

**BOC Finals Test Piece No4 - Positional Welding with MAG:**

Low carbon Steel Plate Fillet Welds in the PD Position and Corner Weld in the PF Position

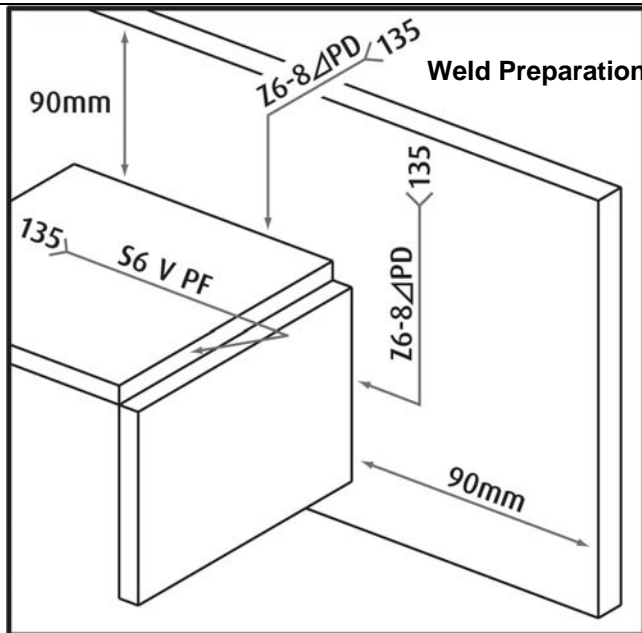
Joint Type: Fillet Welds and Corner Weld

Base Plate 200 x200 x6mm

Welding Position: Fillet Welds PD :  
Corner Weld PF

Vertical Plates 100 x80 x6mm

Parent Material Type: Low Carbon Steel



**Weld Sizes**

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 brushing

Run No.	Electrode Dia	Amperage	Arc Voltage	Polarity	Gas Flow Rate
As required	0.8	As required	As required	DC +	As required

**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:**

Filler Material Type:  
Copper coated mild steel or bare wire

Specification:  
EN 440  
G3Si1 or similar

Shielding Gas Type:  
Argon/12.5%CO<sup>2</sup> or similar

**Testing Criteria:** Visual examination as detailed above and in the six categories of assessment in the competition marking sheet.