

ITEM	DESCRIPTION	QTY.	REMARKS
A	10mm (3/8") x 75mm (3") x 180mm(7")	2	30° Bevel one edge
B	16mm (5/8") x 75mm (3") x 180mm (7")	2	30° Bevel one edge
C	4 Inch Sch 80 Pipe X 6" 30° bevel one end	2	30° Bevel one end

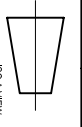

INSTRUCTIONS

Test Plate #1A
 Position: 4G
 Process: SMAW
 Filler Material: E7018 Root and all subsequent Passes

Test Plate #1B
 Position: 2G
 Process: FCAW
 Filler Material: ER70S-3 Root and E71T-1 all subsequent Passes
 Gas Shielding: 75% Argon/25% Carbon Dioxide
 Notes: A Start and Stop is required in the root pass and final cap pass it must be stamped and verified by a judge as shown with the "V" Mark on the drawing. Use a letter V Stamp and mark as a pointer on the root side and face side.
 *Applicable only on test plate 1B

Test Pipe #1C
 Position: 6G
 Process: GTAW Root /GMAW-S Fill and Cover
 Filler Material: ER70S-2 Root and ER70S-3 all subsequent Passes
 Gas Shielding: 100% Argon Root Pass 75% Argon/25% Carbon Dioxide Balance

ASSESSMENT
 Visual assessment of all welds
 Bend test Root and face of all welds
 Radiographic examination of all welds

SCALE	AWS	SKILLS-USA
NONE		
2009 AWS SKILLSUSA WELD TRIALS KANSAS CITY, MO		
TEST PLATES		

