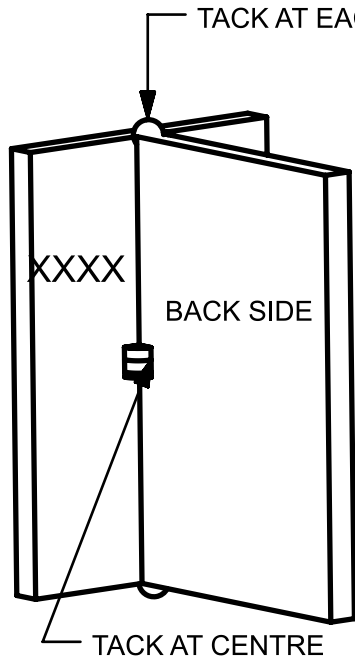


1 2 3 4 5 6

A



FILLET WELD COUPON 1B

MATERIAL: CARBON STEEL PLATE
(ASTM A36/ IS 2062 GR B/EQUIVALENT)

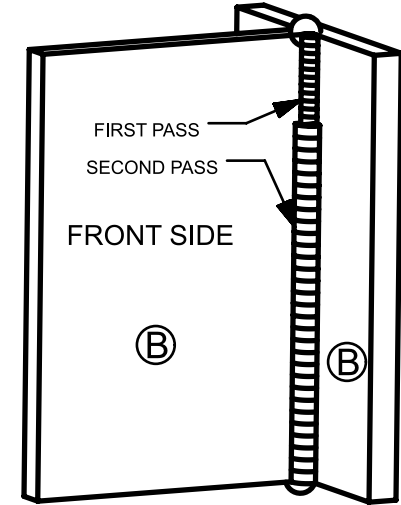
DIMENSION: 250 X 100 X 8 (10) mm

WELDING PROCESS: MMAW

WELDING POSITION: 3F/PF (UPHILL)

CONSUMABLE: E7018 DIA 2.5 mm/ 3.2 mm
(AWS A5.1)

EVALUATION: BREAK TEST (ISO 9606)



A

B

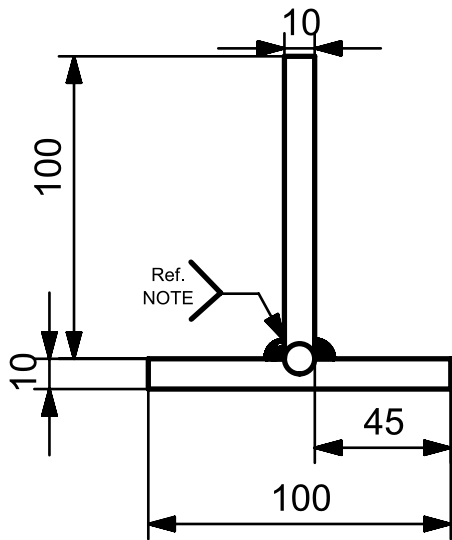
B

NOTE:

1. WELD TO BE DEPOSITED WITH 2 RUNS.
2. COMPLETION TIME 30 MINS.
3. TACK WELDS ARE TO BE NOT LONGER THAN 15 mm
4. EDGE PREPARATION MUST REMIAN AT 90° TO THE PLATE FACE. NO CHAMFER AND GAP ALLOWED.
5. MMAW PROCESS AND ANY POSITION MAY BE USED FOR TACK WELDING.
6. ALL POSITION MUST BE PROPERLY TACKED BEFORE ANY WELDING COMMENECES AS INDICATED.
7. JOINTS MUST BE WELDED IN POSITION AS INDICATED.
8. GRINDING IS NOT ALLOWED FOR CLEANING OF FINAL SURFACES OF WELDS. IT CAN ONLY BE DONE TO CLEAN THE BASE PLATES
9. XXXXX = Competitor's ID

C

C



TOP VIEW

D

D

NWL 2020

| | |
|---|-------------------|
| Skill: Welding | |
| Scale: N. T. S | Date: 07 Mar 2020 |
| Designed by: RAKESH D (CVRCE), T K BHATTACHARYA (CVRCE) | |
| Description: Module I- Mains (Fillet) | |
| SHEET 1 OF 1 | |
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| | | |
|---|--------------|---|
| B | CARBON STEEL | 2 |
| ALL DIMENSIONS IN MM | | |
| Test Project for Mains Module I The 2 nd National Welding League of Women Students in WCoE, CVRCE, Bhubaneswar | | |
| FILLET WELD COUPON | | |
| Drawing Number | | |
| NWL2_M1_DAY2_GENERIC | | |

1 2 3 4 5 A4