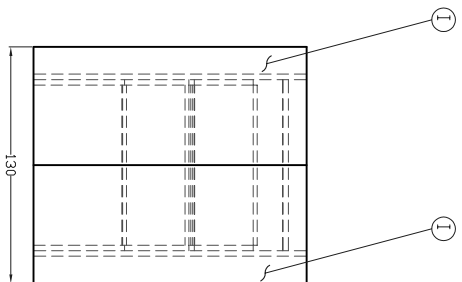
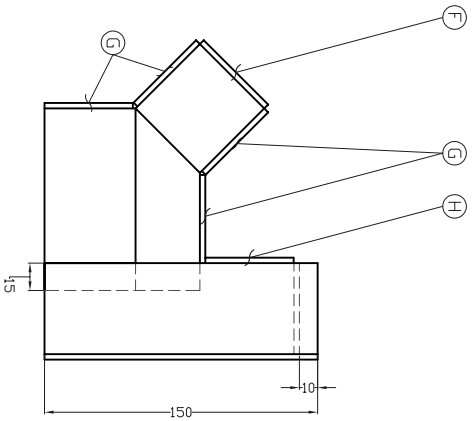
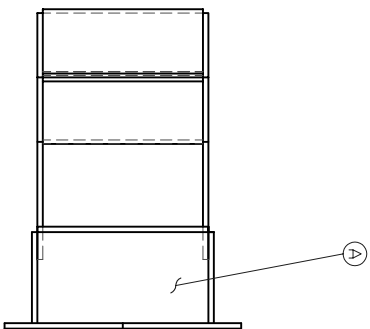
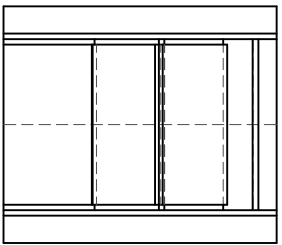
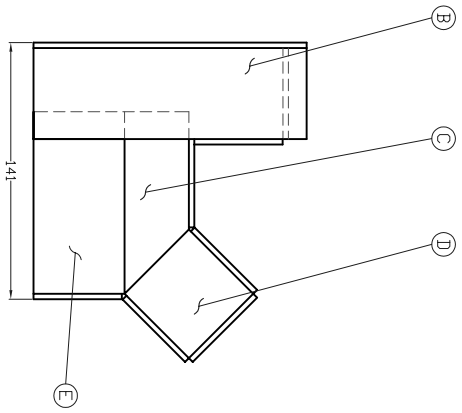


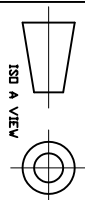
| ITEM | DESCRIPTION NOTE ALL DIMENSIONS +-1MM | QTY. | REMARKS |
|------|---------------------------------------|------|-------------------|
| A | 3 mm x 50 mm x 94 mm Plate | 1 | |
| B | 3 mm x 50 mm x 150 mm Plate | 2 | |
| C | 3 mm x 35.355 mm x 100 mm Plate | 2 | Cut angle one end |
| D | 3 mm x 50 mm x 50mm Plate | 2 | |
| E | 3 mm x 50 mm x 100 mm Plate | 2 | |
| F | 3 mm x 48.5 mm x 94 mm Plate | 1 | |
| G | 3 mm x 48.5 mm x 88 mm Plate | 4 | |
| H | 3 mm x 50 mm x 88 mm Plate | 1 | |
| I | 3 mm x 65 mm x 150 mm Plate | 2 | |

INSTRUCTIONS

1. 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 STRUCTURE ONLY. ALL WELDS ARE TO BE MADE WITH WELD #4 IN THE 3G POSITION.
2. ALL WELDS ARE TO BE MADE WITH GTAW 1.6MMØ OR 2.38MMØ ER5356 100% ARGON.
3. ALL FILLET WELDS ARE TO BE APPROXIMATELY 3MM IN LEG SIZE +-1MM PENETRATION WELDS
4. ALL BUTT AND OUTSIDE CORNER WELDS ARE COMPLETE JOINT
5. ALL OUTSIDE CORNER WELDS TO HAVE FULL RADIUS CONVEX CONTOURS.
6. POST CLEANING: NONE.
7. NO GRINDING IS ALLOWED.



ALL DIMENSIONS IN MILLIMETRES



2009 AWS SKILLSUSA
WELD TRIALS
KANSAS CITY, MO

ALUMINUM