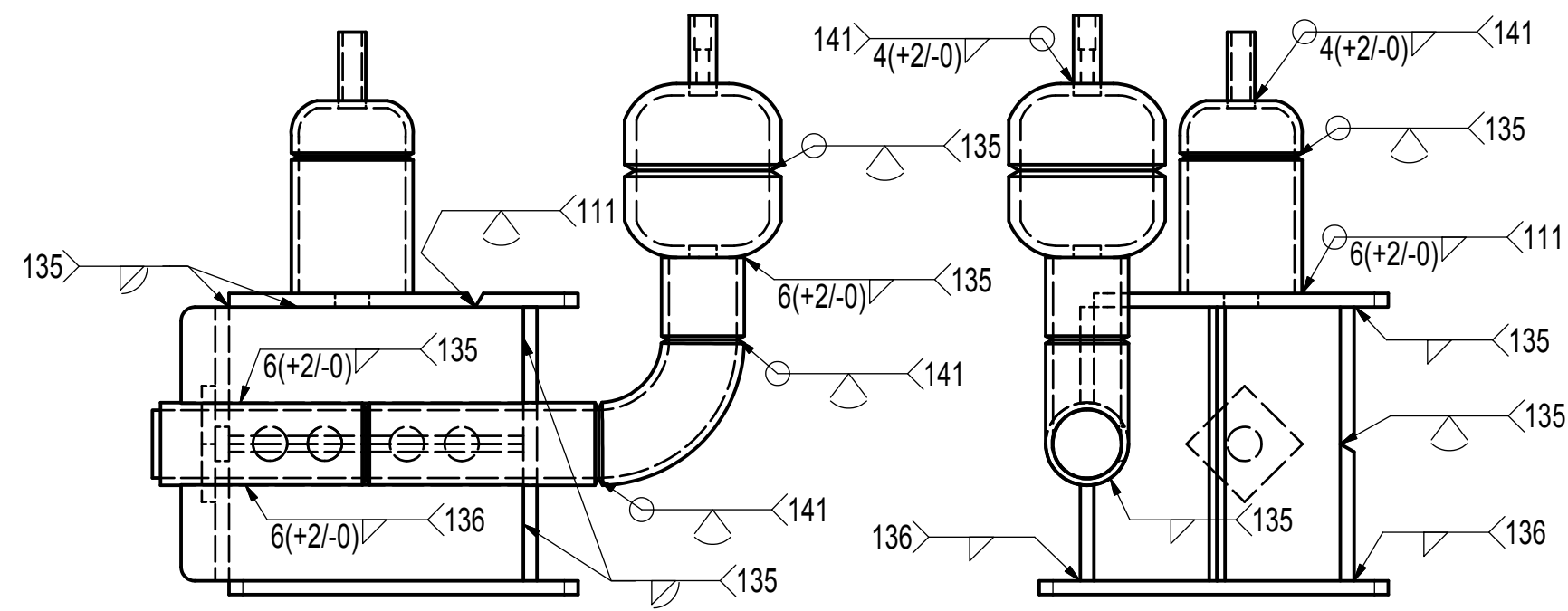
WELDING PROCESSES	
ISO 4063	AWS A3.0
111	SMAW
135	GMAW
136	FCAW-G
141	GTAW

A

B

C

D



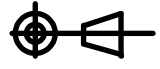

INSTRUCTIONS :

- 1.TACK WELDS CAN BE MADE IN ANY POSITION WITH ANY PROCESS IN THE MOST LOGICAL SEQUENCE FOR STRUCTURAL SQUARENESS AND JOINT ACCESS.
- 2.ALL TACK WELDS ARE TO BE MADE NO LONGER THAN 15 mm AND PLACED ONLY ON THE OUTSIDE OF THE VESSEL.
- 3.ALL WELDS ARE TO BE MADE AS INDICATED ON DRAWING.
- 4.ALL LEG LENGTH OF FILLET WELDS EXCEPT SPECIAL NOTES ARE TO BE 10 mm (+2mm/-0mm).
- 5.COMPLETE ALL WELDING WITH BASE "A" IN THE FLAT POSITION.
- 6.GRINDING WILL BE LIMITED TO : TACK WELDS , STARTS, STOPS AND ROOT PASS.
- 7.POST CLEANING : WIRE BRUSH ONLY AFTER SLAG REMOVAL, NO GRINDING.

NOTE: ALL DIMENSTIONS IN MILLIMETRE

Test Project for the 45th WorldSkills
Competition in Kazan, Russia 2019.
Copyright © 2019 WorldSkills International.
All Rights Reserved.



Skill: 10. Сварочные технологии, Welding, Schweißen, Soudage			 OR 
Scale: N. T. S	Date: 18. Aug. 2019	Paper: A3	
Drawn/Designed by: Chih-Peng Chen TW			Drawing No: WSC2019_TP10_TW_PV_SYMBOLS_ISO A
Description: Pressure Vessel-SYMBOLS			Rev: 04
			Page:
			Appd:
			Sign:

1 2 3 4 5 6