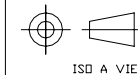


ITEM	DESCRIPTION	QTY	REMARKS
A	1inx1.5in PIPE COUPLING	2	NATIONAL PIPE THREAD-0.5" COUPLING
B	10mm X 44mm DIAMETER	2	20mm HOLE CENTERED
C	50mmID X 50mm X 7mm THCK	2	30° BEVEL ONE END
D	10mm X 125mm X 200mm	2	30° BEVEL ONE END
E	10mm X 95mm X 110mm	2	
F	10mm X 40mm X 40mm	2	
G	10mm X 85mm X 170mm	1	32mmR ONE CORNER/30° BEVEL 2 EDGES
H	10mm X 85mm X 170mm	1	32mmR ONE CORNER/30° BEVEL 2 EDGES
I	10mm X 85mm X 100mm	1	32mmR ONE CORNER/30° BEVEL 2 EDGES
J	10mm X 85mm X 100mm	1	32mmR ONE CORNER/30° BEVEL 2 EDGES
K	10mm X 250mm X 215mm	1	
L	10mm X 250mm X 185mm	1	20mm DIAMETER HOLE
M	50mmID X 280mm X 7mm THCK	1	20mm DIAMETER HOLE
N	10mm X 44mm DIAMETER	1	
O	10mm X 53mm X 115mm	2	
P	10mm X 100mm X 170mm	1	32mmR ONE EDGE
Q	10mm X 160mm X 170mm	1	32mmR ONE EDGE/20mm DIAMETER HOLE

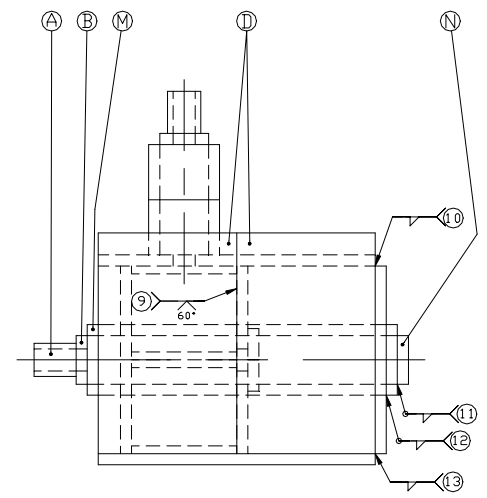
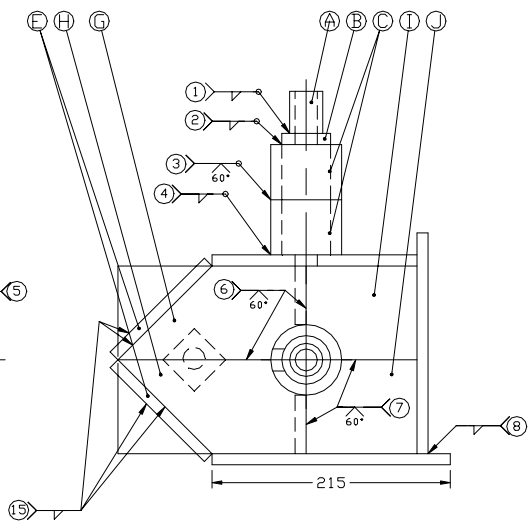
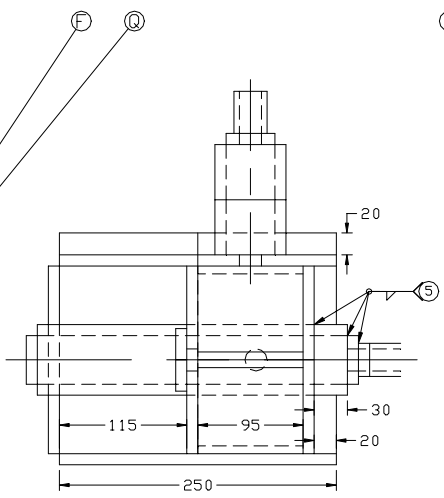
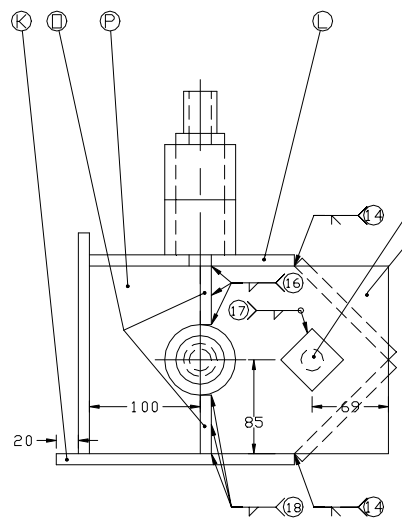
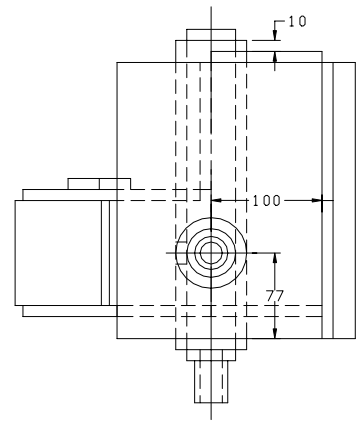


Weld-Off at the AWS Welding Show Las Vegas, NV 2008

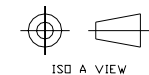
SCALE NONE	AWS	SKILLS-USA
#2A	PRESSURE VESSEL PROJECT	

### INSTRUCTIONS

- TACK WELDS CAN BE MADE IN ANY POSITION WITH ANY PROCESS IN THE MOST LOGICAL SEQUENCE FOR STRUCTURAL SQUARENESS AND JOINT ACCESS. ALL TACK WELDS ARE TO BE MADE NO LONGER THAN 25mm AND PLACED ON THE OUTSIDE OF THE VESSEL ONLY. ALL WELDS ARE TO BE MADE WITH BASE PLATE (ITEM K) ON BOTTOM.
- WELDS 1,2,3, AND 4 ARE TO BE MADE WITH GTAW.
- WELDS 5,6, ARE TO BE MADE WITH GMAW.
- WELDS 7,8, AND 17 ARE TO BE MADE WITH FCAW.
- ALL OTHER WELDS ARE TO BE MADE USING SMAW.
- ALL FILLET WELDS ARE TO BE APPROXIMATELY 10mm IN LEG SIZE.
- GRINDING WILL BE LIMITED TO: TACK WELDS, STARTS, STOPS, ROOT PASS FACE AND TOES.
- POST CLEANING: WIREBRUSH ONLY AFTER SLAG REMOVAL. NO GRINDING.
- SMAW: AWS 5.1 E-7018
- GMAW: AWS 5.18 ER-70S-3 0.9mmØ 75% ARGON - 25% CARBON DIOXIDE.
- FCAW: AWS E70T-1 1.2mmØ 100% CARBON DIOXIDE
- GTAW: AWS ER70S-2 1.6mmØ 100% ARGON



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Weld-Off at the AWS Welding Show Las Vegas, NV 2008

SCALE NONE	AWS	SKILLS-USA
#2B	PRESSURE VESSEL PROJECT	

