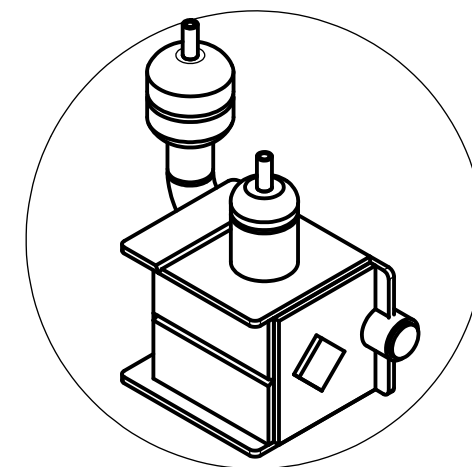
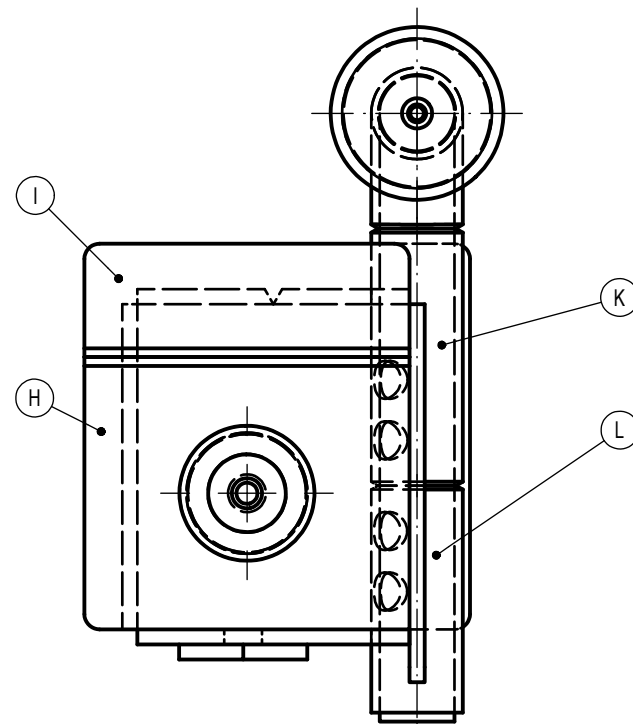
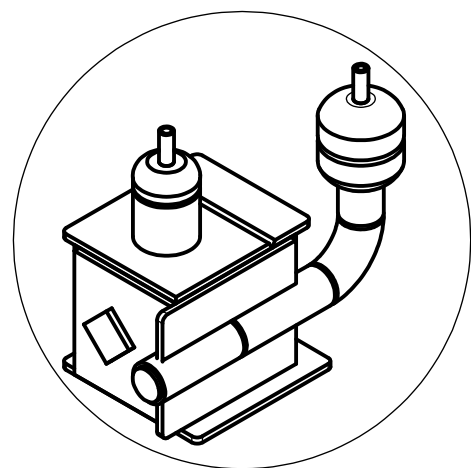
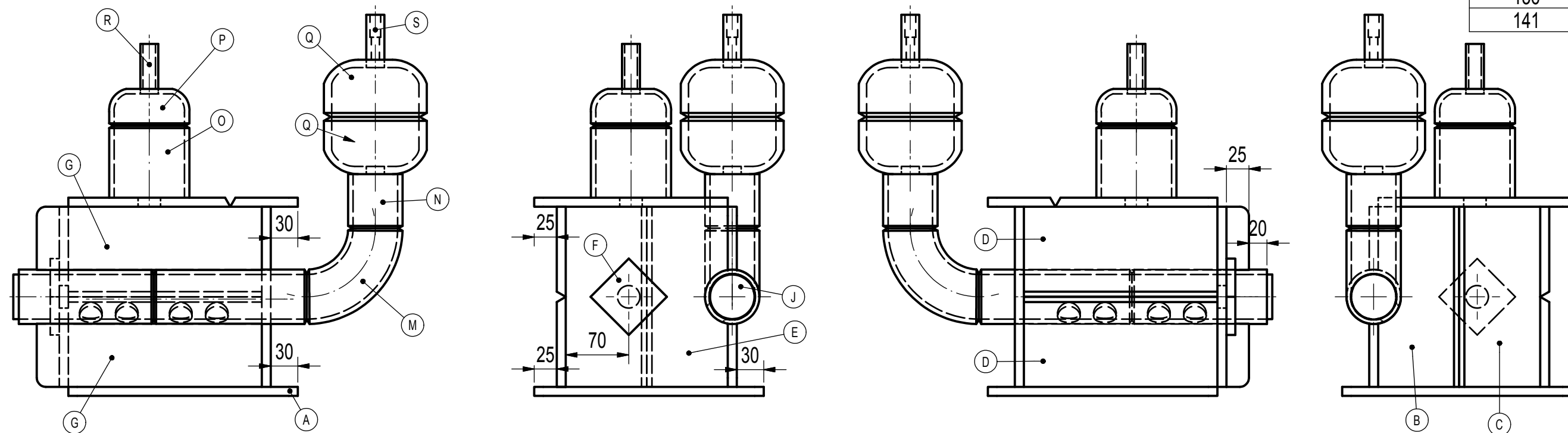


WELDING PROCESSES	
ISO 4063	AWS A3.0
111	SMAW
135	GMAW
136	FCAW-G
141	GTAW





# 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 SHORTER THAN 15 mm AND PLACED ON THE OUTSIDE OF THE VESSEL ONLY.
- 3.ALL WELDS ARE TO BE MADE AS INDICATED ON DRAWING.
- 4.ALL FILLET WELDS EXCEPT SPECIAL NOTES ARE TO BE 10 mm (+2mm/-0mm) IN LEG LENGTH.
- 5.COMPLETE ALL WELDING WITH BASE "A" IN THE FLAT POSITION.
- 6.GRINDING WILL BE LIMITED TO : TACK WELDS , STARTS , STOPS , ROOT PASS , FACE AND TOES.
- 7.POST CLEANING : WIRE BRUSH ONLY AFTER SLAG REMOVAL , NO GRINDING.

NOTE: ALL DIMENSTIONS IN MILLIMETRE

Test Project for the 45<sup>th</sup> WorldSkills  
Competition in Kazan, Russia 2019.  
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Skill: 10. Сварочные технологии, Welding, Schweißen, Soudage				OR	
Scale: N. T. S	Date: 27. Aug. 2017	Paper: A3			
Drawn/Designed by: Chih-Peng Chen TW			Drawing No:WSC2019_TP10_TW_PV_ASSEMBLY_ISO E		
Description: Pressure Vessel-Assembly			Rev:		Page:
			Appd:		Sign: