



SCALE NONE	AWS	WSC	SKILLSUSA
 ISO A VIEW		 2009 AWS SKILLSUSA WELD TRIALS KANSAS CITY, MO	

PRESSURE VESSEL

ALL DIMENSIONS IN MILLIMETRES

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 15mm AND PLACED ON THE OUTSIDE OF THE VESSEL ONLY. ALL WELDS ARE TO BE MADE AS INDICATED ON DRAWING.
2. WELDS LABELED A ARE TO BE MADE WITH GTAW
3. WELDS LABELED B ARE TO BE MADE WITH SMAW (MMA)
4. WELDS LABELED C ARE TO BE MADE WITH GMAW (MAG/MIG)
5. WELDS LABELED D ARE TO BE MADE WITH FCAW
6. ALL FILLET WELDS ARE TO BE 10mm +2mm -0mm IN LEG SIZE.
7. GRINDING WILL BE LIMITED TO: TACK WELDS, STARTS, STOPS, ROOT PASS FACE AND TOES.
8. POST CLEANING: WIRE BRUSH ONLY AFTER SLAG REMOVAL. NO GRINDING.
9. SMAW: AWS A51 E-7018
10. GMAW: AWS A518 ER 70S-3 0.9MMØ 75% ARGON - 25% CARBON DIOXIDE.
11. FCAW: AWS A520 E71T-1 12MMØ 75% ARGON - 25% CARBON DIOXIDE.
12. GTAW: AWS A518 ER70S-2 10MMØ 100% ARGON.

