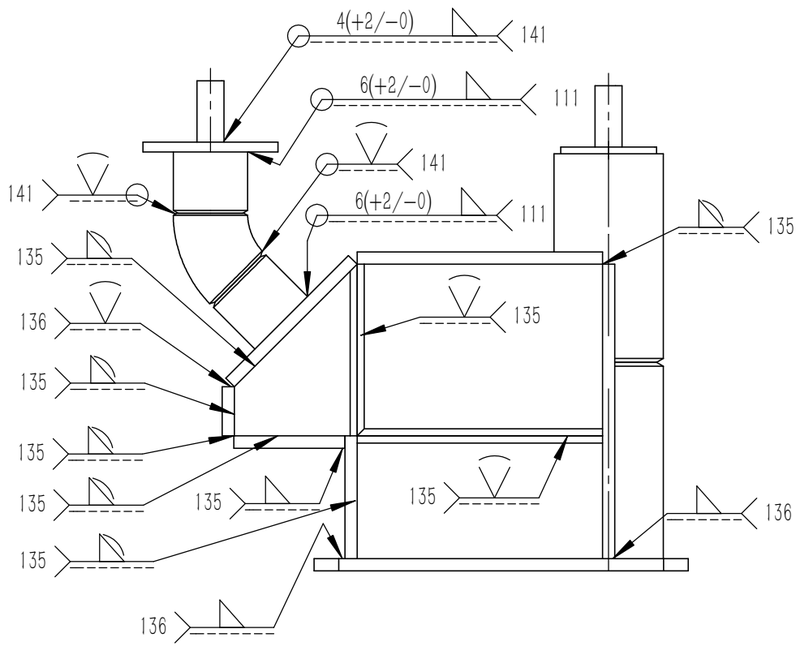
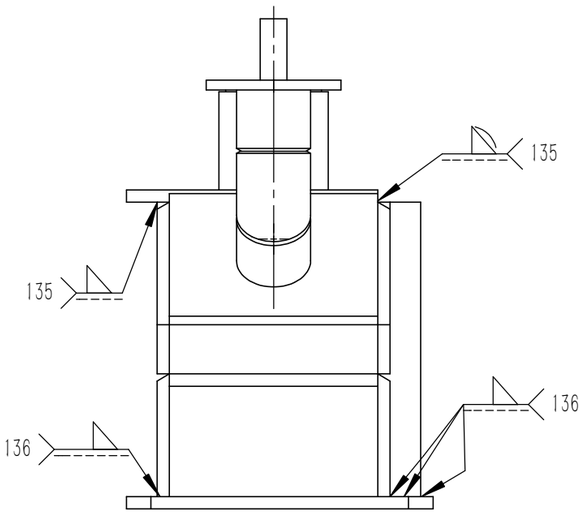
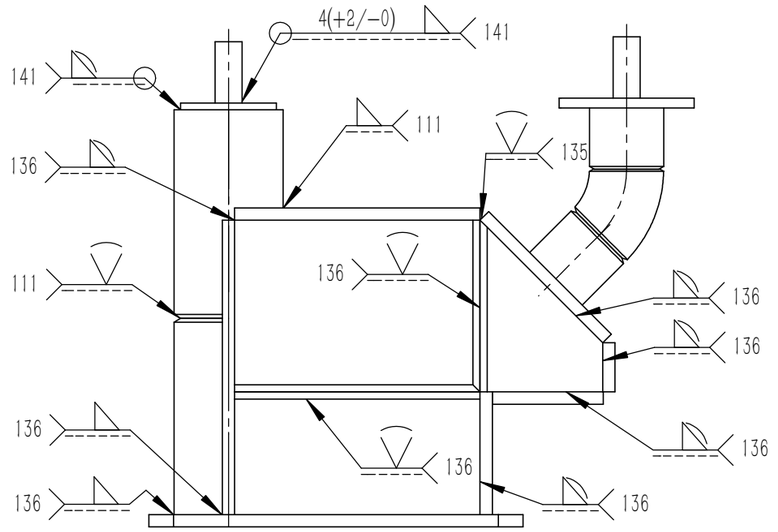
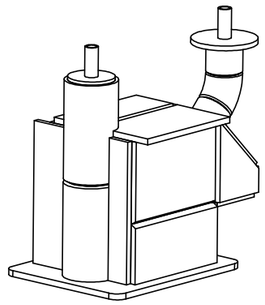
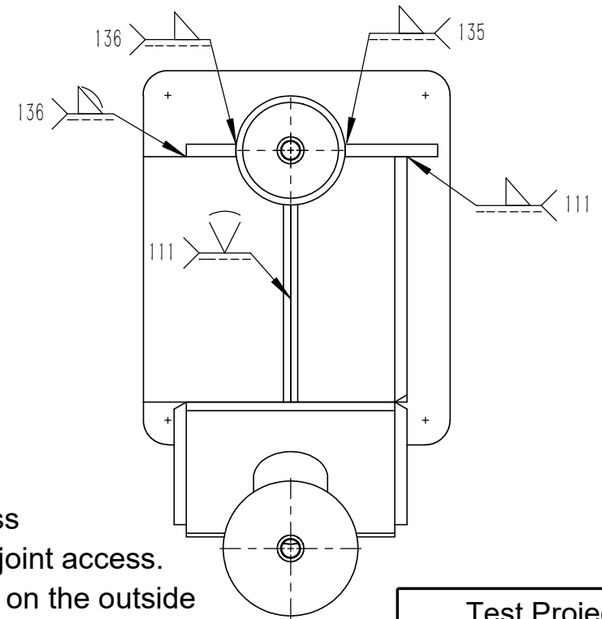
WELDING PROCESSES	
ISO4063	AWS A3.0
111	SMAW
135	GMAW
136	FCAW-G
141	GTAW

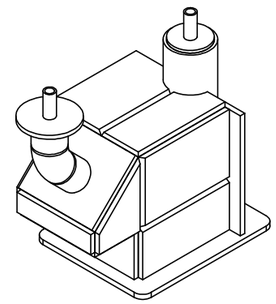












INSTRUCTIONS:

1.Tack welds can be makde in any position with and any process
in the most logical sequence for structural squareness and any joint access.
2. All tack welds are to be made shorter than 15mm and placed on the outside of the vessel only.
3. All welds are to be made as indicated on drawing.
4. All fillet welds except special notes are to be 10mm(+2mm/-0mm） in leg length.
5.Complete all welding with base "A" in the flatposition.
6.Grinding will be limited to :"tack welds,starts, stops, rootpass, face ang toes."
7.Post cleaning : wire brush only after slag removal . No grinding.

Note: All dimensions in millimeter

Test Project for the 48th WorldSkills
Competition In Shanghai ,China 2026
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worldskills

skill: 10 welding			
Scale: N. T. S	Date: 17 Aug 2024	Paper: A3	OR
Designed/ Drawn by : liujingfeng CN			Drawing No. WCS2026_TP10_CN_06_EN
Description: Module B :Pressure Vessel ISO E			Rev.x / Page： 1 of 1