

Designed by <i>Robert Pope</i>	Drawn By <i>Nick Peterson</i>	Date June 1, 2007	ISO A	Scale NONE
Weld-Off at the AWS Welding Show Atlanta, GA 2010		Name PROJECT TASK #2	Trade 10 WELDING	Revision 0
		Sheet 1 of 4		

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. GRINDING WILL BE LIMITED TO: TACK WELDS, STARTS, STOPS, ROOT PASS FACE AND TOES.
7. POST CLEANING: WIRE BRUSH ONLY AFTER SLAG REMOVAL. NO GRINDING.
8. SMAW: AWS A5.1 E-7018
9. GMAW: AWS A5.18 ER 70S-3 0.9MMØ 75% ARGON - 25% CARBON DIOXIDE.
10. FCAW: AWS A5.20 E71T-1 1.2MMØ 75% ARGON - 25% CARBON DIOXIDE.
11. GTAW: AWS A5.18 ER70S-2 1.0MMØ 100% ARGON.

