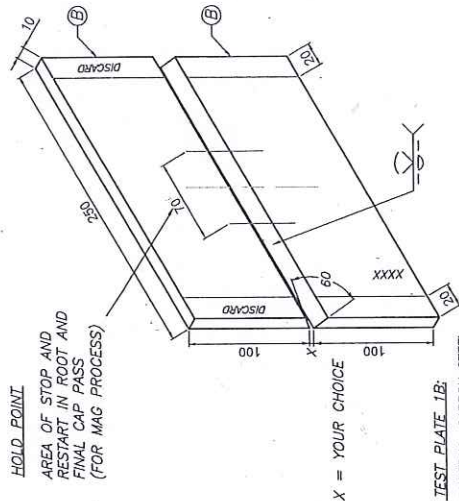


**TEST PIPE 1A:**  
MATERIAL: CARBON STEEL PIPE  
2 PCS Ø 114.3 OD x 8.56 WALL x 120 LONG

WELDING POSITION: PC  
ROOT PASS: TIG-141  
FILL and CAP: MAG-135

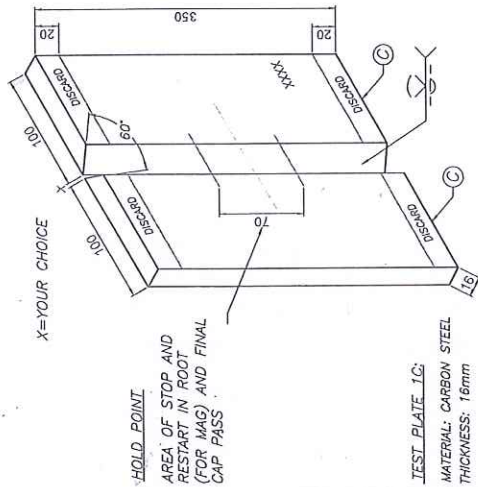
ASSESSMENT:  
VISUAL and X-RAY TEST



**TEST PLATE 1B:**  
MATERIAL: CARBON STEEL  
THICKNESS: 10mm

WELDING POSITION: PE  
ROOT PASS: MAG-135  
FILL and CAP: MAG-135

ASSESSMENT:  
VISUAL and X-RAY TEST  
(DISCARD 20mm of Each End)

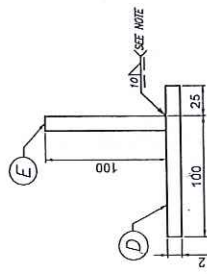


**TEST PLATE 1C:**  
MATERIAL: CARBON STEEL  
THICKNESS: 16mm

WELDING POSITION: PC  
ROOT PASS: MAG-135  
FILL and CAP: FCAW-136

ASSESSMENT:

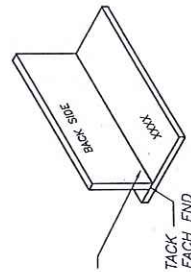
VISUAL and X-RAY TEST  
(DISCARD 20mm of Each End)



**TEST PLATE 1D:**  
MATERIAL: CARBON STEEL  
THICKNESS: 12mm

WELDING POSITION: PD  
WELDING PROCESS: FCAW-136

ASSESSMENT:  
VISUAL and BREAK TEST  
(DISCARD 25mm of Each End)



**NOTE:**  
-DEPOSIT A FILLET WELD ON THE FRONT SIDE OF THE JOINT WITH 10mm -0/+2 LEG LENGTH  
-WELD TO BE DEPOSITED WITH A MINIMUM OF 2 RUNS AND A MAXIMUM OF 3 RUNS  
-EDGE PREPARATION MUST REMAIN AT 90° TO THE PLATE FACE. NO GAP ALLOWED.

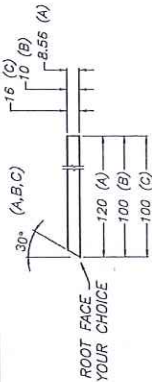
TACK WITH 25mm LENGTH MAXIMUM

TACK EACH END

# NOTES:

1. ANY PROCESS AND ANY POSITION MAY BE USED FOR TACKWELDING.
2. MAXIMUM LENGTH OF TACKS: 15mm
3. ALL PLATES OR PIPES ARE TO BE TACKWELDED BEFORE ANY WELDING COMMENCES.
4. TEST PLATES OR PIPES MUST BE WELDED IN THE POSITION AS INDICATED FOR EACH TEST.
5. PROCESS INDICATED FOR ROOT WELD TO BE USED ONLY FOR ONE RUN, NOT FOR SECOND AND SUBSEQUENT PASSES.
6. NO GRINDING OR FINISHING OF ANY KIND AFTER WELDING IS COMPLETED.
7. XXXX = CONTESTANT'S I.D.

DO NOT SCALE DRAWING



DETAIL OF MILLED BEVEL

ALL MATERIAL CARBON STEEL (CS) and ALL DIMENSIONS IN MILLIMETRES

Item	Qty.	Material	Description	Notes
E 1	1	CS	Plate 12 x 100 x 250	
D 1	1	CS	Plate 12 x 125 x 250	
C 2	2	CS	Plate 16 x 100 x 350	MILLED BEVEL 30°
B 2	2	CS	Plate 10 x 100 x 250	MILLED BEVEL 30°
A 2	2	CS	Pipe x Ø114.3 x 8.56 wall x 120	MILLED BEVEL 30°