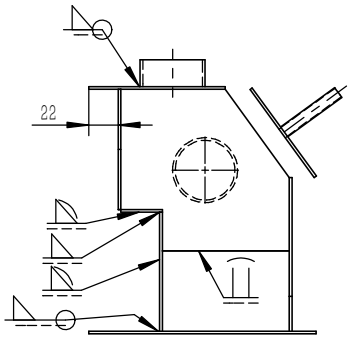
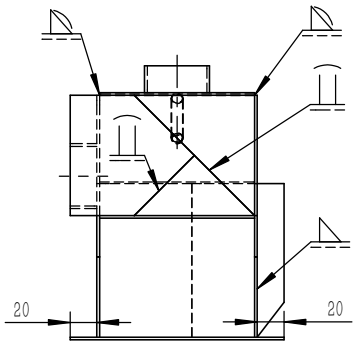
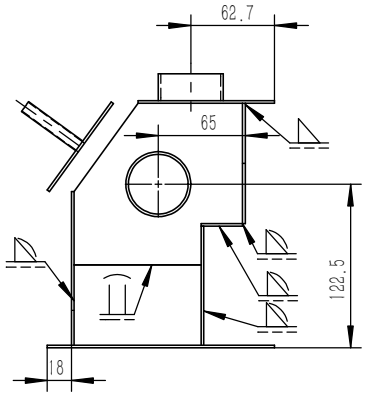
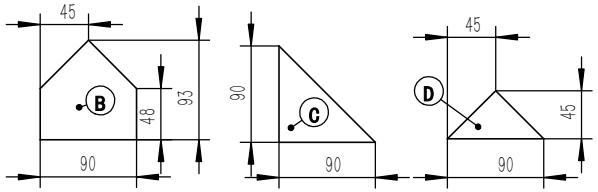
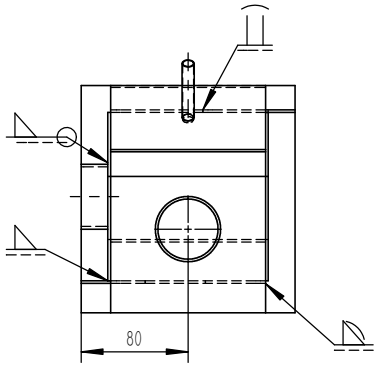
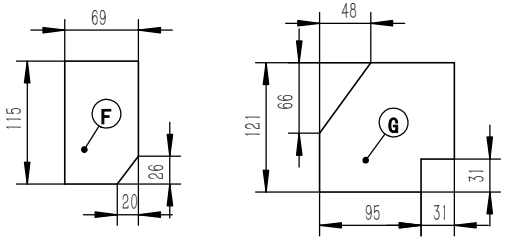




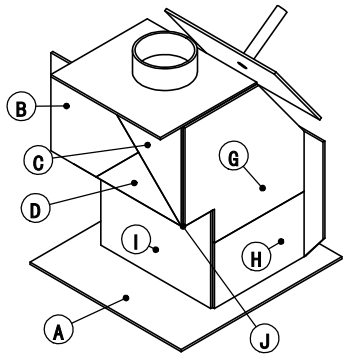


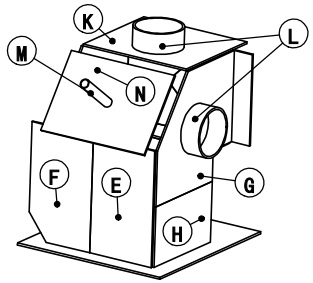






ALL DIMENSIONS IN MILLIMMETERS





INSTRUCTIONS:

1. WELDING PROCESS :GTAW(TIG)141.
2. PURGE PLATE TACKED IN PLACE AND REMOVE AFTER COMPLETE WELDING.
3. WELDING POSITIONS : ALL EXCEPT VERTICAL DOWN.
4. COMPLETE ALL WELDING WITH BASE : "A" IN THE FLAT POSITION.
5. ALL LEG SIZES OF FILLET WELDS : 3.0mm (+1.0mm/-0.0mm).
6. OUTSIDE CORNER WELD RADII : 2.0mm (+1.0mm/-0.9mm).
7. OUTSIDE CORNER WELD RADII : 3.0mm WITH TOLERANCE (+1.0mm/-0.9mm)
8. NO FINISHING OF ANY KIND AFTER WELDING.

ITEM	QTY	Material	Dimensions	REMARKS
A	1	ANSI 304	Plate 160×170×2.0	
B	1	ANSI 304	Plate 93×90×2.0 as per sketch	
C	1	ANSI 304	Plate 90×90×2.0 as per sketch	
D	1	ANSI 304	Plate 45×90×2.0 as per sketch	
E	1	ANSI 304	Plate 69×115×2.0	
F	1	ANSI 304	Plate 69×115×2.0 as per sketch	
G	2	ANSI 304	Plate 121×126×2.0 as per sketch	
H	2	ANSI 304	Plate 60×95×2.0	
I	1	ANSI 304	Plate 89×116×2.0	
J	1	ANSI 304	Plate 31×116×2.0	
K	1	ANSI 304	Plate 102×116×2.0	
L	2	ANSI 304	Tube OD 48.6×20×2.0	
M	1	ANSI 304	Tube OD 9×50×0.5 Purging Tube	
N	1	ANSI 304	Plate 81.5×116×2.0 Purging plate	φ8 hole in center

Test Project for the 48th WorldSkills
Competition In Shanghai ,China 2026
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skill: 10 welding

Scale: N. T. S | Date: 28/08/2024 | Paper: A3

OR

Designed/ Drawn by : Takuma Suzuki JP

Drawing No. WCS2026_TP10_JJ.SS_Assembly_ISOE

Description:Module D Stainless steel -Assembly@ symbols

Rev.x

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