

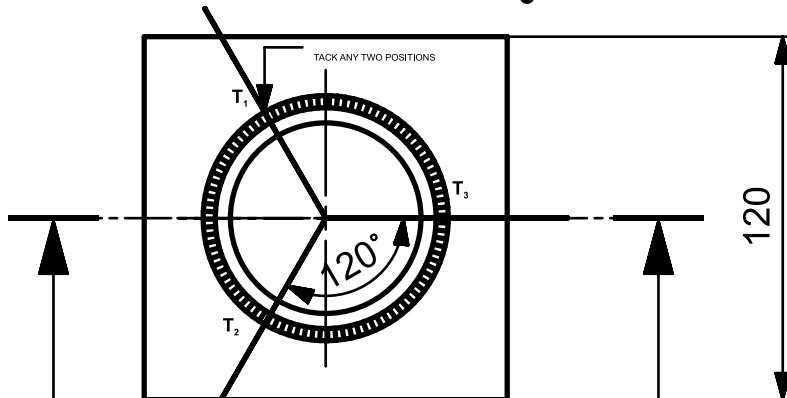
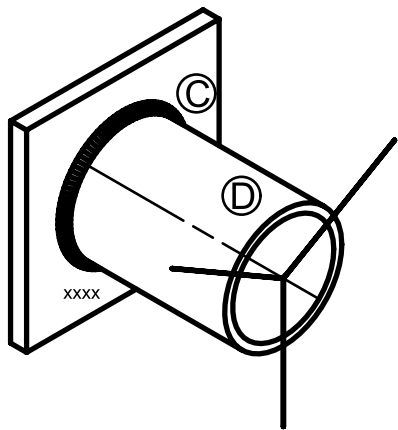
1 2 3 4 5 6

A

B

C

D



A

A

B

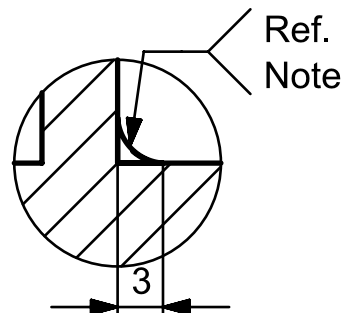
FILLET WELD COUPON 1C

MATERIAL C: CARBON STEEL PLATE
 (ASTM A36/ IS 2062 GR B/EQUIVALENT)
 MATERIAL D: CARBON STEEL PIPE / 73 OD
 (ASTM A106 GR B/API 5L/ EQUIVALENT)
 DIMENSION C: 120 X 120 X 8 (10) mm
 DIMENSION D: 73 OD X 100 (L) X 5 (T)
 WELDING PROCESS: TIG
 WELDING POSITION: 5F/PH (UPHILL)
 CONSUMABLE: ER-70 S2 DIA 2.4 mm (AWS A5.18)
 & TUNGSTEN (2% THORIATED)
 DIA 2.4 mm & 3.2 mm

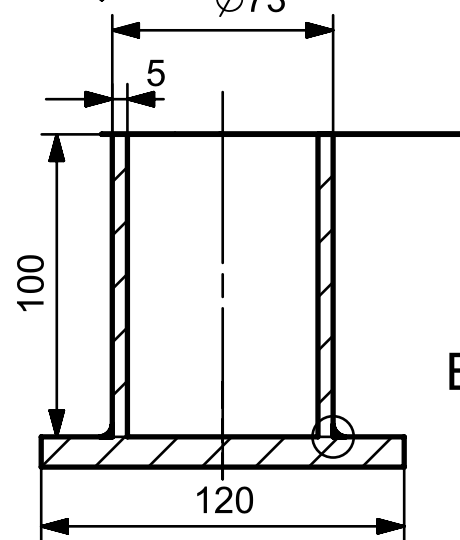
EVALUATION: VISUAL

NOTE:

1. WELD TO BE DEPOSITED WITH 1 RUN ONLY.
2. FILLET WELD SIZE = 3 mm (+2.0/-1 mm)
3. COMPLETION TIME 30 MINS.
4. TACK AT ANY TWO POSITIONS FROM T₁, T₂ & T₃ AND START FROM THE THIRD
5. TACK WELDS ARE TO BE NOT LONGER THAN 10 mm (+2.0/-0 mm)
6. EDGE PREPARATION MUST REMIAN AT 90° TO THE PLATE FACE. NO CHAMFER AND GAP ALLOWED.
7. TIG PROCESS AND ANY POSITION MAY BE USED FOR TACK WELDING.
8. ALL POSITION MUST BE PROPERLY TACKED BEFORE ANY WELDING COMMENECES AS INDICATED.
9. JOINTS MUST BE WELDED IN POSITION AS INDICATED.
10. GRINDING IS NOT ALLOWED FOR CLEANING OF FINAL SURFACES OF WELDS. IT CAN ONLY BE DONE TO CLEAN THE BASE PLATES
11. XXXX = Competitor's ID



DETAIL B
SCALE 2:1



SECTION A-A

C	CARBON STEEL PLATE	1
D	CARBON STEEL PIPE	1

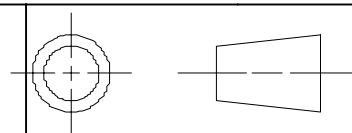
NWL 2020

Skill: Welding	
Scale: N. T. S	Date: 07 Mar 2020
Designed by: RAKESH D (CVRCE), T K BHATTACHARYA (CVRCE)	
Description: Module III- Mains (Fillet)	
SHEET 1 OF 1	
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ALL DIMENSIONS IN MM

Test Project for Mains- Module III
 The 2nd National Welding League of Women Students in WCoE, CVRCE, Bhubaneswar

FILLET WELD COUPON



Drawing Number

NWL2_M3_DAY2_GENERIC

1 2 3 4 5 A4