

ITEM	DESCRIPTION	QTY	REMARKS
A	3MM X 65.00MM X 200.00MM	2	
B	3MM X 80.00MM X 100.00 MM	1	
C	3MM X 100.00MM X 100.00MM	1	
D	3MM X 52.00MM X 94.00MM	1	
E	3MM X 52.00MM X 100.00MM	1	
F	3MM X 60.00MM X 94.00MM	2	
G	3MM X 75.00MM X 75.00MM	2	
H	3MM X 50.00MM X 180.00MM	4	45° ANGLE ONE END
I	3MM X 67.71MM X 100.00MM	1	
J	3MM X 67.71MM X 94.00MM	1	

NONE	AWS	WSC	SkillsUSA		
 ISO A VIEW		2007 US Open Weld Trials Kansas City, MO			
#4		ALUMINUM			

ALL DIMENSIONS IN MILLIMETRES

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 10mm AND PLACED ON THE OUTSIDE OF THE VESSEL ONLY. ALL WELDS ARE TO BE MADE WITH BASE PLATE (ITEM A) ON BOTTOM.
- ALL WELDS ARE TO BE MADE WITH GTAW.
- ALL FILLET WELDS ARE TO BE APPROXIMATELY 3MM IN LEG SIZE +-1MM
- ALL BUTT AND OUTSIDE CORNER WELDS ARE COMPLETE JOINT PENETRATION
- ALL OUTSIDE CORNER WELDS TO HAVE FULL RADIUS CONVEX CONTOUR.
- POST CLEANING: NONE. NO GRINDING.
- NO GRINDING IS ALLOWED EXCEPT TO PREPARE PLATES

