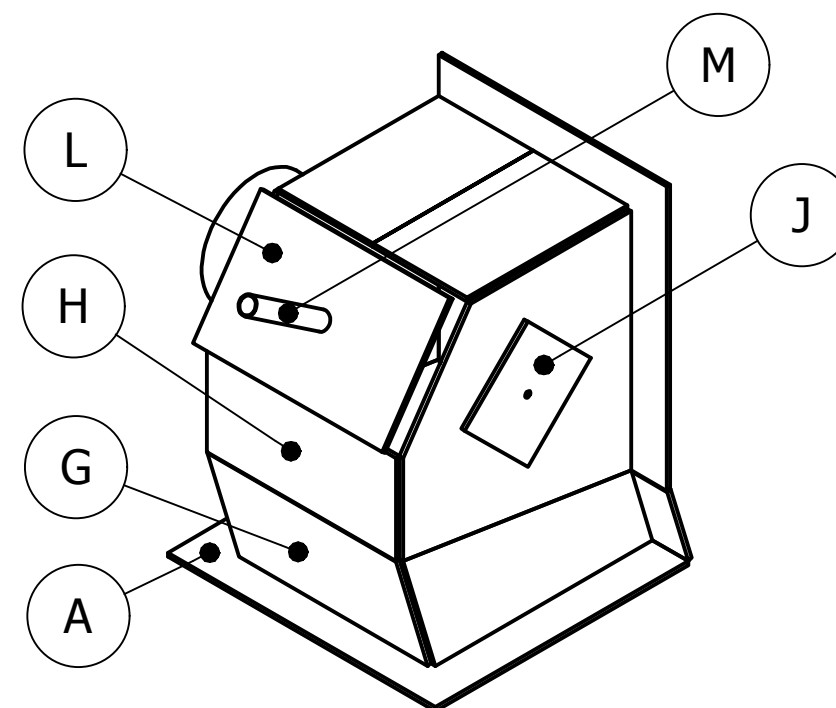
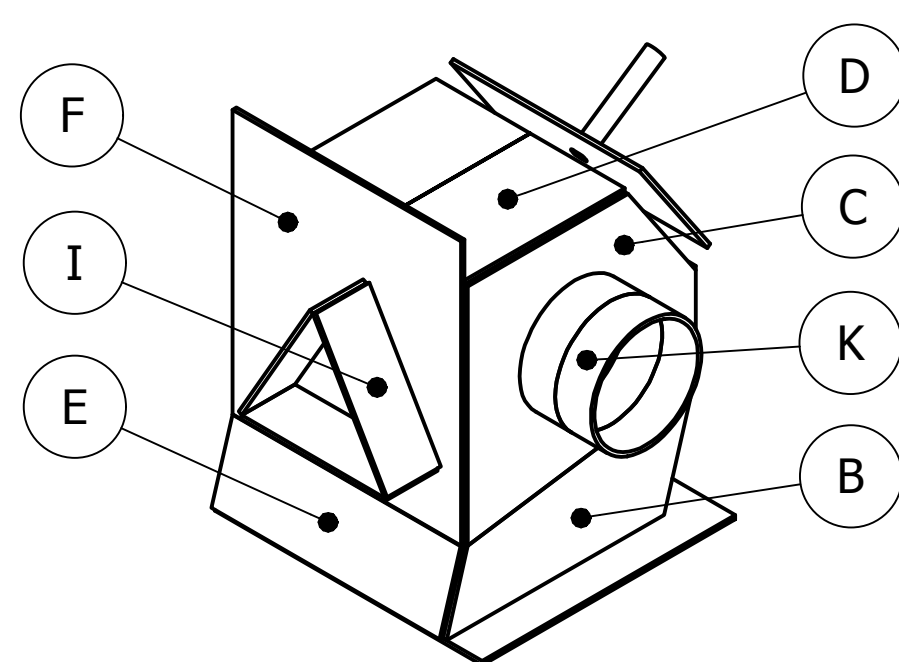


ALL DIMENSIONS IN MILLIMETERS

#### 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.

| 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    |                     |



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



Skill: Weiding

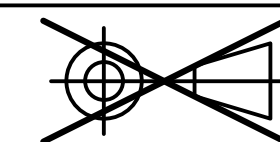
Scale: N. T. S

Date: 11/07/2017

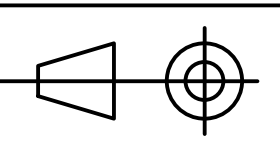
Paper: A3

Drawn / Design by: Shoki Yasuda JP

Description: Stainless Steel-Assembly & Symbols



OR



Drawing No: WSC2019\_TP10\_JP\_SS\_PV\_ISO E

Rev:

Page: 1 of 1