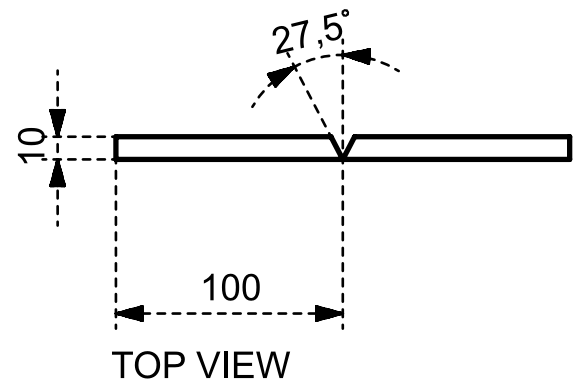


**BUTT WELD COUPON 2B**  
 MATERIAL: CARBON STEEL PLATE  
 (ASTM A36/ IS 2062 GR B/EQUIVALENT)  
 DIMENSION: 250 X 100 X 8 (10) mm  
 WELDING PROCESS: GMAW/135  
 WELDING POSITION: 3G/PF (UPHILL)  
 CONSUMABLE: ER-70S-6  
 DIA 0.9 mm/ 1.2 mm  
 (AWS A5.18)

**EVALUATION: RADIOGRAPHY / BEND TEST**

**NOTE:**

1. SINGLE V PREPARATION WITH INCULDED ANGLE BETWEEN 55° - 65° AS PER WELDER CHOICE
2. ROOT GAP AND ROOT FACE AS PER WELDER CHOICE.
3. COMPLETION TIME: 40 Mins
4. MAXIMUM TACK LENGTH: 15 mm
5. GMAW PROCESS AND ANY POSITION MAY BE USED FOR TACK WELDING.
6. ALL POSITION MUST BE TACKED AS INDICATED BEFORE ANY WELDING COMMENCES.
7. JOINTS MUST BE WELDED IN POSITION AS INDICATED.
8. GRINDING IS ALLOWED FOR RESTART POINT ON ROOT PASS ONLY, NOT ON HOT PASS OR CAPPING RUN.
9. XXXXX = Competitor's ID



**NWL 2020**

Skill: Welding	
Scale: N. T. S	Date: 07 Mar 2020
Designed by: RAKESH D (CVRCE), T K BHATTACHARYA (CVRCE)	
Description: Module II- Mains ( Plates)	
<b>SHEET 1 OF 1</b>	
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B	CARBON STEEL	2 (27.5 deg. MILLED BEVEL)
ALL DIMENSIONS IN MM		
<b>Test Project for Mains Module II</b> The 2 <sup>nd</sup> National Welding League of Women Students in WCoE, CVRCE, Bhubaneswar		
<b>BUTT WELD COUPON</b>		
Drawing Number		
<b>NWL2_M2_DAY2_GENERIC</b>		