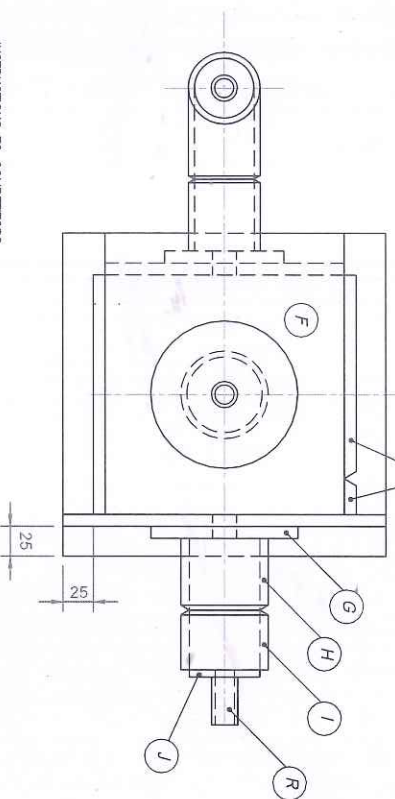
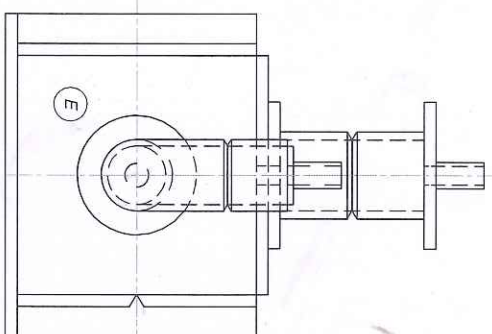
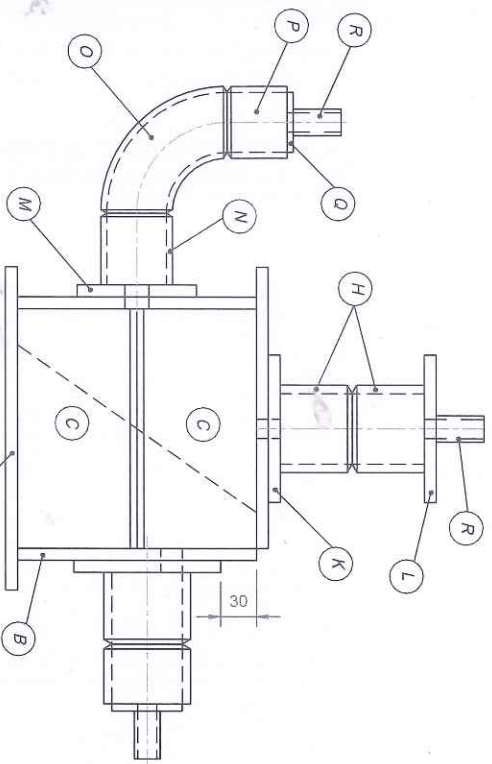


111 - MMAW
141 - TIG
135 - MAG
136 - FCAW

INSTRUCTIONS TO COMPETITORS:

- All welds are to be made as indicated on drawing (welding processes and position)
- All vertical welds are progression up
- Grinding will be limited to the technical description
- Unless noted otherwise all fillet welds leg size is 10 (-0/+2)
- All corner welds are to be full radius (-1/+1)
- The final cleaning is permitted with wire brush

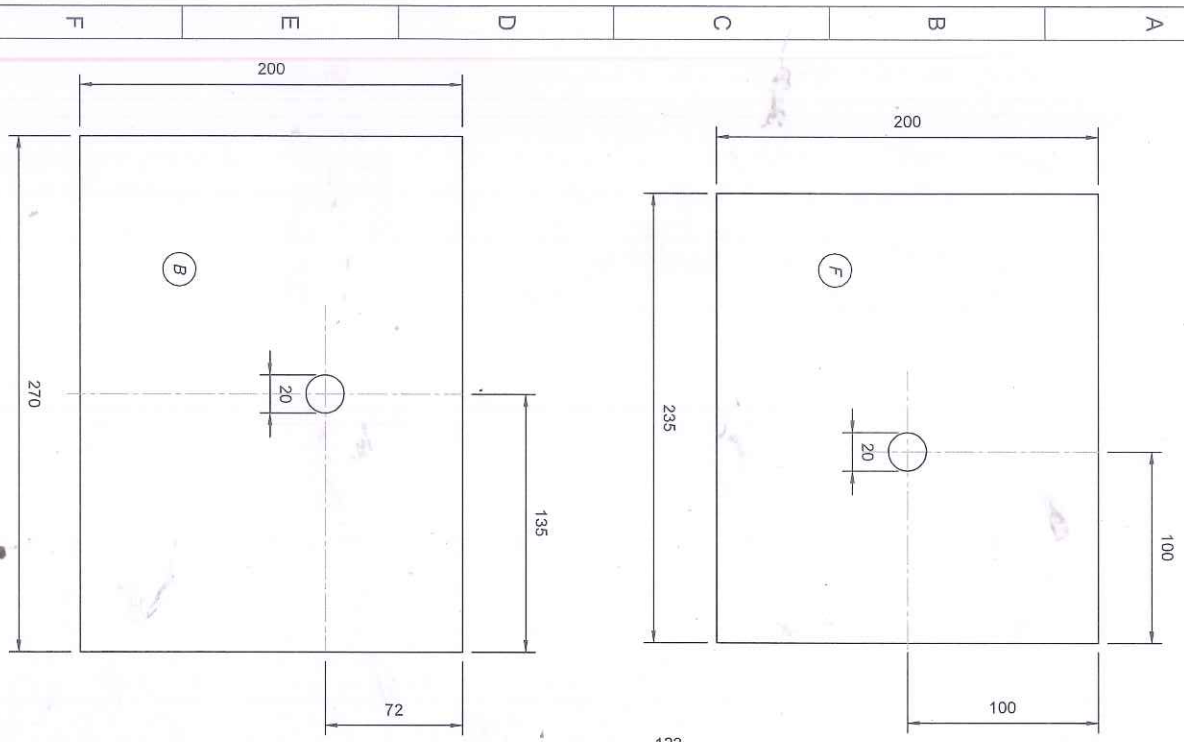
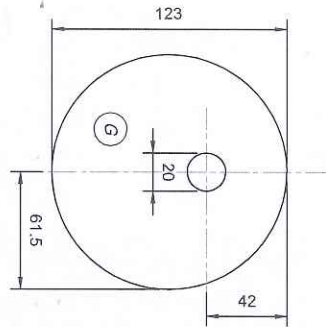
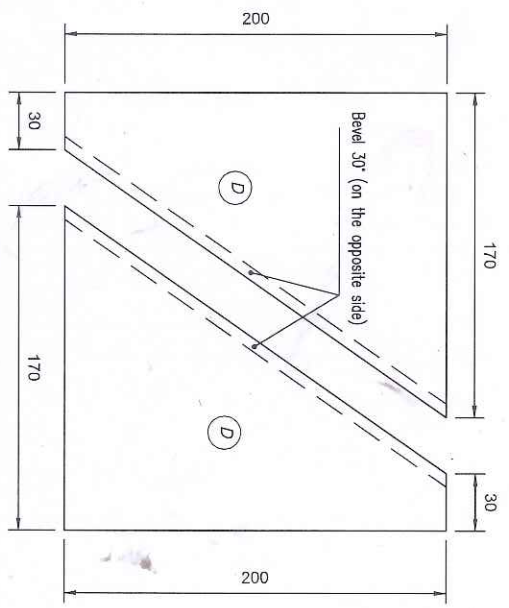


REF.	QUANT.	MATERIAL	DIMENSIONS	REMARKS
R	3	Pipe low carbon steel S235JR	φ 21,3 x 3,2 x 40	20mm thread according to test pump connections
Q	1	Pipe low carbon steel S235JR	φ 49 x 6	With hole φ16 centered
P	1	Pipe low carbon steel S235JR	φ60,3 x 5,54 x 50 (SCH 80)	One end beveled 30°
O	1	Pipe elbow 90° low carbon steel 235JR	φ60,3 x 5,54 (SCH 80)	Both ends beveled 30°
N	1	Pipe low carbon steel S235JR	φ60,3 x 5,54 x 60 (SCH 80)	One end beveled 30°
M	1	Pipe low carbon steel S235JR	φ 100 x 10	With hole φ20 centered
L	1	Pipe low carbon steel S235JR	φ 123 x 10	With hole φ16 centered
K	1	Pipe low carbon steel S235JR	φ 123 x 10	With hole φ16 centered
J	1	Pipe low carbon steel S235JR	φ 59 x 6	With hole φ16 centered
I	1	Pipe low carbon steel S235JR	φ73,03 x 7,01 x 50 (SCH 80)	One end beveled 30°
H	3	Pipe low carbon steel S235JR	φ73,03 x 7,01 x 60 (SCH 80)	One end beveled 30°
G	1	Pipe low carbon steel S235JR	φ 123 x 10	With hole φ20 - see drawing
F	1	Pipe low carbon steel S235JR	235 x 200 x 10	With hole φ20 - see drawing
E	1	Pipe low carbon steel S235JR	200 x 200 x 10	With hole φ20 centered
D	2	Pipe low carbon steel S235JR	170 x 200 x 10 - see drawing	The skew edge beveled 30°-see drawing
C	2	Pipe low carbon steel S235JR	200 x 100 x 10	One edge of 200 beveled 30°
B	1	Pipe low carbon steel S235JR	270 x 200 x 10	With hole φ20 - see drawing
A	1	Pipe low carbon steel S235JR	270 x 270 x 10	

INSTRUCTIONS TO COMPETITORS:

- TACK WELDS CAN BE MADE IN ANY POSITION WITH ANY PROCESS LISTED
- TACK WELDS MAXIMUM LENGTH 15mm OUTSIDE ONLY
- The tacks are permitted on the interconnections/corners till 15mm to each direction
- BEFORE TACK THE PLATE F CALL THE JURI FOR INSPECTION

ALL DIMENSIONS IN MILLIMETERS



REF.	QUANT.	MATERIAL	DIMENSIONS	REMARKS
R	3	Pipe low carbon steel S235LR	Ø 21,3 x 3,2 x 40	20mm thread according to tail pump connections
Q	1	Plate low carbon steel S235LR	Ø 49 x 6	With hole Ø16 centered
P	1	Pipe low carbon steel S235LR	Ø60,3 x 5,54 x 50 (SCH 80)	One end beveled 30°
O	1	Pipe elbow 90° low carbon steel 235LR	Ø60,3 x 5,54 (SCH 80)	Both ends beveled 30°
N	1	Pipe low carbon steel S235LR	Ø60,3 x 5,54 x 60 (SCH 80)	One end beveled 30°
M	1	Plate low carbon steel S235LR	Ø 100 x 10	With hole Ø20 centered
L	1	Plate low carbon steel S235LR	Ø 123 x 10	With hole Ø16 centered
K	1	Plate low carbon steel S235LR	Ø 123 x 10	With hole Ø20 centered
J	1	Plate low carbon steel S235LR	Ø 59 x 6	With hole Ø16 centered
I	1	Pipe low carbon steel S235LR	Ø73,03 x 7,01 x 50 (SCH 80)	One end beveled 30°
H	3	Pipe low carbon steel S235LR	Ø73,03 x 7,01 x 60 (SCH 80)	With hole Ø20 – see drawing
G	1	Plate low carbon steel S235LR	Ø 123 x 10	With hole Ø20 – see drawing
F	1	Plate low carbon steel S235LR	235 x 200 x 10	With hole Ø20 – see drawing
E	1	Plate low carbon steel S235LR	200 x 200 x 10	With hole Ø20 centered
D	2	Plate low carbon steel S235LR	170 x 200 x 10 see drawing	The skew edge beveled 30°-see drawing
C	2	Plate low carbon steel S235LR	200 x 100 x 10	One edge of 200 beveled 30°
B	1	Plate low carbon steel S235LR	270 x 200 x 10	With hole Ø20 – see drawing
A	1	Plate low carbon steel S235LR	270 x 270 x 10	