

**BOC Finals Test Piece No3 - Positional Welding with MMA:**

**Low Carbon Steel Plate Fillet Welds in the PD Position and Corner Weld in the PF position**

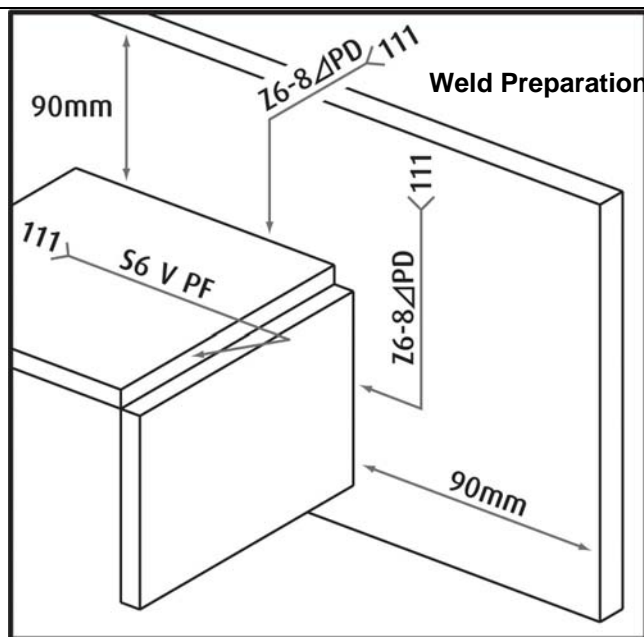
**Joint Type:** Fillets weld and Corner Weld

**Welding Position:** Fillet Welds PD Position  
Corner Weld PF position

**Parent Material Type:** Low Carbon Steel

Base Plate 200x200x6mm

Vertical plates 100x80x6mm



**Test Piece Weld Sizes and Method of Completion**

Fillet Welds Z=6mm (+2 -0 mm)

Corner Weld- included angle 90 deg.

Full Penetration (+2 -0mm)

Overfill (+2 -0mm)

Corner weld to be completed first in the PF position.

Fillet weld to be welded around the vertical plate ends and blended to the corner weld.

**Method of Preparation and Cleaning:** Degrease / mechanical dressing / wire brush.

Run No.	Electrode dia	Amperage	Arc Voltage	Polarity	Gas Flow Rate
As required	2,5mm and 3.25mm	As required	As required	DC +/-	N/A

**Other Information:-** It is the aim of the competition to assess the weld accuracy produced by the candidate using the weld parameters and technique of his choice with the given welding process, consumable sizes and class on proscribed welds on a weld test piece in a given welding position to produce welds of the dimensions shown above

**Welding Consumables:**

<b>Filler Material Type:</b> Basic	<b>Specification</b> E7016 or similar	<b>Shielding Gas Type:</b> N/A
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**Testing Criteria:** Visual examination as detailed above and in the six categories of assessment in the competition marking sheet.