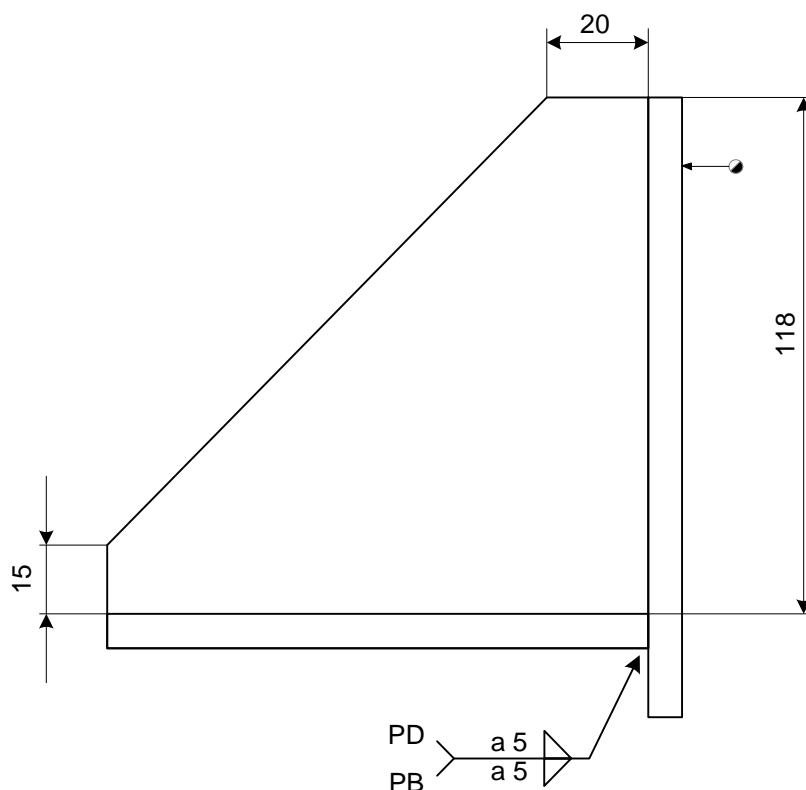
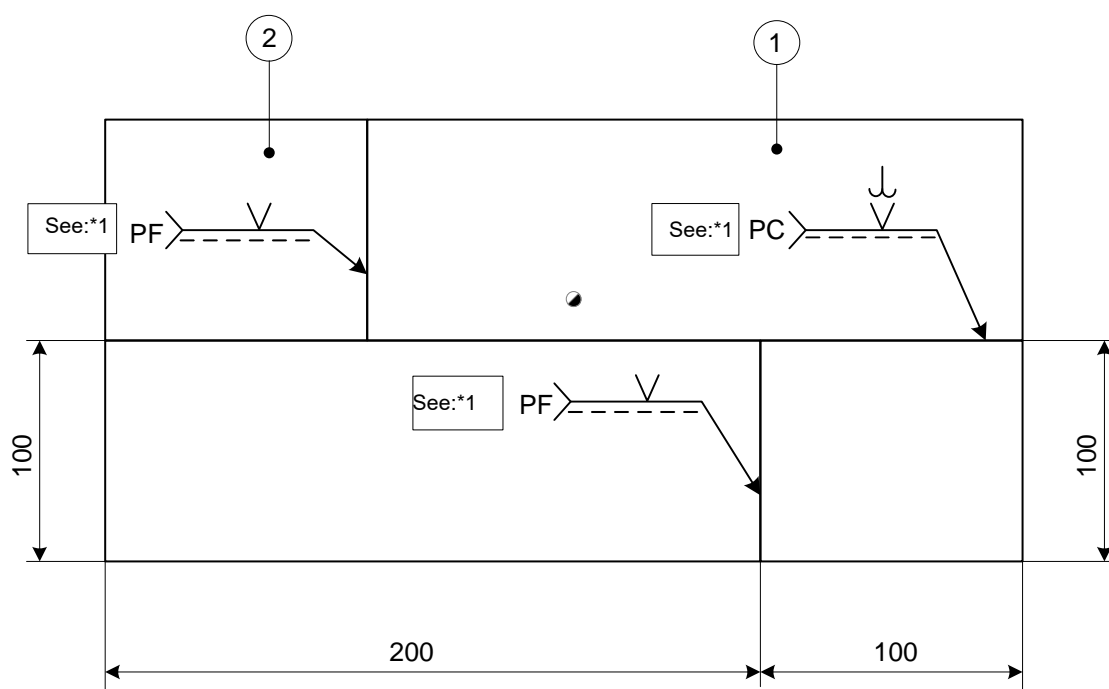
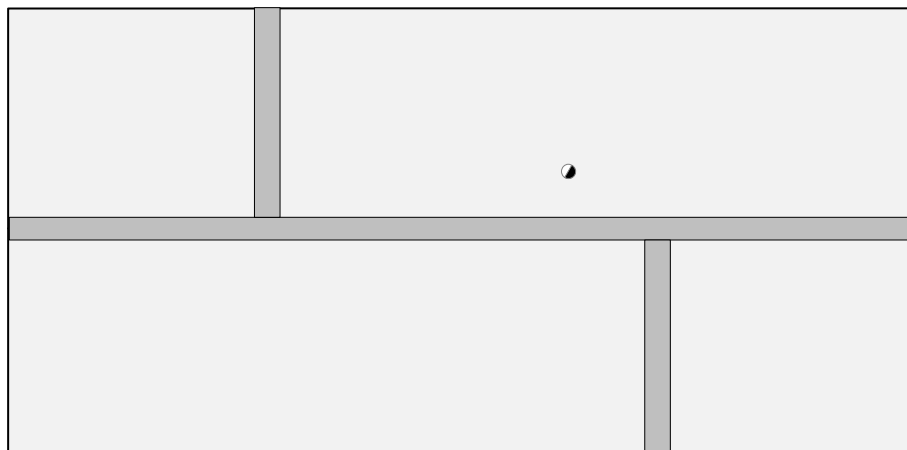


*1= penetration required

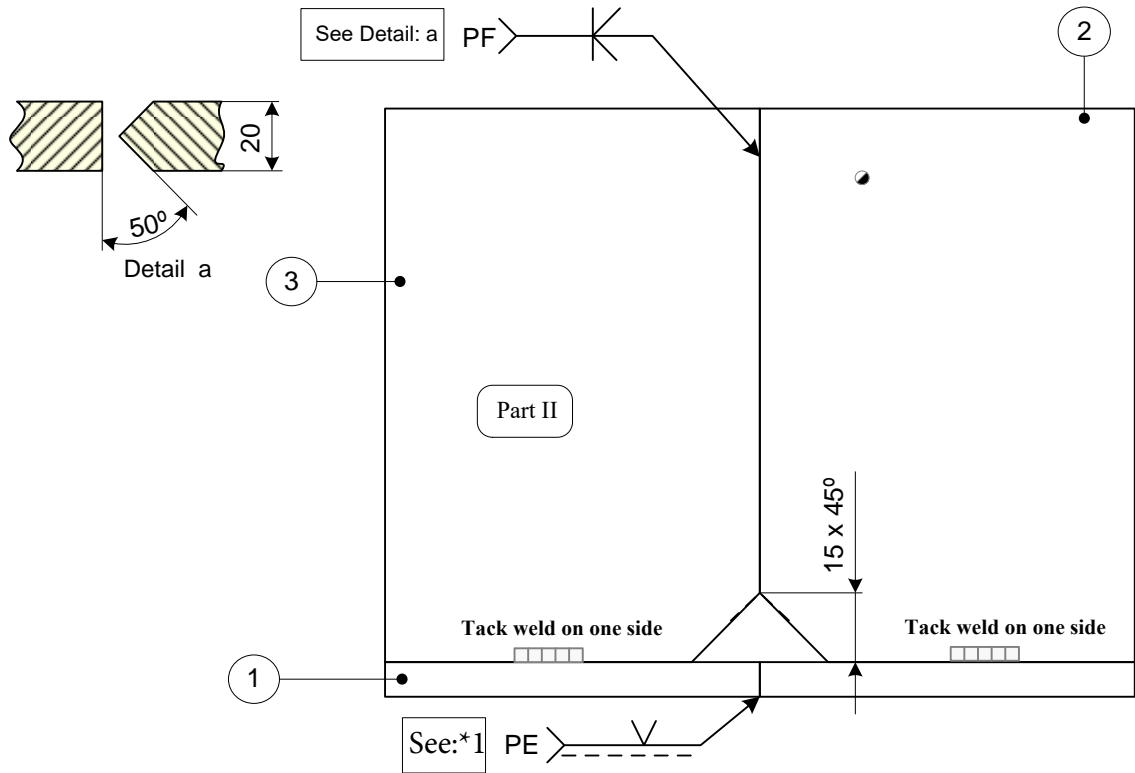
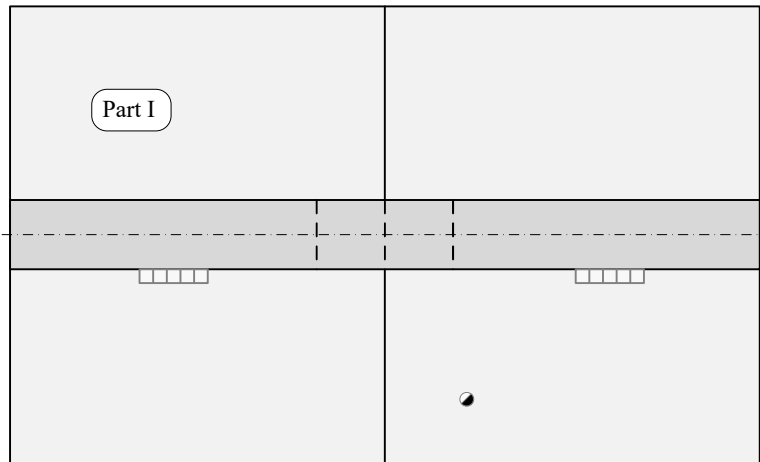


3	2	Plate	118 x 10 – 200	S235		
2	1	Plate	150 x 10 – 240	S235		
1	2	Plate of Strip	120 x 12 – 200 (chamfer 30° one side)	S235		
Part no.	Number	Denomination	Dimensions	Material type		
	Welding process: 135-136-138		examination: Visual and sizes	Institute for Welding Technology		
	Scale: not to scale		Signed:Institute for Welding Technology			
	Unit of measure: mm		Date : 24 – 10 – 2020			
	Max. working time: 85 min .		☉ = Candidate No.			
Workpiece no. Gold	Level: 3		workpiece name : CORNER PIECE		Rev: May. 2021	A 4



*1= penetration required

2	2	Plate of Strip	100 x 12 – 100 (chamfer 30° two side)	S235
1	2	Plate of Strip	100 x 12 – 200 (chamfer 30° two side)	S235
Part no.	Number	Denomination	Dimensions	Material type
	Welding process:		examination:	Institute for Welding Technology
	135 – 136 – 138		Visual and radiographic examination	
	Scale: not to scale		Signed: Institute for Welding Technology	
	Unit of measure: mm		Date: 24 – 10 – 2020	
Max. working time: 85 min .		● = Candidate No.		
Workpiece no. Gold	Level: 4	workpiece name : COMPOSITE SHEET WELD JOINT		
		Rev: May. 2021	A 4	



Remarks:
After welding, separate parts I (V-seam) and II (K-seam) from each other and remove remnants of the tack welds

*1= penetration required

3	1	Plate of Strip	100 x 20 – 150	S235		
2	1	Plate of Strip	100 x 20 - 150 (chamfer 50° two-sided - K-seam)	S235		
1	2	Plate of Strip	100 x 12 - 150 (chamfer 30° on one side - V-seam)	S235		
Part no.	Number	Denomination	Dimensions	Material type		
	Welding process: 135-136-138		examination: Visual and radiographic examination	Institute for Welding Technology		
	Scale: not to scale.		Signed: Institute for Welding Technology			
	Unit of measure: mm		Date : 24 – 10 – 2020			
	Max. working time: 60 min.		☉= Candidate No.			
Workpiece no.	Level:		workpiece name :		Rev:	A 4
Gold	3		COMPOSITE SHEET PARTS		May. 2021	