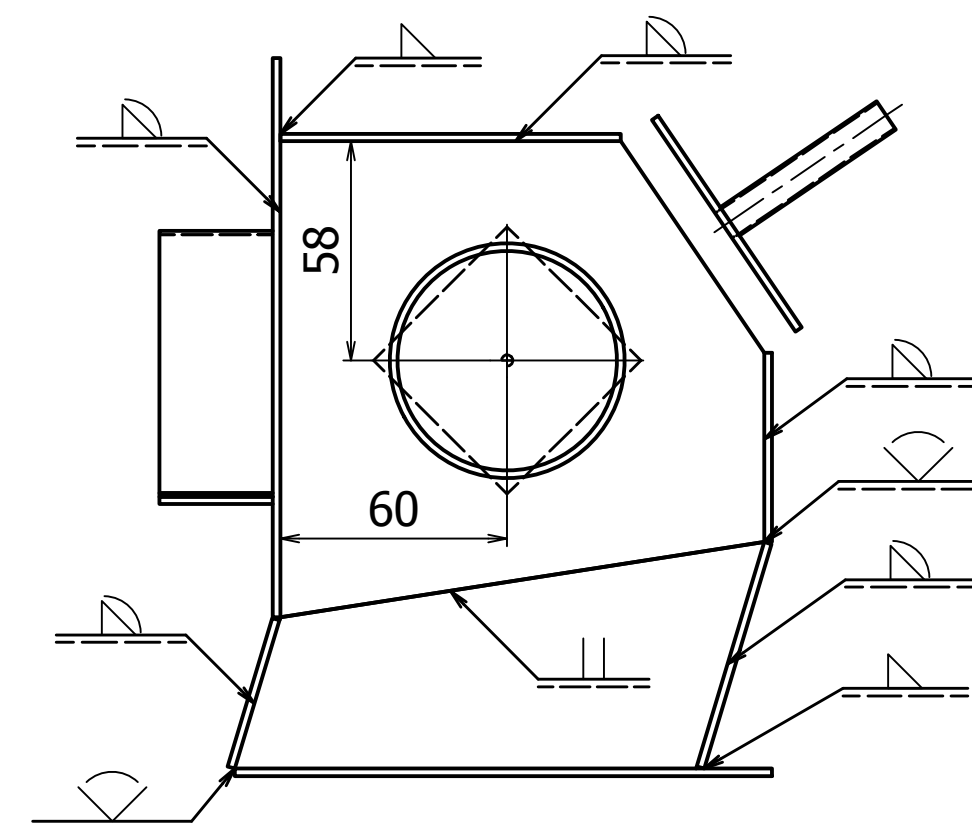
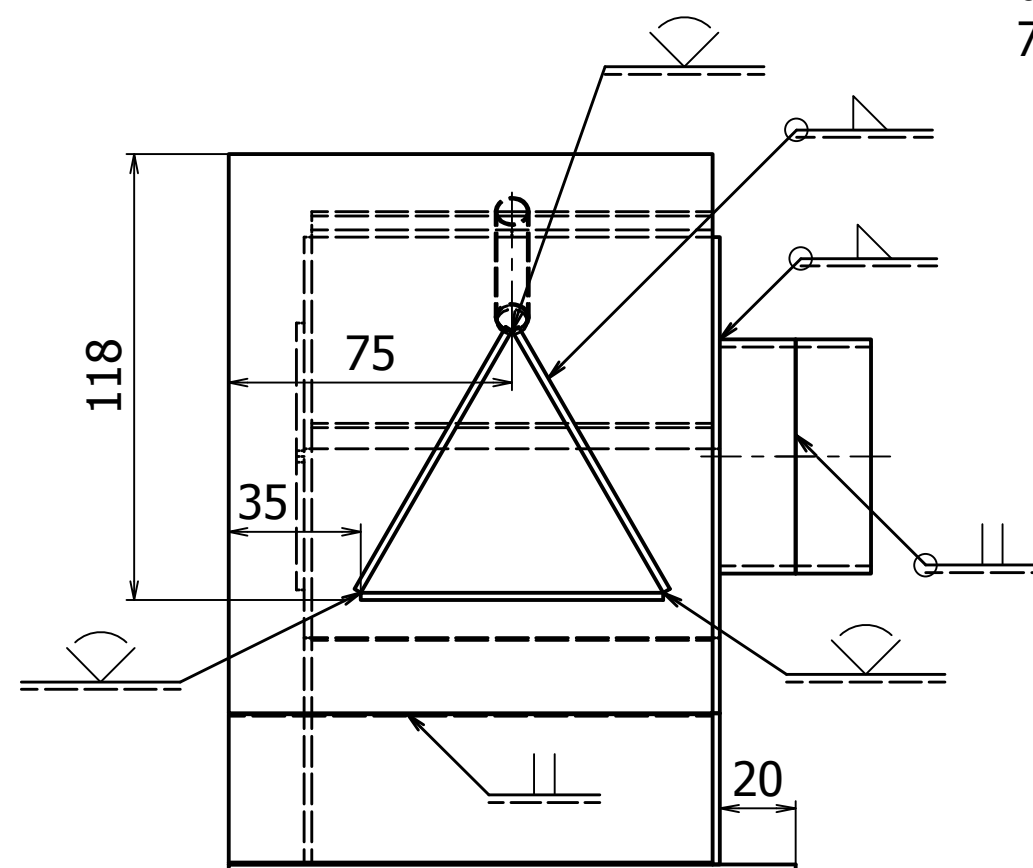
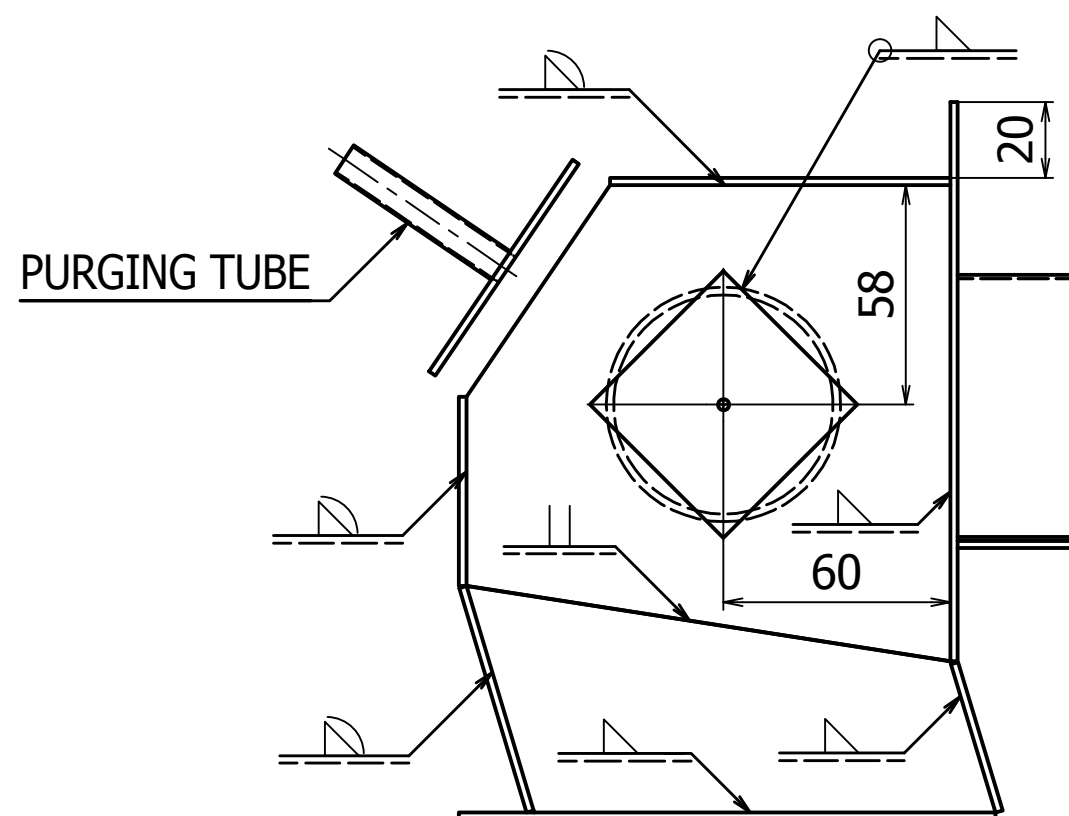


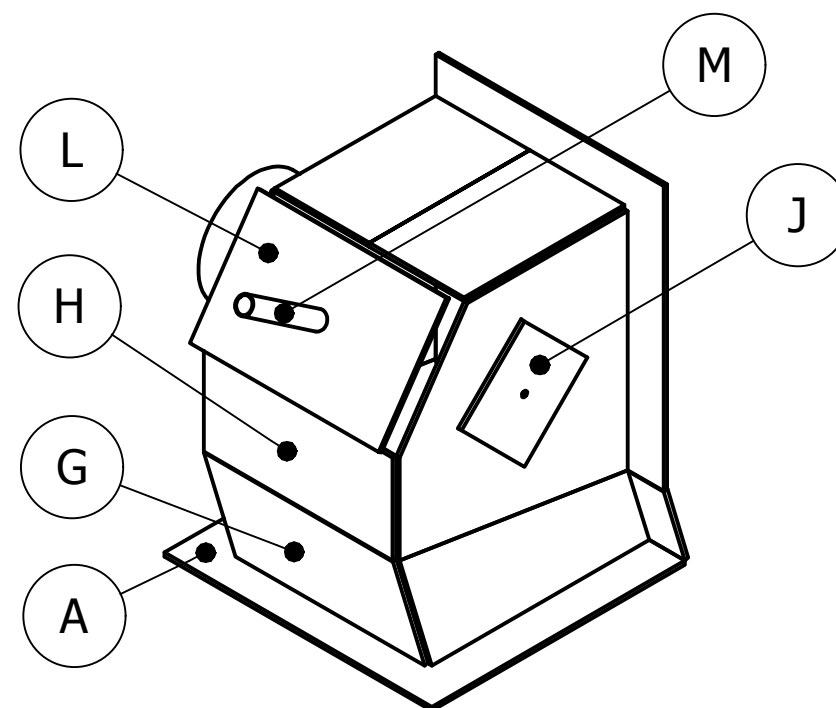
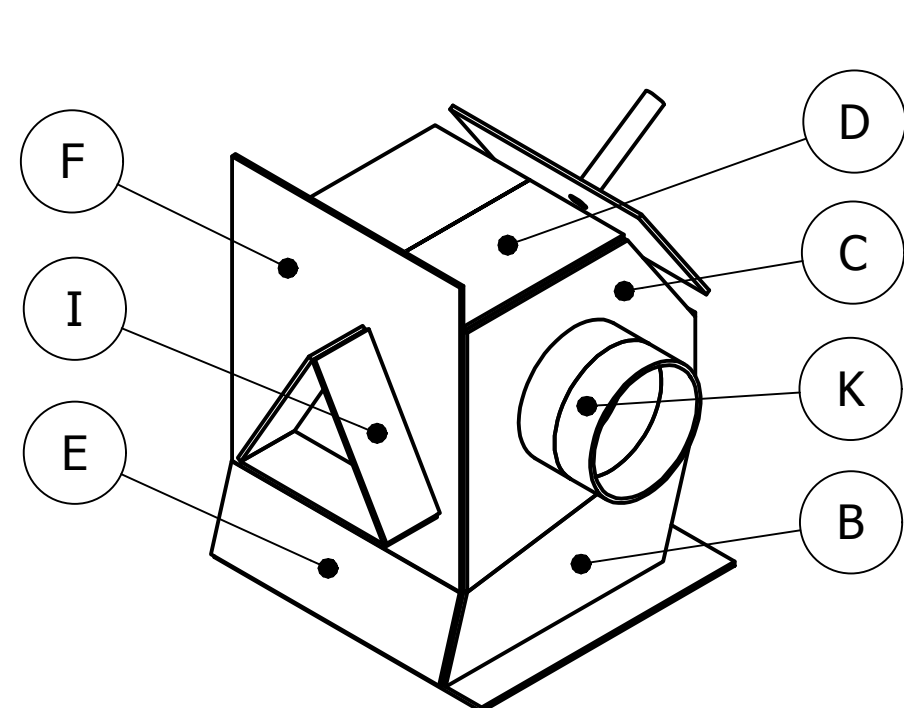
ITEM	QTY	MATERIAL	DIMENSIONS	REMARKS
A	2	AISI 304	Plate 150X142X2.0	
B	2	AISI 304	Plate 122X60X2.0 as per sketch	
C	1	AISI 304	Plate 128X126X2.0 as per sketch	
D	1	AISI 304	Plate 90X53X2.0	
E	2	AISI 304	Plate 128X41X2.0	
F	1	AISI 304	Plate 148X128X2.0	
G	1	AISI 304	Plate 106X62X2.0	
H	2	AISI 304	Plate 106X50X2.0	
I	3	AISI 304	Plate 80X30X2.0	
J	1	AISI 304	Plate 50X50X2.0	φ3mm hole in center
K	2	AISI 304	Tube OD 62X20X2.0	
L	1	AISI 304	Plate 106X67.6X2.0 purging Plate	φ8mm hole in center
M	1	AISI 304	Tube OD 9X50X0.5 purging Tube	

INSTRUCTIONS :

1. WELDING PROCESS : GTAW(TIG)141.
2. PURGE PLATE TACKED IN PLACE AND REMOVE AFTER COMPLETE WELDING.
3. WELDING POSITIONS : ALL EXCEPT VERTICAL DOWN.
4. COMPLETE ALL WELDING WITH BASE : "A" IN THE FLAT POSITION.
5. ALL FILLET LEG LENGTHS : 3mm (+1mm/-0mm).
6. OUTSIDE CORNER WELD RADII : 2mm (+1mm/-0mm).
7. NO FINISHING OF ANY KIND AFTER WELDING.



ALL DIMENSIONS IN MILLIMETERS



Test Project for the 45th WorldSkills
Competition in Kazan, Russia 2019.
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Skill: Weiding

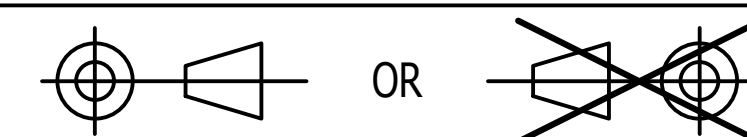
Scale: N. T. S

Date: 11/07/2017

Paper: A3

Drawn / Design by: Shoki Yasuda JP

Description: Stainless Steel-Assembly & Symbols



Drawing No: WSC2019_TP10_JP_SS-US_ISO A

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