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Welding Procedure Specification

WPS No. WPS 110 Revision 3 Date 03/06/2025 By MTC

Authorized By MTC Date 03/10/2025 Prequalified ■

Welding Process(es) GMAW Type: Manual Machine ☐ Semi-Auto ■ Auto ☐

Supporting PQR(s) Prequalified

JOINT

Type T-Joint / Corner

Backing Yes ☐ No ■ Single Weld ■ Double Weld ☐

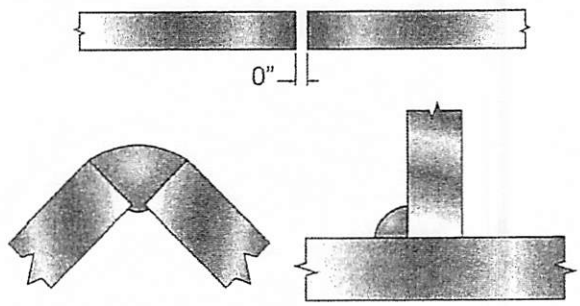
Backing Material N/A

Root Opening 0 Root Face Dimension 0

Groove Angle 30-90 Radius (J-U) N/A

Back Gouge Yes ☐ No ■

Method N/A



BASE METALS

Material Spec. A 36 to A 36

Type or Grade to

Thickness: Groove ( ) Unlimited - N/A

Fillet (in) Unlimited -

Diameter (Pipe,) N/A - N/A

FILLER METALS

AWS Specification A5.18

AWS Classification ER70S-6

SHIELDING

Flux N/A

Electrode-Flux (Class) N/A

Gas M20-ARC-25

Composition 75% ARGON / 25% C02

Flow Rate 35-45 CFH

Gas Cup Size 3/4 in.

PREHEAT

Preheat Temp., Min. 60 Deg.F

Thickness Up to 3/4" Temperature N/A

Over 3/4" to 1-1/2" N/A

Over 1-1/2" to 2-1/2" N/A

Over 2-1/2" N/A

Interpass Temp., Min. N/A Max. N/A

POSITION

Position of Groove All Fillet All

Vertical Progression: ■ Up ☐ Down

ELECTRICAL CHARACTERISTICS

Transfer Mode (GMAW):

Short-Circuiting ■ Globular ☐ Spray ☐

Current: AC DCEP ☐ DCEN ☐ Pulsed ☐

Other N/A

Tungsten Electrode (GTAW):

Size

TECHNIQUE

Stringer or Weave Bead Stringer

Multi-pass or Single Pass (per side) Multiple/Single

Number of Electrodes 1

Electrode Spacing: Longitudinal N/A

Lateral N/A

Angle N/A

Contact Tube to Work Distance 1/4" - 1/2"

Peening N/A

Interpass Cleaning

POSTWELD HEAT TREATMENT

PWHT Required ☐

Temp. N/A Time N/A

WELDING PROCEDURE

Layer/Pass	Process	Filler Metal Class	Diameter	Cur. Type	Amps	Volts	Travel Speed	Other Notes
ALL	GMAW	ER70S-6	0.035"	DC	90-150	16-21V	4-8 ipm	WFS 140-350 IPM

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Welding Procedure Specification

WPS 108

WPS No. WPS 108 Revision 2 Date 03/06/2025 By MTC

Authorized By EN Date 4/19/2016 Prequalified ■

Welding Process(es) FCAW-G Type: Manual ☐ Machine ☐ Semi-Auto ■ Auto ☐

Supporting PQR(s) Prequalified

JOINT

Type T-Joint, Butt, Flanged

Backing Yes ☐ No ■ Single Weld ■ Double Weld ■

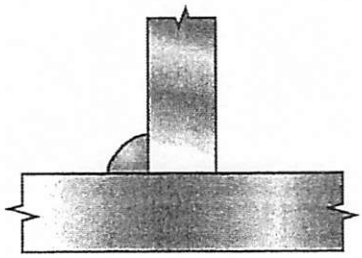
Backing Material N/A

Root Opening 0 Root Face Dimension N/A

Groove Angle N/A Radius (J-U) N/A

Back Gouge Yes ☐ No ■

Method N/A



BASE METALS

Material Spec. A-36 to A-36

Type or Grade to

Thickness: Groove ( ) Unlimited - N/A

Fillet (in) Unlimited -

Diameter (Pipe,) N/A - N/A

FILLER METALS

AWS Specification A5.20

AWS Classification E71T-1

SHIELDING

Flux: N/A

Electrode-Flux (Class): N/A

Gas

Composition: 75%Argon/25%CO2

Flow Rate: 35-45 CFH

Gas Cup Size: 1/2" - 3/4"

PREHEAT

Preheat Temp., Min. 60 Deg.F

Thickness Up to 3/4" Temperature N/A

Over 3/4" to 1-1/2" N/A

Over 1-1/2" to 2-1/2" N/A

Over 2-1/2" N/A

Interpass Temp., Min. N/A Max. N/A

POSITION

Position of Groove All Fillet All

Vertical Progression: ■ Up ☐ Down

ELECTRICAL CHARACTERISTICS

Transfer Mode (GMAW):

Short-Circuiting ☐ Globular ☐ Spray ☐

Current: AC ☐ DCEP ■ DCEN ☐ Pulsed ☐

Other N/A

Tungsten Electrode (GTAW):

Size N/A Type N/A

TECHNIQUE

Stringer or Weave Bead Both

Multi-pass or Single Pass (per side) Multiple/Single

Number of Electrodes 1

Electrode Spacing: Longitudinal N/A

Lateral N/A

Angle N/A

Contact Tube to Work Distance 1/2" to 3/4"

Peening N/A

Interpass Cleaning Chip slag and wire brush

POSTWELD HEAT TREATMENT

PWHT Required ☐

Temp. N/A Time N/A

WELDING PROCEDURE

Layer/Pass	Process	Filler Metal Class	Diameter	Cur. Type	Amps	Volts	Travel Speed	Other Notes
All	FCAW-G	E71T-1	0.045	DCEP	200-260	20-26	5-12	WFS:200-500ipm

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Welding Procedure Specification

WPS 103

WPS No. WPS 103 Revision 3 Date 01/03/2023 By CRV

Authorized By GH Date 5/15/2011 Prequalified ■

Welding Process(es) GTAW Type: Manual ■ Machine ☐ Semi-Auto ☐ Auto ☐

Supporting PQR(s) Prequalified

JOINT

Type T-Joint / Corner

Backing Yes ☐ No ■ Single Weld ■ Double Weld ☐

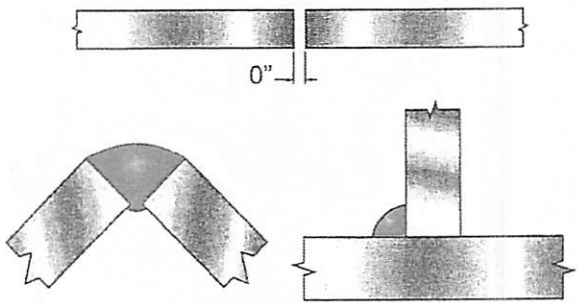
Backing Material N/A

Root Opening 0 Root Face Dimension 0

Groove Angle 30-90 Radius (J-U) N/A

Back Gouge Yes ☐ No ■

Method N/A



BASE METALS

Material Spec. 3003 to 3003

Type or Grade to

Thickness: Groove ( ) Unlimited - N/A

Fillet (in) Unlimited -

Diameter (Pipe,) N/A - N/A

FILLER METALS

AWS Specification A5.10

AWS Classification ER4043

SHIELDING

Flux N/A

Electrode-Flux (Class) N/A

Gas 100%Argon

Composition 100%Argon

Flow Rate 15-25 CFH

Gas Cup Size 3/8" Min. (#6)

PREHEAT

Preheat Temp., Min. 60 Deg.F

Thickness Up to 3/4" Temperature N/A

Over 3/4" to 1-1/2" N/A

Over 1-1/2" to 2-1/2" N/A

Over 2-1/2" N/A

Interpass Temp., Min. N/A Max. N/A

POSITION

Position of Groove All Fillet All

Vertical Progression: ■ Up ☐ Down

ELECTRICAL CHARACTERISTICS

Transfer Mode (GMAW):

Short-Circuiting ☐ Globular ☐ Spray ☐

Current: AC ■ DCEP ☐ DCEN ☐ Pulsed ☐

Other N/A

Tungsten Electrode (GTAW):

Size 3/32" - 1/8" Type EWCe2

TECHNIQUE

Stringer or Weave Bead Stringer

Multi-pass or Single Pass (per side) Multiple/Single

Number of Electrodes 1

Electrode Spacing: Longitudinal N/A

Lateral N/A

Angle N/A

Contact Tube to Work Distance N/A

Peening N/A

Interpass Cleaning

POSTWELD HEAT TREATMENT

PWHT Required ☐

Temp. N/A Time N/A

WELDING PROCEDURE

Layer/Pass	Process	Filler Metal Class	Diameter	Cur. Type	Amps	Volts	Travel Speed	Other Notes
All	GTAW	ER4043	1/16"	AC	100-175	N/A	4-8 ipm	AC Bal. 65-75%EN
								AC Hz. 60 - 120
All	GTAW	ER4043	3/32"	AC	100-175	N/A	4-8 ipm	AC Bal. 65-75%EN
								AC Hz. 60 - 120

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Welding Procedure Specification

WPS 101

WPS No. WPS 101 Revision 4 Date 03/06/2025 By MTC

Authorized By EN Date 2/3/2020 Prequalified ■

Welding Process(es) SMAW Type: Manual ■ Machine ☐ Semi-Auto ☐ Auto ☐

Supporting PQR(s) Prequalified

JOINT

Type Single V Groove

Backing Yes ■ No ☐ Single Weld ■ Double Weld ☐

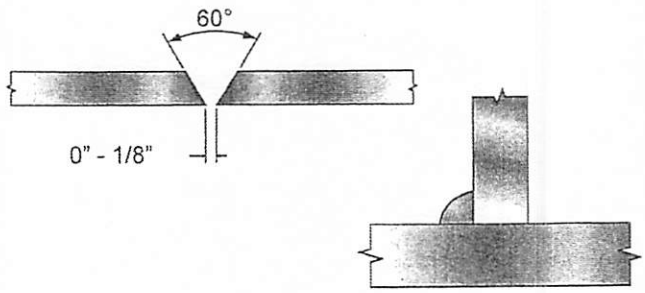
Backing Material A-36

Root Opening 0"+1/16" Root Face Dimension 0"

Groove Angle 45 Deg. Radius (J-U) N/A

Back Gouge Yes ☐ No ■

Method N/A



BASE METALS

Material Spec. A-36 to A-36

Type or Grade to

Thickness: Groove (in) 1/8 - 3/4

Fillet ( ) Any - All

Diameter (Pipe, in) 4 - Unlimited

FILLER METALS

AWS Specification A5.1

AWS Classification E-7018

SHIELDING

Flux N/A

Electrode-Flux (Class) N/A

Gas N/A

Composition N/A

Flow Rate N/A

Gas Cup Size N/A

PREHEAT

Preheat Temp., Min. 60 Deg.F

Thickness Up to 3/4" Temperature N/A

Over 3/4" to 1-1/2" N/A

Over 1-1/2" to 2-1/2" N/A

Over 2-1/2" N/A

Interpass Temp., Min. N/A Max. N/A

POSITION

Position of Groove 1G,2G,3G,4G,5G Fillet 1F,2F,3F,4F,5F

Vertical Progression: ■ Up ☐ Down

ELECTRICAL CHARACTERISTICS

Transfer Mode (GMAW):

Short-Circuiting ☐ Globular ☐ Spray ☐

Current: AC ☐ DCEP ■ DCEN ☐ Pulsed ☐

Other N/A

Tungsten Electrode (GTAW):

Size N/A Type N/A

TECHNIQUE

Stringer or Weave Bead Either

Multi-pass or Single Pass (per side) Single / Multiple

Number of Electrodes 1

Electrode Spacing: Longitudinal N/A

Lateral N/A

Angle N/A

Contact Tube to Work Distance N/A

Peening N/A

Interpass Cleaning Chip slag and wire brush

POSTWELD HEAT TREATMENT

PWHT Required ☐

Temp. N/A Time N/A

WELDING PROCEDURE

Layer/Pass	Process	Filler Metal Class	Diameter	Cur. Type	Amps	Volts	Travel Speed	Other Notes
All	SMAW	E-7018	1/8	DCEP	90-150	N/A	4-10 ipm	
ALL	SMAW	E7018	3/32	DCEP	75 - 110	N/A	4 -10 IPM	

SkillsUSA Welding Sculpture

Contestant #: _____

Scoresheet Totals		
Category Item	**Points Scored**	**Points Possible**
Weld Test This test to be administered by MTC Faculty.		100
Notebook Judges score notebook based on formatting and contents. This includes verification letter, photos, and drawings.		200
Interview Judges score interviews based on knowledge and presentation. This includes professional conduct, flow of content, knowledge of project, and level of detail.		200
Sculpture Project Judges score the project based on fit up, welding, cutting and creativity. This includes forming technique, amount/function/quality of welds, function/quality of cuts, and level of difficulty/creativity/originality in the design.		500
Total Points Scored:		Out of 1000

SkillsUSA Welding Sculpture

Contestant #: _____

Design: Creativity The project should demonstrate creativity and innovation.		50
Design: Originality The project should be an original design.		50
Total Points Scored:		Out of 500
Comments:		

SkillsUSA Welding Sculpture

Contestant #: _____

Sculpture Project	Judges:	
Inspection Item	**Points Scored**	**Points Possible**
Metal Forming The project should be formed to match the theme of the design.		50
Weld: Fit and Function The weld joints should be fit properly and serve a function to the overall design.		50
Weld: Quantity Welded components should be incorporated as much as possible.		50
Weld: Quality Welds should demonstrate skill and professionalism.		50
Cutting: Function Cuts should be incorporated to serve the function and theme of the overall design.		50
Cutting: Quality Cuts should demonstrate skill and professionalism.		50
Design: Difficulty The project should exemplify skill and professionalism.		50
Design: Material Usage The project should incorporate various materials and processes in innovative ways.		50

SkillsUSA Welding Sculpture

Contestant #: _____

Interview	Judges:	
Inspection Item	**Points Scored**	**Points Possible**
Presentation/Professionalism The student should begin with a greeting, explain the project in detail, answer questions in a professional manner (make eye contact, speak clearly), and end with a closing statement.		50
Knowledge of Project The student should be knowledgeable about the project, and able to answer questions regarding design, fabrication, and methods used in construction.		100
Level of Detail The student should be very detailed in responses. All questions should be answered fully.		50
Total Points Scored:		Out of 200
Comments:		

SkillsUSA Welding Sculpture

Contestant #: _____

Notebook	Judges:	
Inspection Item	**Points Scored**	**Points Possible**
Notebook Formatting: Notebook should have Table of Contents, Verification Letters, Photos, and Drawings		10
Verification Letter: Each of the following are worth 4 points: • School letterhead • Construction by student • Itemized Expenses • School, City, State, Advisor • Time on each Process		20
Photos (10 minimum): Photos of student creating the project, with captions explaining the process.		100
Concept Drawings: Drawings used to develop the initial theme and design.		25
Final Drawings: These drawings should include final dimensions/templates.		25
Supporting Documents: Additional photos of process, design, cutting, welding, forming; explanation of creative use of process, etc.		20
Total Points Scored:		Out of 200
Comments:		

SkillsUSA Welding Sculpture

Contestant #: _____

3F SMAW T-Joint	Judge:	
Inspection Item	**Points Scored**	**Points Possible**
7018 1/4" Fillet Quality The weld must tie into each plate with no evidence of incomplete fusion, undercut, porosity, or slag inclusions. The profile of the bead should be as flat as possible and uniform for the entirety of the joint.		25
7018 1/4" Fillet Size The weld shall have equal 1/4" legs.		25
7018 3/8" Fillet Quality The weld must tie into each plate with no evidence of incomplete fusion, undercut, porosity, or slag inclusions. The profile of the bead should be as flat as possible and uniform for the entirety of the joint.		25
7018 3/8" Fillet Size The weld shall have equal 3/8" legs.		25
Total Points Scored:		Out of 100
Comments:		

Welding Sculpture State Competition Schedule - March 26th and 27th

Time	Item	Item Description
March 26th		
5:00pm – 6:00pm	Welcome/Registration/Welding Shop Walkthrough	Welcome competitors to the competition, ensure all are present, conduct a review of the competition rules in WTC room 106 Competitors can get familiar with their workstation that they will use at the competition.
6:00pm – 7:00 pm	Welding Competition	Welding Sculpture competition competitors will begin the welding Project. Upon completion competitors clean up the area and move the project to the judging area.
7:00p.m. – 7:30p.m.	Final Booth Check	Competitors will have their booth checked to verify it has been properly cleaned and they can move all personal equipment back to their vehicle.
7:30p.m.	Adjourn	
March 27th		
10:00a.m. – 12:00p.m.	Sculpture Interviews	Competitors will present their sculpture projects to the judges. Judges will also have a series of questions for the competitors.
1:00 p.m. - 2:00 p.m.	Lunch from Hudson's BBQ	
2:30pm – 3:00p.m.	Awards and Adjourn	

SC SkillsUSA Welding Fabrication

Team # _____

Scoresheet Totals		
Category Item	**Points Scored**	**Points Possible**
Judge #1 This judge scored the team's GMAW Quality, Teamwork, and overall project dimensions.		400
Judge #2 This judge scored the team's SMAW Quality, Safety Practices, and Project Distortion.		400
Overall Appearance Both judges score this category together. The finished assembly shall have a professional appearance. All welds should match the given procedure and the finished assembly should have no deviation from the provided drawing.		200
Total Points Scored:		Out of 1000

SC SkillsUSA Welding Fabrication

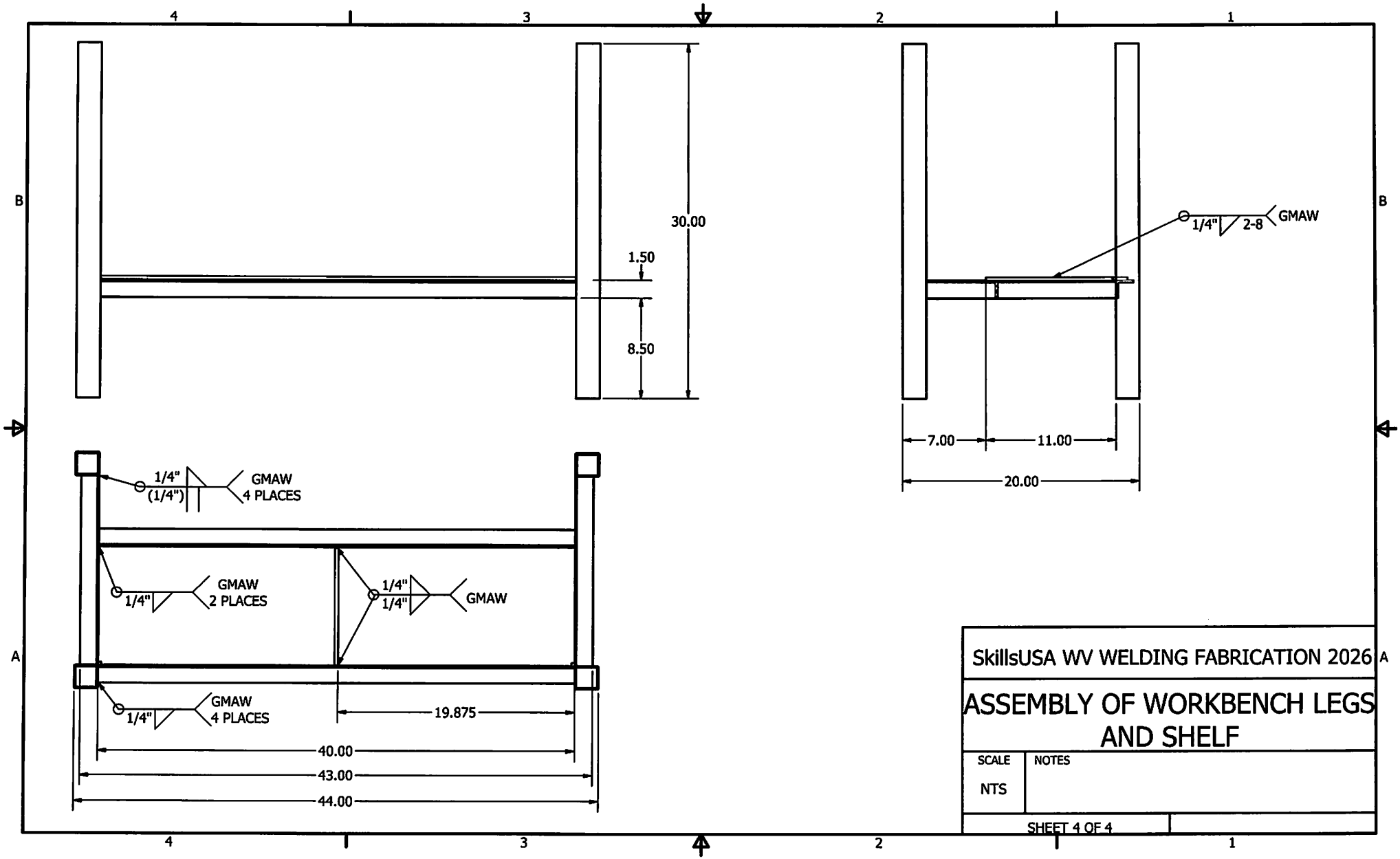
Team # _____

Judge # 2:		
Inspection Item	**Points Scored**	**Points Possible**
Teamwork The team should divide work evenly. Each member should contribute to the success of the team and work in a professional manner.		100
GMAW Quality The weld must tie into each side with no evidence of incomplete fusion, undercut, or porosity. Welds must meet the specified sizes.		200
Project Dimensions The finished assembly must measure in accordance with the provided drawing.		100
Total Points Scored:		Out of 400
Comments:		

SC SkillsUSA Welding Fabrication

Team # _____

Judge # 1:		
Inspection Item	**Points Scored**	**Points Possible**
Safety Appropriate PPE shall be worn AT ALL TIMES. Safe work practices shall also be employed. Contestants shall conduct themselves in a professional manner.		100
SMAW Quality The weld must tie into each side with no evidence of incomplete fusion, undercut, porosity, or slag inclusion. Welds must meet the specified sizes.		200
Distortion The finished assembly must have square corners and not have excessive welding or finishing to accommodate inaccurate measurements.		100
Total Points Scored:		Out of 400
Comments:		

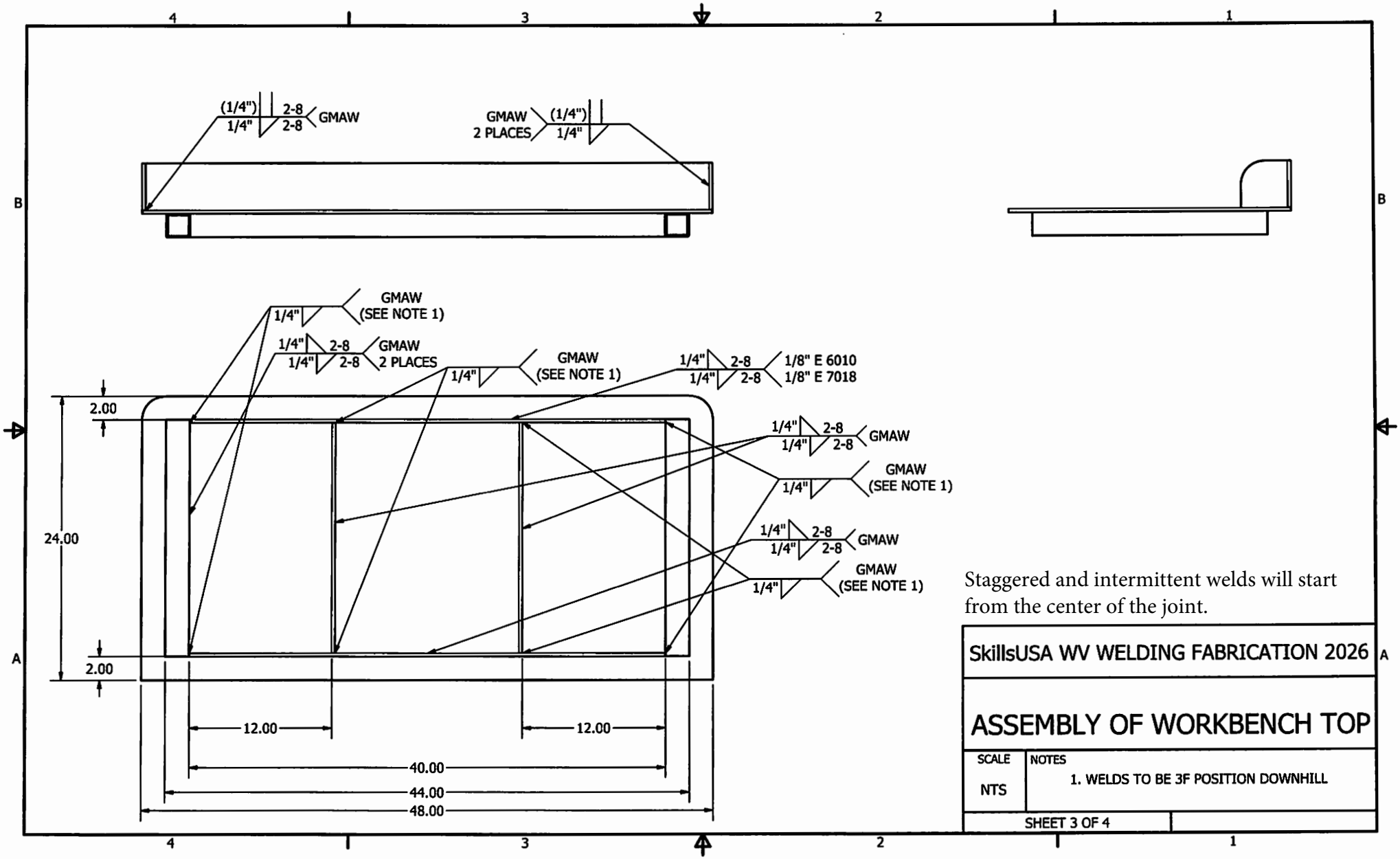


SkillsUSA WV WELDING FABRICATION 2026

ASSEMBLY OF WORKBENCH LEGS AND SHELF

SCALE	NOTES
NTS	

SHEET 4 OF 4



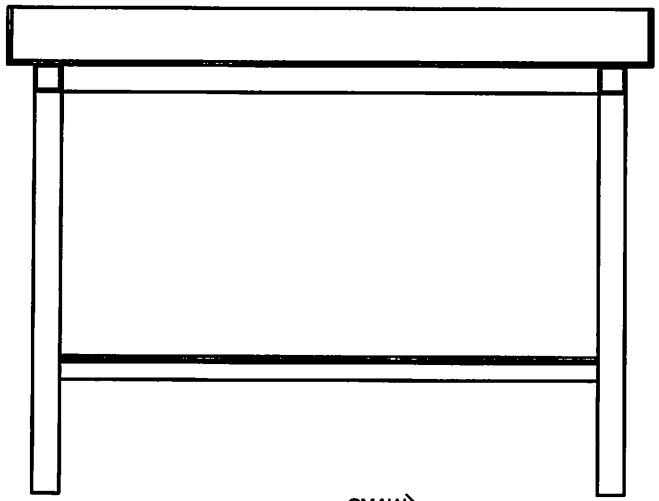
Staggered and intermittent welds will start from the center of the joint.

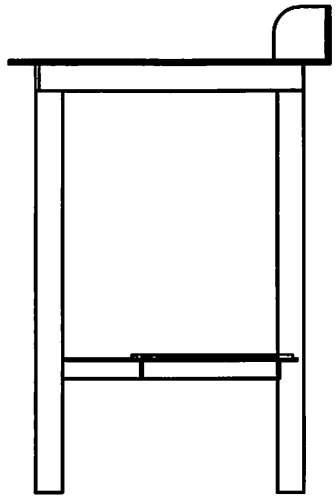
SkillsUSA WV WELDING FABRICATION 2026

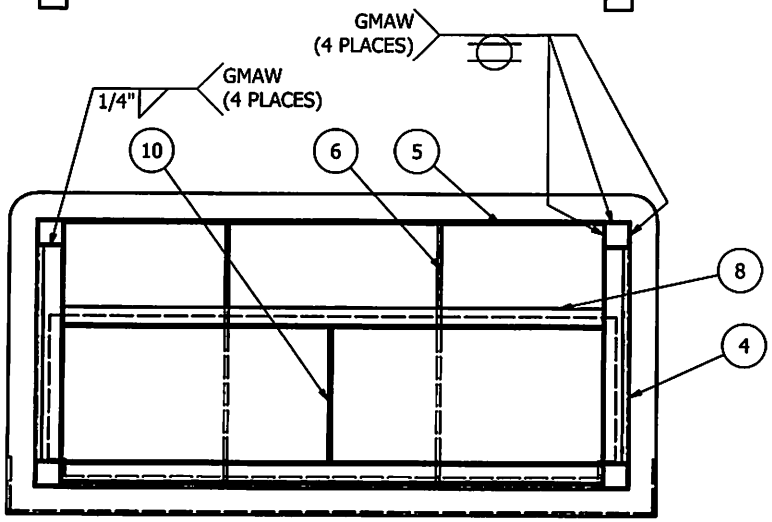
ASSEMBLY OF WORKBENCH TOP

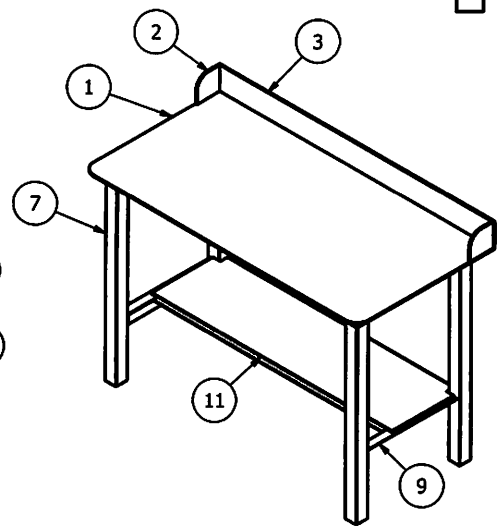
SCALE	NOTES
NTS	1. WELDS TO BE 3F POSITION DOWNHILL

SHEET 3 OF 4







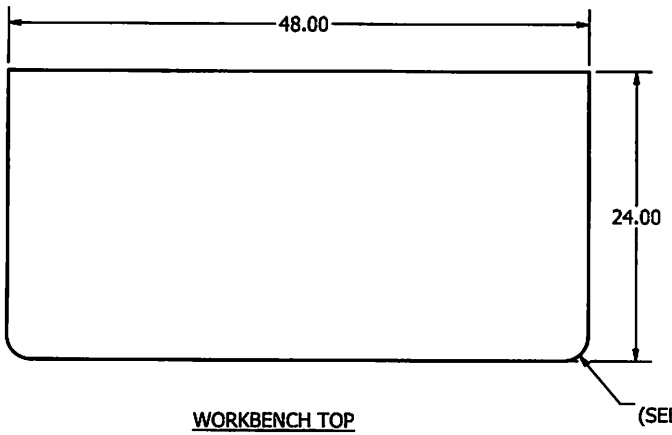


SkillsUSA WV WELDING FABRICATION 2026

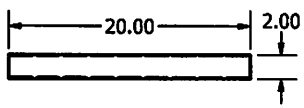
ASSEMBLY OF WORKBENCH

SCALE	NOTES
NTS	

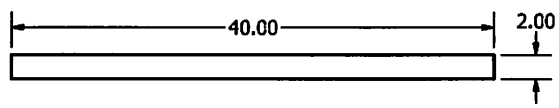
SHEET 2 OF 4



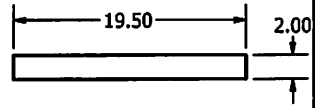
WORKBENCH TOP



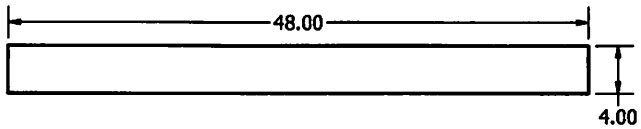
WORKBENCH FRAME



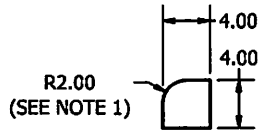
WORKBENCH FRAME 2



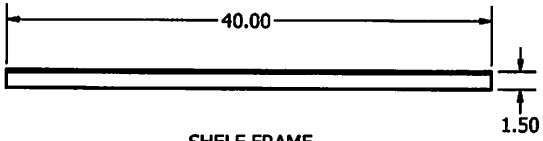
WORKBENCH FRAME 3



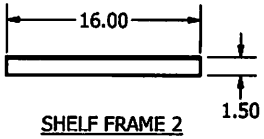
WORKBENCH BACK



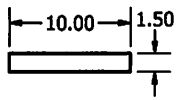
GUSSET



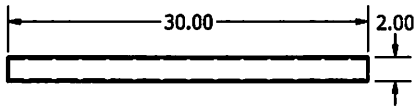
SHELF FRAME



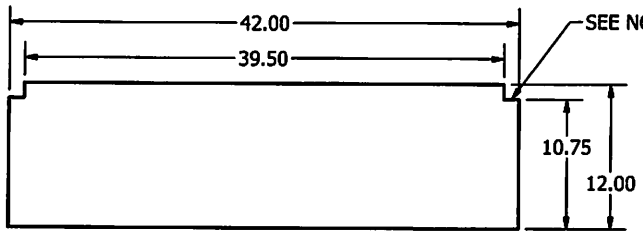
SHELF FRAME 2



SHELF FRAME 3



WORKBENCH LEG



SHELF

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	WORKBENCH TOP	1/4" PLATE
2	2	GUSSET	1/4" PLATE
3	1	WORKBENCH BACK	1/4" PLATE
4	2	WORKBENCH FRAME	2"X2"X1/8"
5	2	WORKBENCH FRAME 2	1/4" PLATE
6	2	WORKBENCH FRAME 3	1/4" PLATE
7	4	WORKBENCH LEG	2"X2"X1/8"
8	2	SHELF FRAME	1 1/2" X 1 1/2" X 3/16" ANGLE
9	2	SHELF FRAME 2	1 1/2" X 1 1/2" X 3/16" ANGLE
10	1	SHELF FRAME 3	1/4"PLATE
11	1	SHELF	1/4" PLATE

SkillsUSA WV WELDING FABRICATION 2026

PARTS DRAWINGS

SCALE
NTS

NOTES
1. USE OFC PROCESS
2. MATERIAL THICKNESS ¼" UNLESS OTHERWISE NOTED
3. 1/4" PLATE MAYBE CHANGED TO 3/16" PLATE DEPENDING ON AVAILABILITY & PRICE

Welding Fabrication State Competition Schedule – March 26th & 27th

Time	Item	Item Description
March 26th		
5:00pm – 7:30pm	Welding Shop Walkthrough	Competitors can get familiar with their workstation that they will use at the competition.
March 27th		
8:00 – 8:30 a.m.	Welcome/Roll Call	Welcome competitors to the competition, ensure all are present, conduct a review of the competition rules.
8:30 a.m. – 1:00 p.m.	Team Fabrication Competition	Complete the fabrication project from the prints and materials provided. Teams continue working on project upon completion competitors clean up the area and move the project to the judging area.
1:00 p.m. - 2:00 p.m.	Lunch from Hudson's BBQ	
2:00p.m. – 2:30p.m.	Final Booth Check and Move to Awards	Competitors will have their booth checked to verify they it has been properly cleaned and they can move all personal equipment back to their vehicle. They will then proceed to the auditorium for Awards
2:30pm – 3:00p.m.	Awards and Adjourn	

SC SkillsUSA Welding Singles

Competitor # _____

Scoresheet Totals		
Category Item	**Points Scored**	**Points Possible**
Steel Welding Project Steel assembly welded from a blueprint using SMAW and FCAW.		400
Aluminum Welding Project Aluminum assembly welded from a blueprint using GTAW.		400
Cutting Project Steel plate cut to specified dimensions using OFC.		200
Total Points Scored:		Out of 1000

SC SkillsUSA Welding Singles

Competitor # _____

Cutting Project Judge:		
Inspection Item	**Points Scored**	**Points Possible**
End Cut Cuts should be straight and square with minimal dross sticking to plate that is easily removed, and edges should be sharp, not rounded. Cuts should also have a smooth kerf face with minimal notching. All dimensions of completed product should measure in accordance with supplied print. No grinding is allowed.		50
Circle Cut Cuts should be straight and square with minimal dross sticking to plate that is easily removed, and edges should be sharp, not rounded. Cuts should also have a smooth kerf face with minimal notching. All dimensions of completed product should measure in accordance with supplied print. No grinding is allowed.		50
Square Cut Cuts should be straight and square with minimal dross sticking to plate that is easily removed, and edges should be sharp, not rounded. Cuts should also have a smooth kerf face with minimal notching. All dimensions of completed product should measure in accordance with supplied print. No grinding is allowed.		50
Slot Cut Cuts should be straight and square with minimal dross sticking to plate that is easily removed, and edges should be sharp, not rounded. Cuts should also have a smooth kerf face with minimal notching. All dimensions of completed product should measure in accordance with supplied print. No grinding is allowed.		50
Total Points Scored:		Out of 200

SC SkillsUSA Welding Singles

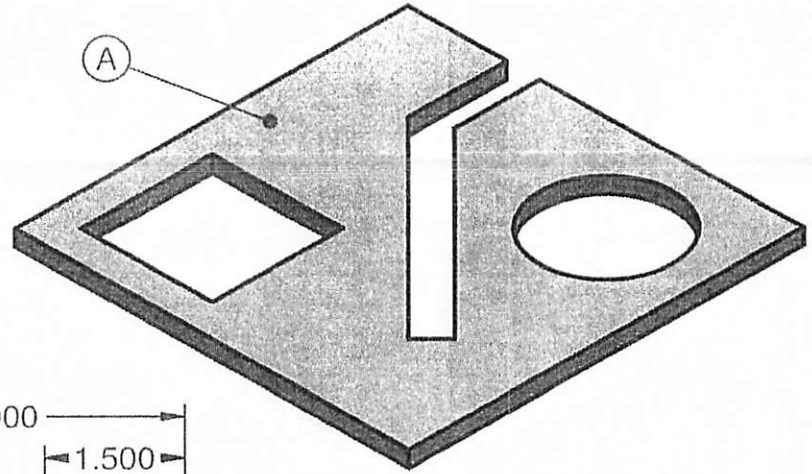
Competitor # _____

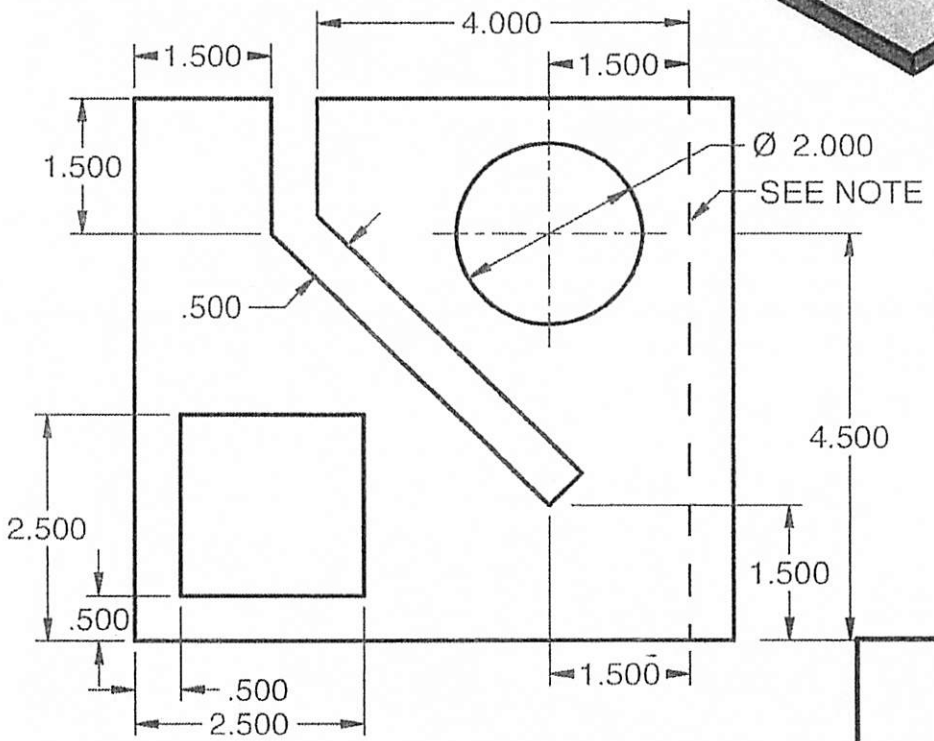
Aluminum Welding Project Judge:		
Inspection Item	**Points Scored**	**Points Possible**
Weld # 1 The weld must tie into each side with no evidence of incomplete fusion, undercut, porosity, or contamination. Welds must meet the specified sizes.		50
Weld # 2 The weld must tie into each side with no evidence of incomplete fusion, undercut, porosity, or contamination. Welds must meet the specified sizes.		50
Weld # 3 The weld must tie into each side with no evidence of incomplete fusion, undercut, porosity, or contamination. Welds must meet the specified sizes.		50
Weld # 4 The weld must tie into each side with no evidence of incomplete fusion, undercut, porosity, or contamination. Welds must meet the specified sizes.		50
Weld # 5 The weld must tie into each side with no evidence of incomplete fusion, undercut, porosity, or contamination. Welds must meet the specified sizes.		50
Weld # 6 The weld must tie into each side with no evidence of incomplete fusion, undercut, porosity, or contamination. Welds must meet the specified sizes.		50
Project Dimensions The finished assembly must measure in accordance with the provided drawing.		50
Overall Appearance The finished assembly shall have a professional appearance. All welds should match the given procedure and the finished assembly should have no deviation from the given drawing.		50
Total Points Scored:		Out of 400

SC SkillsUSA Welding Singles

Competitor # _____

Steel Welding Project Judge:		
Inspection Item	**Points Scored**	**Points Possible**
Weld # 1 The weld must tie into each side with no evidence of incomplete fusion, undercut, porosity, or slag inclusion. Welds must meet the specified sizes.		50
Weld # 2 The weld must tie into each side with no evidence of incomplete fusion, undercut, porosity, or slag inclusion. Welds must meet the specified sizes.		50
Weld # 3 The weld must tie into each side with no evidence of incomplete fusion, undercut, porosity, or slag inclusion. Welds must meet the specified sizes.		50
Weld # 4 The weld must tie into each side with no evidence of incomplete fusion, undercut, porosity, or slag inclusion. Welds must meet the specified sizes.		50
Weld # 5 The weld must tie into each side with no evidence of incomplete fusion, undercut, porosity, or slag inclusion. Welds must meet the specified sizes.		50
Weld # 6 The weld must tie into each side with no evidence of incomplete fusion, undercut, porosity, or slag inclusion. Welds must meet the specified sizes.		50
Project Dimensions The finished assembly must measure in accordance with the provided drawing.		50
Overall Appearance The finished assembly shall have a professional appearance. All welds should match the given procedure and the finished assembly should have no deviation from the given drawing.		50
Total Points Scored:		Out of 400





Item	Qty.	Description
A	1	0.25 x 6 x 6.5

ALL PROCESSES TO BE COMPLETED WITH THE MATERIALS PROVIDED

NOTE: PERFORM A SQUARE CUT ALONG DASHED LINE

SkillsUSA

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

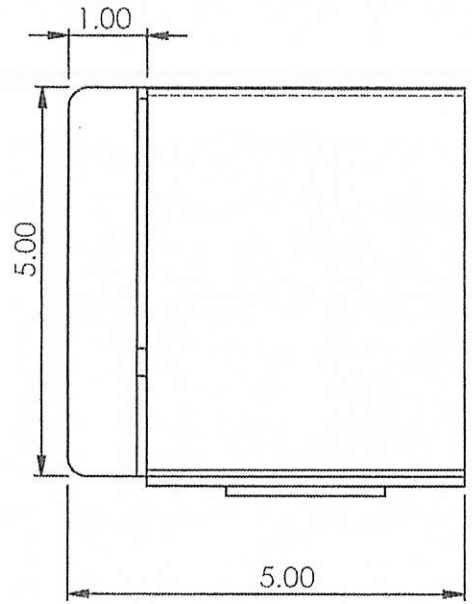
SkillsUSA Welding Contest

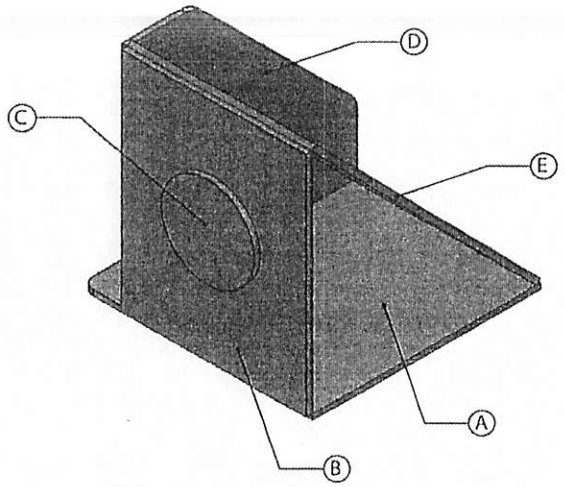
TITLE

PAC or OFC

SIZE A

SHEET 1 OF 1





ID	QTY.	DESC.
A	1	0.125 x 5 x 5
B	1	0.125 x 4 x 5
C	1	0.125 x 2 Dia.
D	1	0.125 x 5 x 5 Gusset
E	1	0.125 x 4 x 7

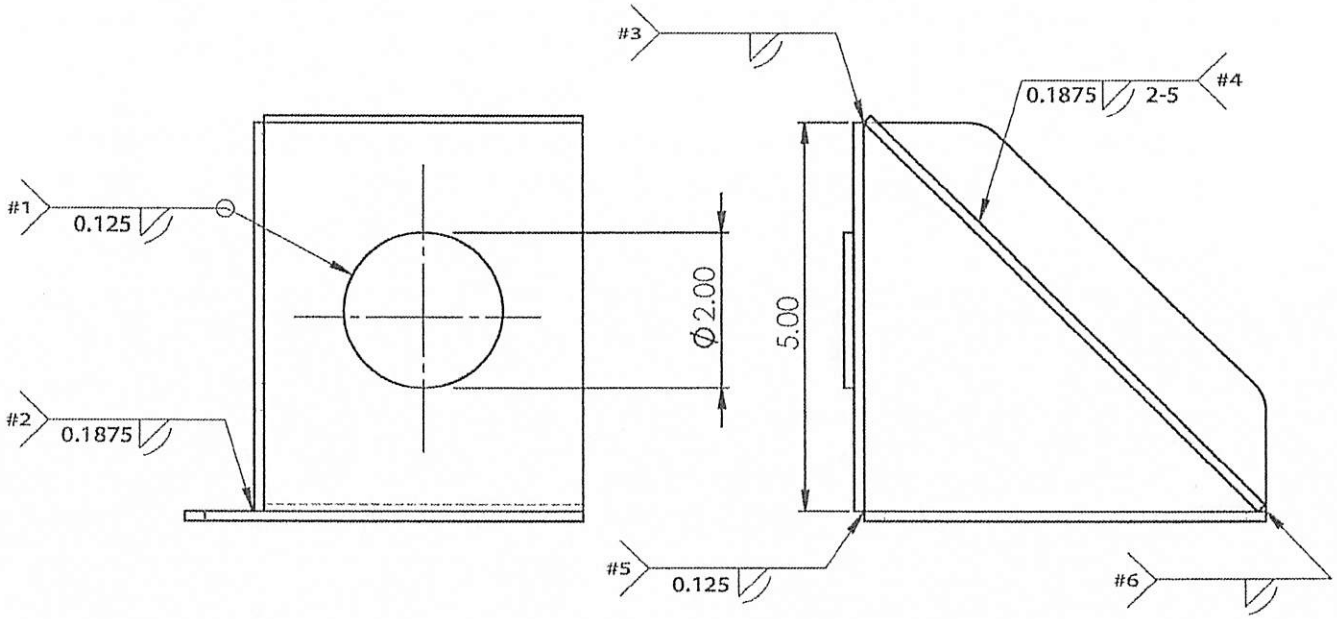
ALL PROCESSES TO BE COMPLETED WITH THE MATERIALS PROVIDED

1. TACK COMPLETE ASSEMBLY IN ANY POSITION.

2. WELDING TO BE COMPLETED WITH PLATE A FLAT TO THE TABLE

3. ALL VERTICAL WELDS TO BE WELDED IN THE UPHILL PROGRESSION.

4. NO POST WELD CLEANING ALLOWED



TITLE: STATE

SkillsUSA

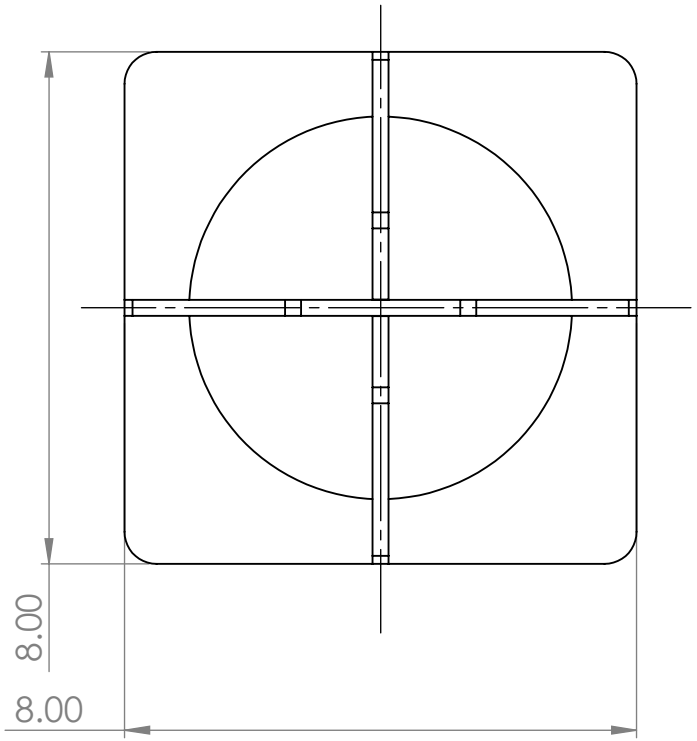
Welding Contest

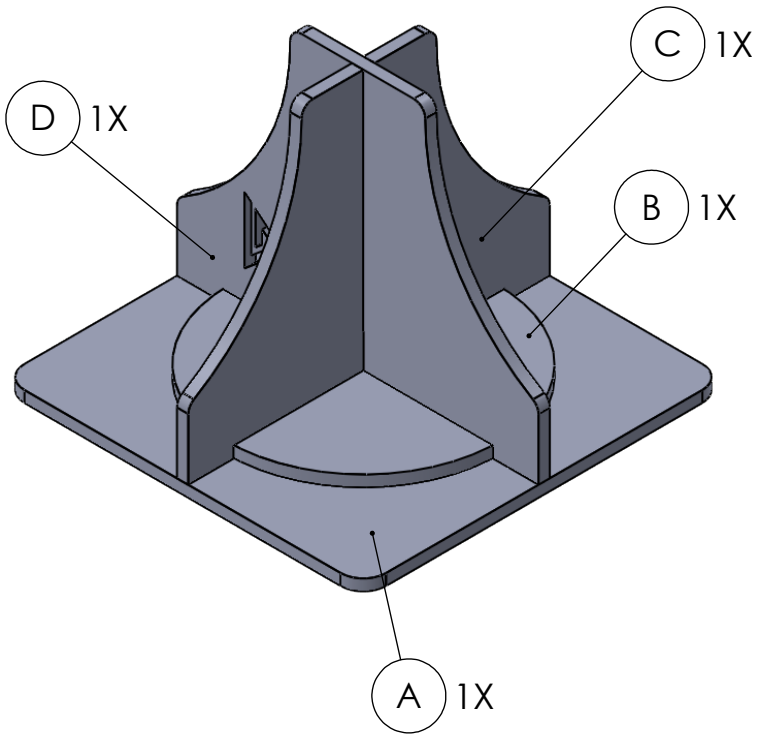
DWG. NO.

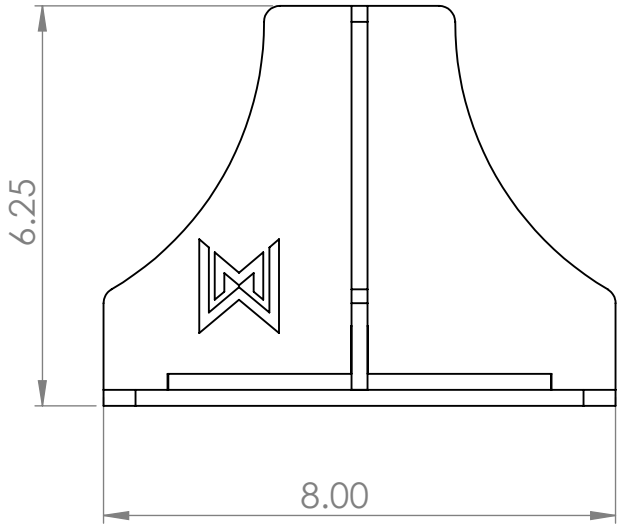
GTAW - Aluminum

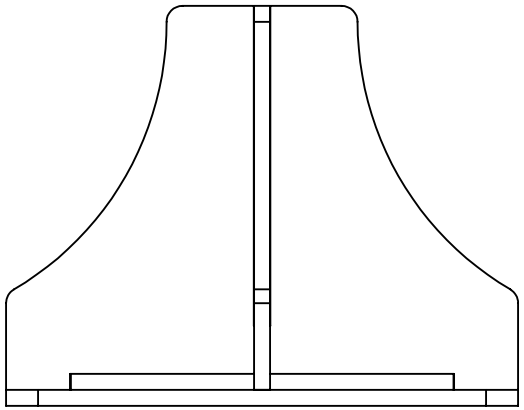
STATE SUSAT

SHEET 1 OF 1









Suggestion Notes.

1. Tack the complete project up before performing any welds.

2. Place tack welds on all corners joining any member meeting that corner.

3. To further challange your abilities plate A should remain in the flat position during welding.

4. Pay attention to weld sequence in order to cover up starts/stops and provide a visually appealing project.

TITLE:

Steel Practice Project

DWG. NO.

WS_ST1-4-14

Welding Singles State Competition Schedule - March 26th & 27th

Time	Item	Item Description
March 26th		
5:00pm – 7:30pm	Welding Shop Walkthrough	Competitors can get familiar with the workstation they will use during the competition.
March 27th		
8:00 – 8:30 a.m.	Welcome/Roll Call	Welcome competitors to the competition, ensure all are present, conduct a review of the competition rules.
8:30 a.m. - 1:00 p.m.	Welding Competition	Welding Singles competitors will begin FCAW/GMAW/SMAW Project. Upon completion they will proceed to Aluminum Project
1:00 p.m. - 2:00 p.m.	Lunch from Hudson's BBQ	
2:00p.m. – 2:30p.m.	Final Booth Check and Move to Awards	Competitors will have their booth checked to verify it has been properly cleaned and they can move all personal equipment back to their vehicle.
2:30pm – 3:00p.m.	Awards and Adjourn	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