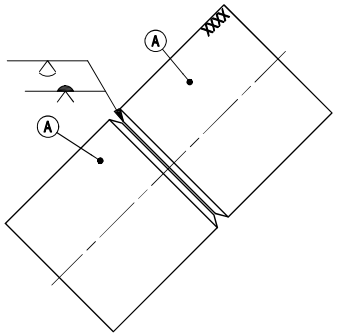
PIPE TEST COUPON 1A:
MATERIAL: CARBON STEEL PIPE
2 PCS Ø114.3 X 8.6 WALL X 115 LONG

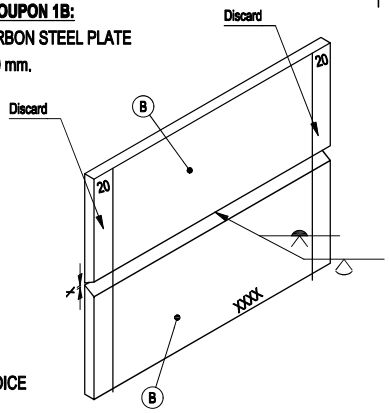
NOTE:
THE NUMBER OF TACKS IS TO BE LIMITED WITH A MAXIMUM 4 TACKS AND MINIMUM 3 TACKS.



WELDING PROCESSES/POSITION:
ROOT PASS: _____
FILL & CAP: _____
WELDING POSITION: _____

EVALUATION:
1. VISUAL
2. X-RAY ENTIRE WELD JOINT

TEST PLATE COUPON 1B:
MATERIAL: CARBON STEEL PLATE
THICKNESS: 10 mm.



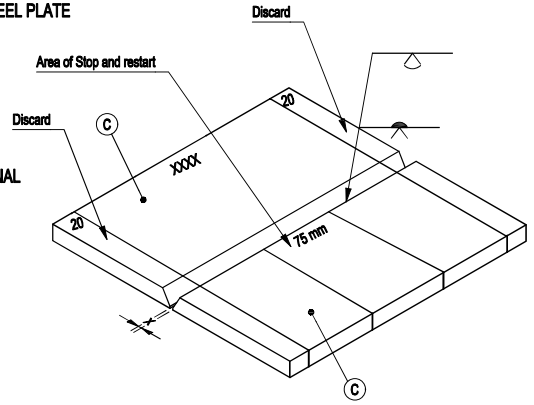
X = YOUR CHOICE

WELDING PROCESSES/POSITION:
ROOT PASS: _____
FILL & CAP: _____
WELDING POSITION: _____

EVALUATION:
1. VISUAL
2. X-RAY ENTIRE WELD JOINT

TEST PLATE COUPON 1C:
X = YOUR CHOICE
MATERIAL: CARBON STEEL PLATE
THICKNESS: 16 mm.

HOLD POINT
AREA OF STOP AND RESTART IN ROOT & FINAL CAP PASS

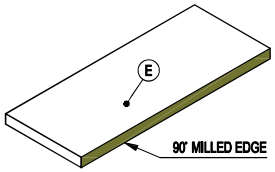


WELDING PROCESSES/POSITION:
ROOT PASS: _____
FILL & CAP: _____
WELDING POSITION: _____

EVALUATION:
1. VISUAL
2. X-RAY ENTIRE WELD JOINT

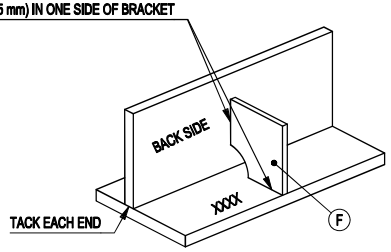
FILLET WELD COUPON-1:
MATERIAL: CARBON STEEL PLATE
THICKNESS: 12 mm
WELDING PROCESS: _____
WELDING POSITION: _____

FILLET WELD COUPON-2:
MATERIAL: CARBON STEEL PLATE
THICKNESS: 12 mm
WELDING PROCESS: _____
WELDING POSITION: _____

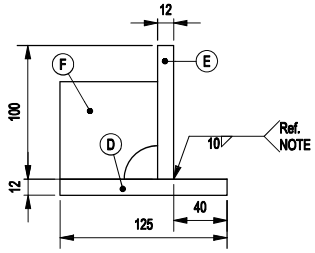


NOTE:
1. DEPOSIT A FILLET WELD ON THE FRONT SIDE OF THE JOINT WITH A 10 mm (+2.0/-0) mm LEG LENGTH.
2. WELD TO BE DEPOSITED WITH A MINIMUM OF 2 RUNS AND A MAXIMUM OF 3 RUNS.
3. EDGE PREPARATION MUST REMAIN AT 90° TO THE PLATE FACE. NO CHAMFER AND GAP ARE ALLOWED.

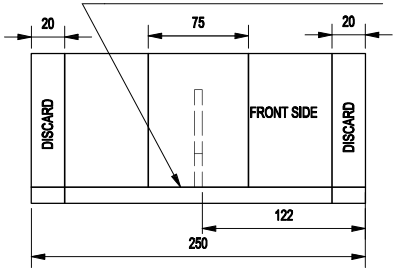
TWO TACKS (MAX. 15 mm) IN ONE SIDE OF BRACKET



EVALUATION:
1. VISUAL
2. BREAK TEST

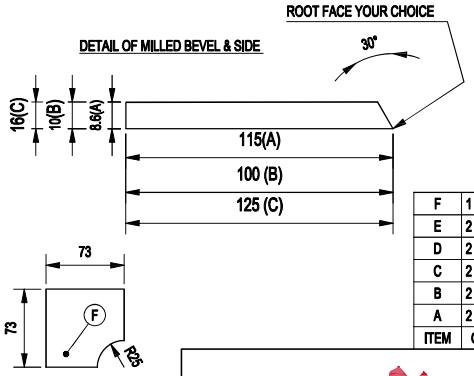


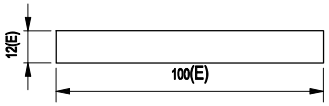
STOP/RESTART OF ROOT AND FINAL CAPPING PASS WITHIN THIS AREA



ALL DIMENSIONS IN MILLIMETRES
BUT DO NOT SCALE DRAWING

NOTE:
1. ANY PROCESS AND ANY POSITION MAY BE USED FOR TACKWELDING.
2. ALL TACK WELDS 15mm MAXIMUM IN LENGTH. NO TACK WELDING IN THE JOINT OF FILLET WELD 1 AND 2, ONLY TACK WHERE SHOWN ON DRAWING. FOR COUPON 1A (TEST PIPE), MAXIMUM 4 TACK WELDS, MINIMUM 3 TACK WELDS. FOR COUPONS 1B AND 1C (TEST PLATES), TACK WELD IN DISCARD AREA ONLY
3. ALL PLATE OR PIPE COUPONS ARE TO BE TACKWELDED BEFORE ANY WELDING COMMENCES.
4. PROCESS INDICATED FOR ROOT WELD TO BE USED ONLY FOR ONE RUN, NOT FOR SECOND AND SUBSEQUENT PASSES.
5. ALL PLATE OR PIPE COUPONS MUST BE WELDED IN THE POSITION AS INDICATED FOR EACH TEST.
6. GRINDING IS NOT ALLOWED FOR THE CLEANING OF THE FINAL SURFACES OF BOTH CAP AND ROOT WELDS.
7. XXXX= COMPETITOR'S I.D.





NTS = NOT TO SCALE

ITEM	Q'TY	MATERIAL	DESCRIPTIONS	REMARKS
F	1	CARBON STEEL	PLATE 73 X 73 X 6	BRACKET FOR TEMPORARY BACKING
E	2	CARBON STEEL	PLATE 250 X 100 X 12	ONE 90 deg.MILLED EDGE AS PER SKETCH
D	2	CARBON STEEL	PLATE 250 X 125 X 12	
C	2	CARBON STEEL	PLATE 250 X 125 X 16	30 deg. MILLED BEVEL
B	2	CARBON STEEL	PLATE 250 X 100 X 10	30 deg. MILLED BEVEL
A	2	CARBON STEEL	PIPE OD 114.3 X 8.6 WALL X 115 LONG	30 deg. TURNED BEVEL

worldskills Shanghai2026

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