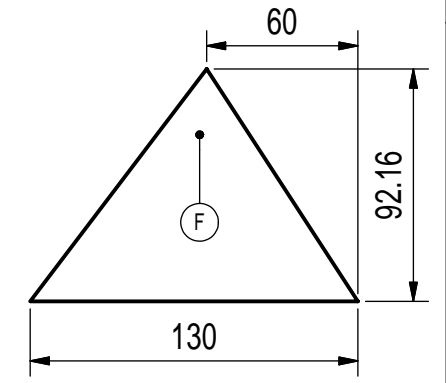
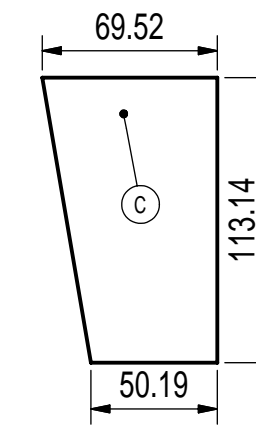
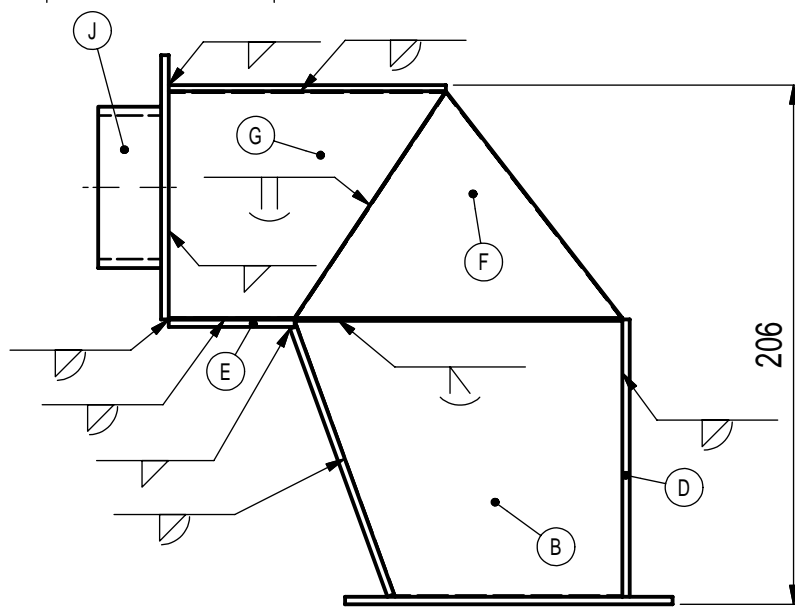
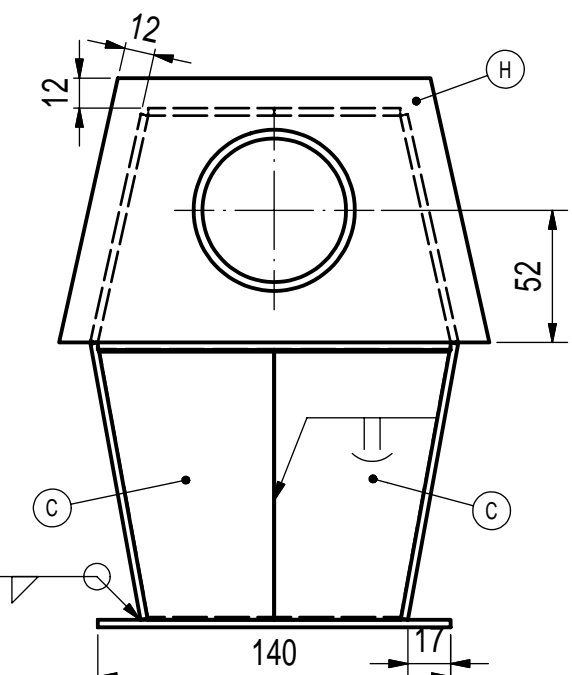
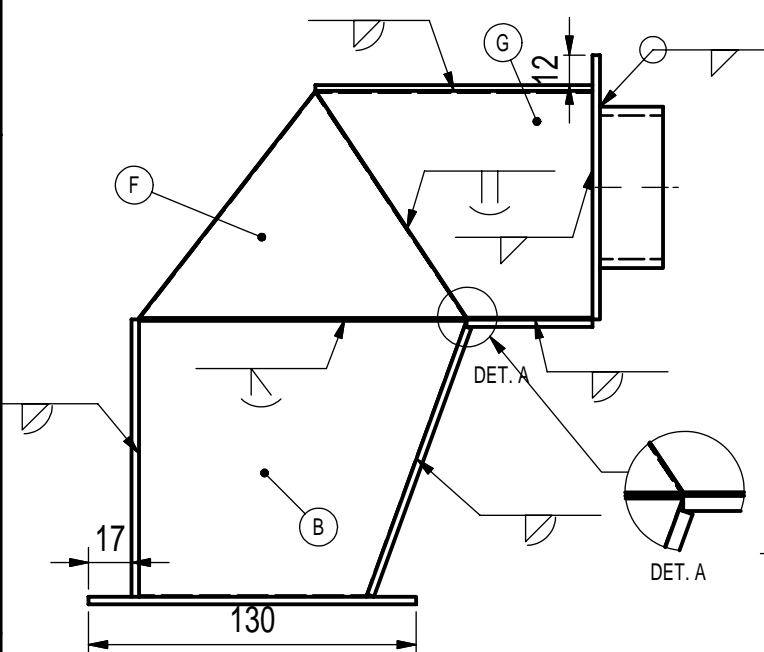
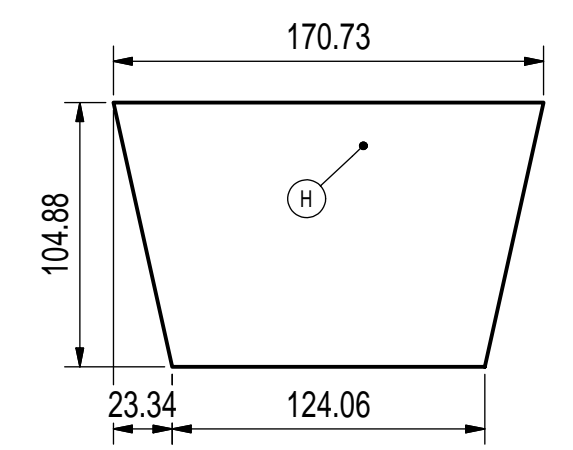


No.	Items	Q'ty	Descriptions
1	A	1	AA 5052 SHEET, 140X130X3
2	B	2	AA 5052 SHEET, 130X111.26X90.19X3, CUT TO SHAPE
3	C	2	AA5052 SHEET, 50.19X113.14X69.52X3 CUT TO SHAPE
4	D	1	AA5052 SHEET, 140X110X100X3 CUT TO SHAPE
5	E	1	AA5052 SHEET, 140X50X3
6	F	2	AA5052 SHEET, 130X92.16X60X3 CUT TO SHAPE
7	G	2	AA5052 SHEET, 110X92.16X50X3 CUT TO SHAPE
8	H	1	AA5052 SHEET, 170.73X104.88X124.06X3 CUT TO SHAPE
9	I	2	AA5052 SHEET, 110X50X3
10	J	1	AA 6061 TUBE, OD 64X25X3



**INSTRUCTIONS TO COMPETITORS**

1. WELDING PROCESS: GTAW (TIG) (141).
2. WELDING POSITIONS: ALL EXCEPT VERTICAL DOWN.
3. ALL THE WELDING MUST BE CARRIED OUT WITH BASE PLATE 'A' IN THE FLAT POSITION.
4. ALL FILLET LEG SIZES: 4.0 mm WITH TOLERANCE (+2.0 mm/-0.0 mm).
5. OUTSIDE CORNER WELD RADII: 3.0mm WITH TOLERANCE (+1.0 mm/-1.0 mm).

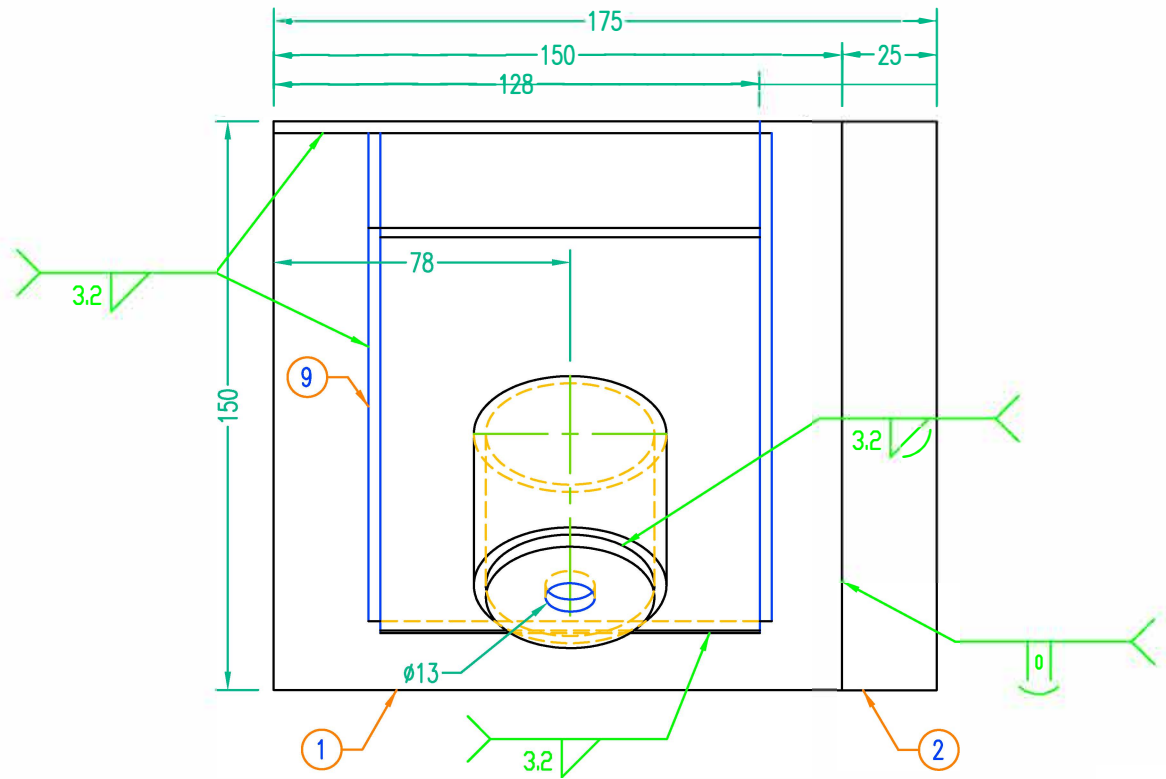


DOCUMENT USE

Note: All Dimension in Millimetres



Skill: 10. Welding,			
Scale: N. T. S	Date: 14. June. 2013	Paper: A3	
Drawn/Designed by: Chih-Peng Chen TW			Drawing No: WSC2015_TP10_TW_AL_ASSEMBLY_ISO A
Description: Aluminium-Assembly & Symbols			Rev: _____ Page: _____
Appd: _____			Sign: _____

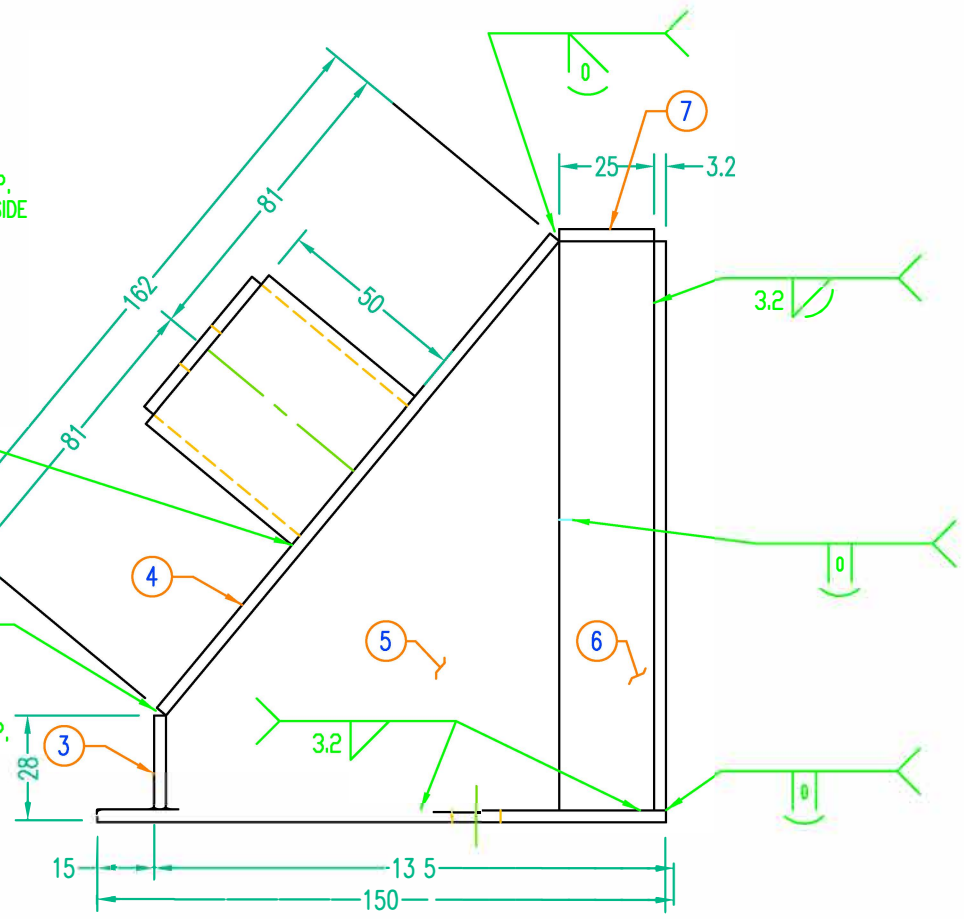
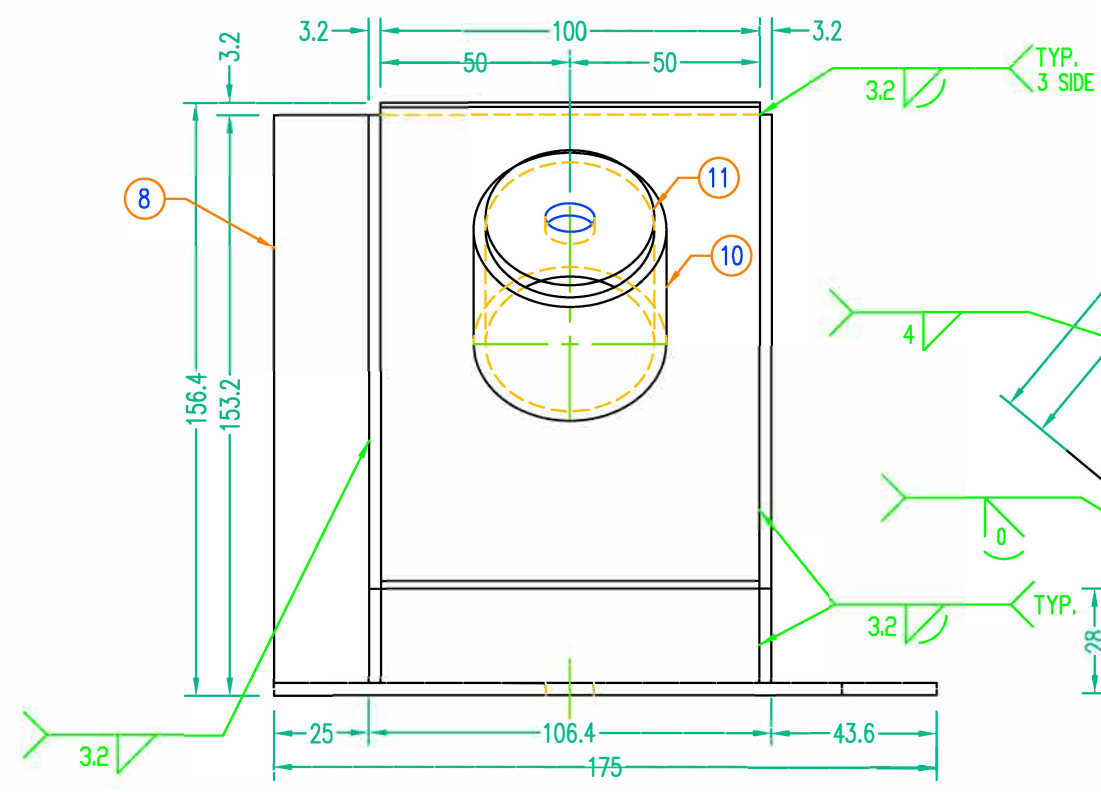


- NOTE:**
- 1) All welds are done with the GTAW process.
  - 2) Project must remain flat on plates #1 and #2 during welding.
  - 3) The tolerance of fillet weld sizes is +1mm -0mm
  - 4) The tolerance for the radius of the corner welds is 3.2mm +1mm -0mm
  - 5) All welds require filler metal (fusion only not permitted).
  - 6) All vertical welds to be uphill.
  - 7) Purging not required.
  - 8) Arc washing over completed weld is not permitted
  - 9) Wire brushing or cleaning of any kind is not permitted.
  - 10) Tackweld all components together before any welding commences.
  - 11) All dimensions in millimetres.

**TIME LIMIT: 2.0 HRS.**

ITEM	QTY	DESCRIPTION	REMARKS
1	1	PL. 3.2mm X 150mm X150mm	
2	1	PL. 3.2mm X 25mm X150mm	
3	1	PL. 3.2mm X 25mm X100mm	
4	1	PL. 3.2mm X 100mm X162mm	
5	1	PL. 3.2mm X 103.6mm X150mm	SHAPE CUT
6	1	PL. 3.2mm X 25mm X150mm	
7	1	PL. 3.2mm X 25mm X100mm	
8	1	PL. 3.2mm X 128mm X150mm	
9	1	PL. 3.2mm X 128.6mm X150mm	SHAPE CUT
10	1	PIPE $\phi$ 50.8mm O.D. X 3.2mm X 50mm lg	
*11	1	PL. 3.2mm X $\phi$ 45mm O.D.	SHAPE CUT

\* (1) Hole for pressure relief



**PROJECT #1**  
 CONCEPTION: DANNY BLAIS  
 DRAWN BY:BERNARD CARON  
 EDITED: Robbie Duncan

SCALE: 1 : 2

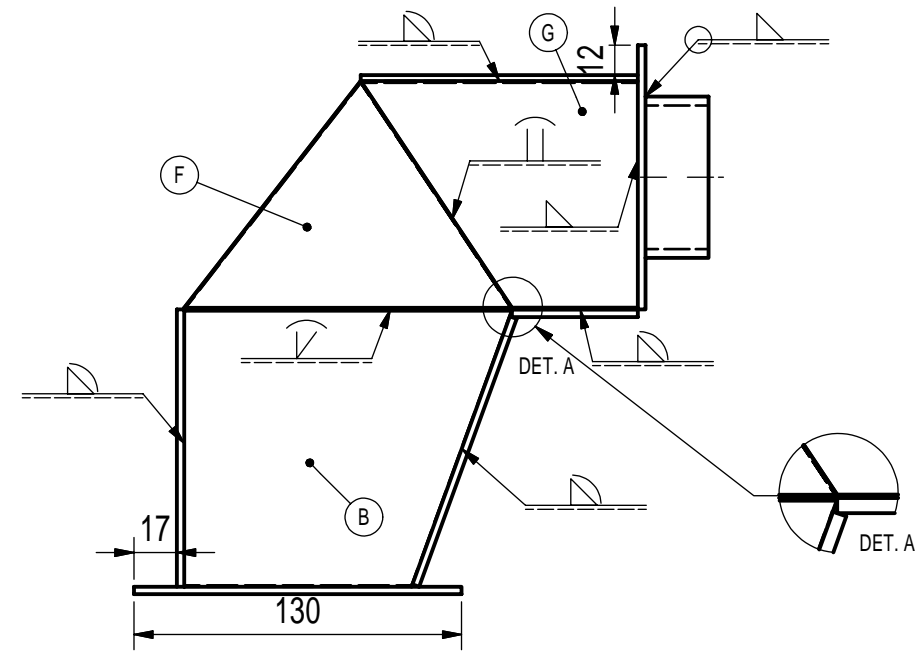
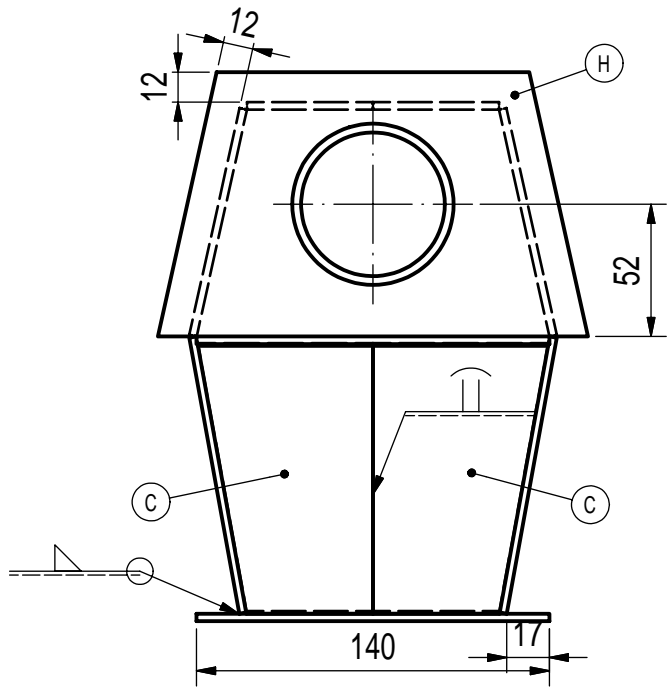
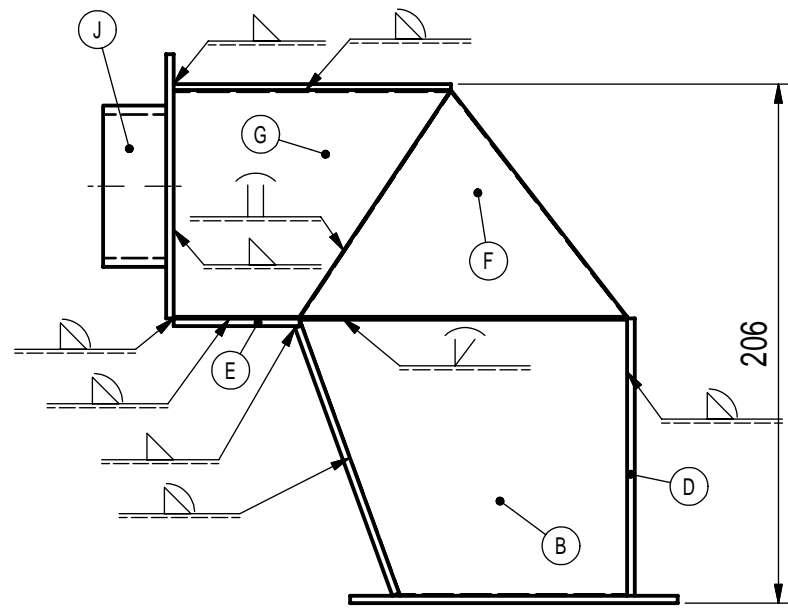
DRAWING NO.  
 2017-CPS-ICS-1E

**PROJECT  
 CARBON STEEL**

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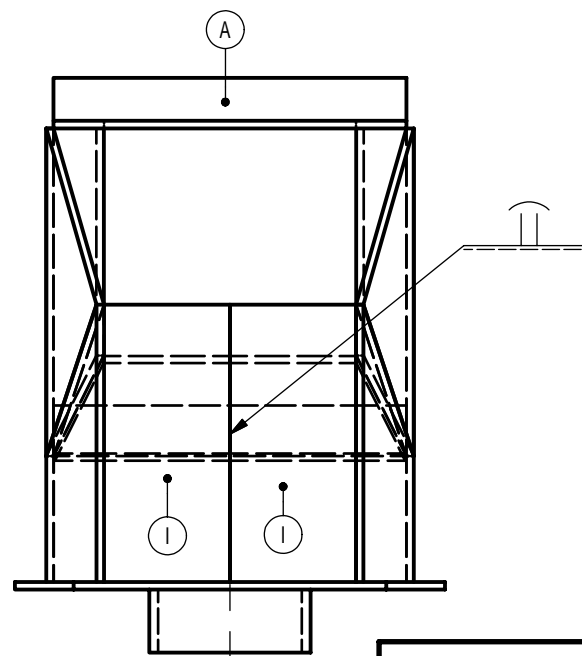
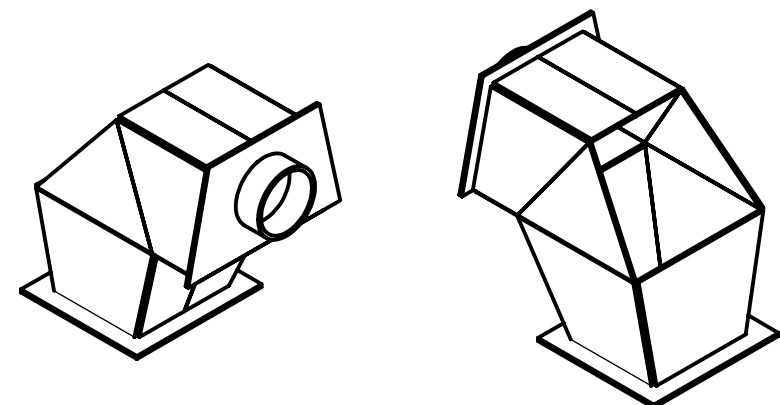
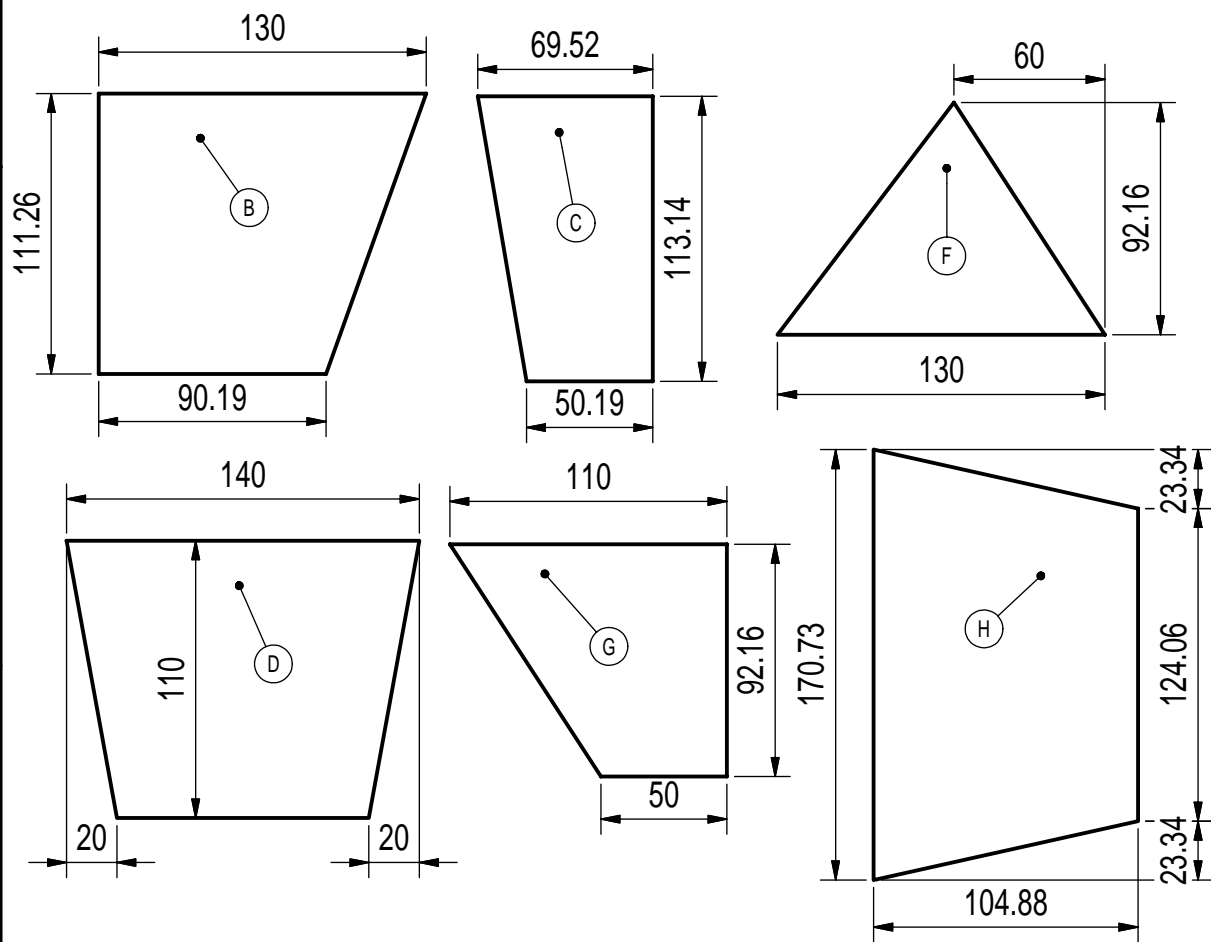
A

A



B

B



No.	Items	Qty	Descriptions
10	J	1	AA 6061 TUBE, OD 64X25X3
9	I	2	AA5052 SHEET, 110X50X3
8	H	1	AA5052 SHEET, 170.73X104.88X124.06X3 CUT TO SHAPE
7	G	2	AA5052 SHEET, 110X92.16X50X3 CUT TO SHAPE
6	F	2	AA5052 SHEET, 130X92.16X60X3 CUT TO SHAPE
5	E	1	AA5052 SHEET, 140X50X3
4	D	1	AA5052 SHEET, 140X110X100X3 CUT TO SHAPE
3	C	2	AA5052 SHEET, 50.19X113.14X69.52X3 CUT TO SHAPE
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1	A	1	AA 5052 SHEET, 140X130X3

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DOCUMENT USE

Note: All Dimension in Millimetres



Scale: N. T. S	Date: 14. June. 2013	Paper: A3
Drawn/Designed by: Chih-Peng Chen TW		
Description: Aluminium-Assembly & Symbols		

	OR	
Drawing No: WSC2015_TP10_TW_AL_ASSEMBLY_ISO E		
Rev:	Page:	
Appd:	Sign:	

1 2 3 4 5 6

D

D

## INSTRUCTIONS

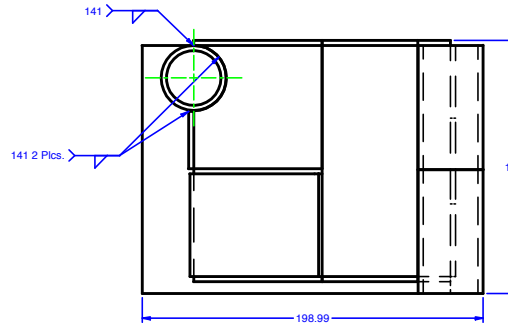
1. TACK WELDS CAN BE MADE IN ANY POSITION WITH ANY PROCESS IN THE MOST LOGICAL SEQUENCE FOR STRUCTURAL SQUARENESS AND JOINT ACCESS. ALL TACK WELDS ARE TO BE MADE NO LONGER THAN 10mm AND PLACED ON THE OUTSIDE OF THE STRUCTURE ONLY. ALL WELDS ARE TO BE MADE AS INDICATED ON DRAWING.

2. ALL FILLET WELDS ARE TO BE 3mm +1mm -0mm IN LEG SIZE.

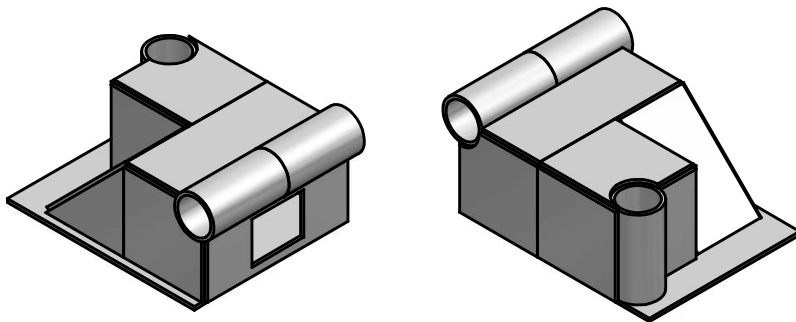
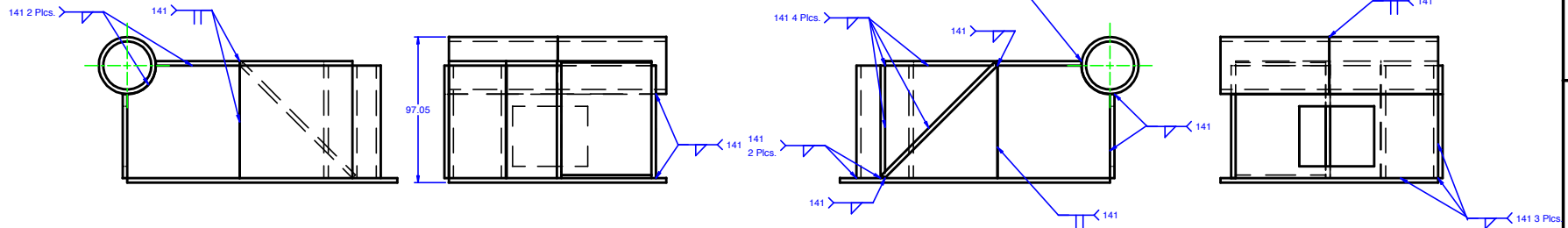
3. NO GRINDING WILL BE ALLOWED

4. NO POST CLEANING

5. GTAW (141): AWS A5.9 ER308L 100% ARGON.



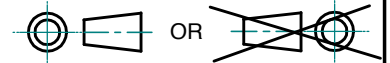
DOCUMENT USE



Skill: WELDING

Scale: NONE Date:

Paper: A3



Drawn / Design by: N.Peterson

Drawing No:

Description:

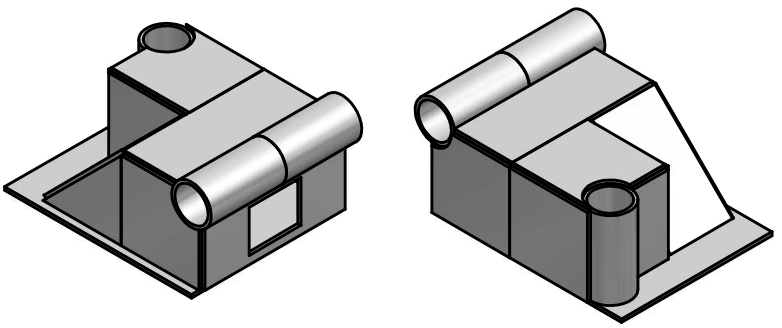
Rev:

1 of 2

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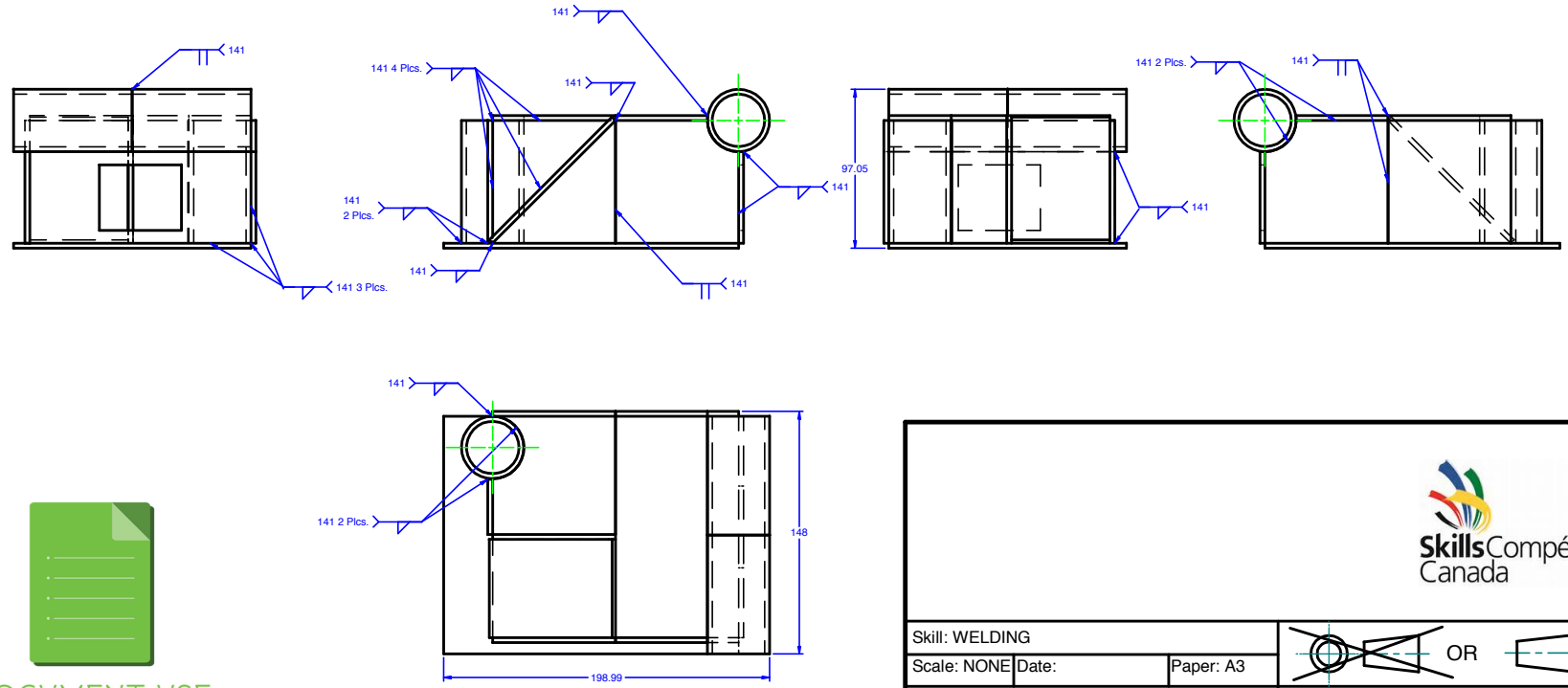
A  
B  
C  
D  
E  
F

A  
B  
C  
D  
E  
F



### 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 10mm AND PLACED ON THE OUTSIDE OF THE STRUCTURE ONLY. ALL WELDS ARE TO BE MADE AS INDICATED ON DRAWING.
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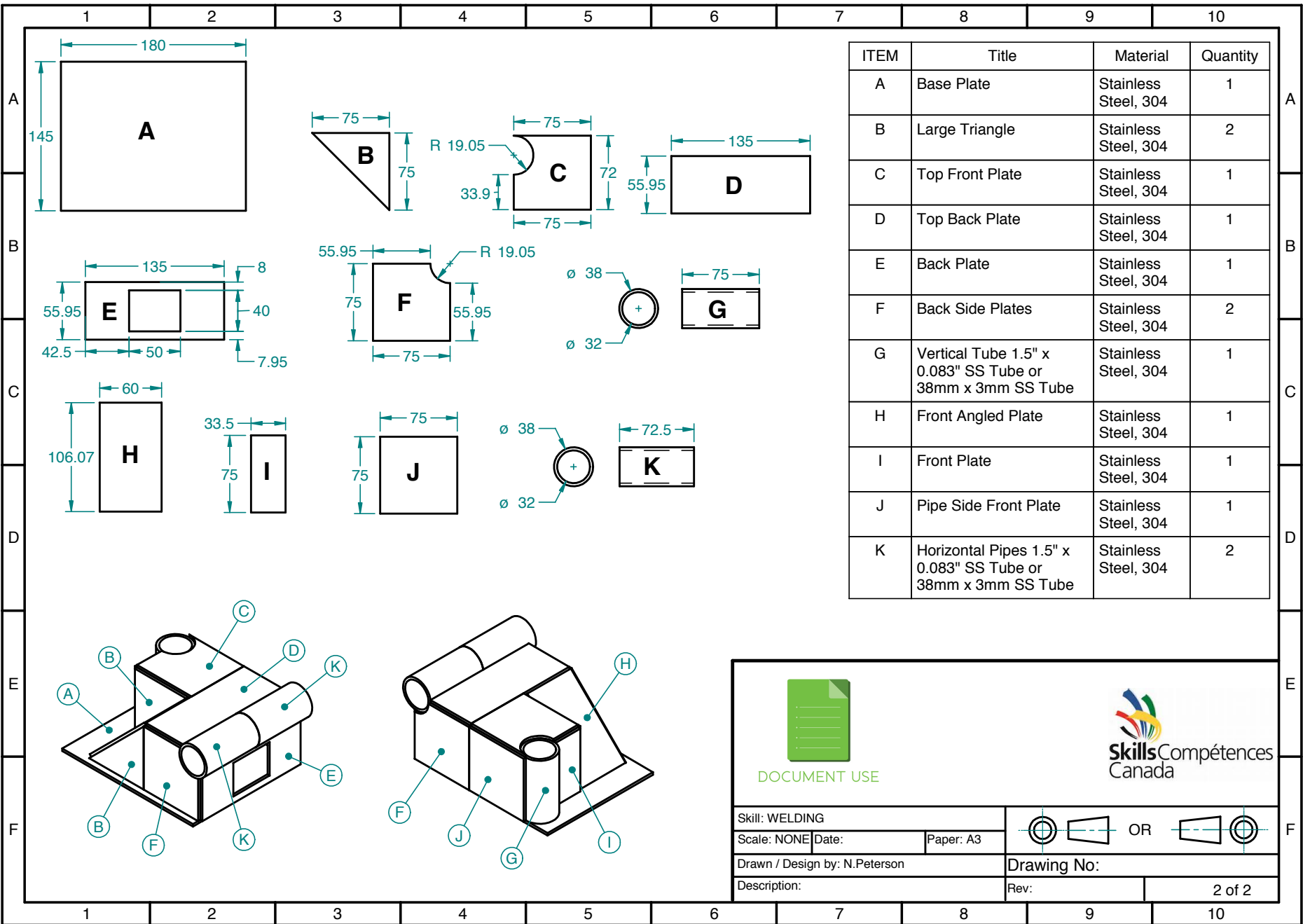


DOCUMENT USE



Skill: WELDING			
Scale: NONE	Date:		
Drawn / Design by: N.Peterson		Drawing No:	
Description:		Rev:	1 of 2

1 2 3 4 5 6 7 8 9 10



DOCUMENT USE



Skill: WELDING			
Scale: NONE	Date:	Paper: A3	
Drawn / Design by: N.Peterson		Drawing No:	
Description:		Rev:	2 of 2