

The criteria for the Best Welders' tests are given below :

1. Only one pre-prepared test coupon shall be given to each competitor.
2. **A maximum of three hours shall be given for the written tests .**
3. TOTAL MARKS: 100 Marks
 - a) Practical test (Butt Welding): Marks 80
The test coupons should qualify in Visual and Radiography Tests.
 - b) Viva Voce test: Marks 20

FOR BEST PIPE WELDER'S TEST:

- A. Practical test (Butt Welding) : Marks 80**
1. Pipe Specification: - ASTM – A – 106 – Gr-B
 2. Pipe dimensions : 6" dia Sch 80 pipe (thickness $\geq 10.00\text{mm}$)
 3. Process : SMAW
 4. Position : 6G
 5. Weld fit-up
 - Root face 1.5 to 2.0m
 - Root gap 1.00 to 1.5 mm
 - Bevel angle 60 – 65 degree
 6. Welding consumables
 - Root – E7018 , size – 2.5mm / 3.15 mm
 - Hot pass and subsequent pass – E7018 3.15mm / 2.5mm
 7. Cleaning: Grinding is not allowed during and after welding. Hacksaw Blade, file and brush can be used for cleaning
 8. Completion time: Three hours maximum
 9. **Acceptable Test:** The test coupons should qualify in Visual and Radiography Tests.
- B . Viva Voce Test : 20 Marks**
TOTAL MARKS : 100

FOR BEST STRUCTURAL WELDER'S TEST:

- A. Practical test (Butt welding) : Marks 80**
1. Plate Specification: - ASTM – A 36 / IS 2062
 2. Plate dimensions : 100 X 300 X 10-12 mm thick
 3. Process: SMAW
 4. Position : 4G without baking
 5. Weld fit-up
 - Root gap 1.0 to 1.5mm
 - Root face 1.5 to 2.00 mm
 - Bevel angle 60 – 65 degree
 6. Welding consumables
 - Root ,Hot pass and subsequent pass – E7018
 - Electrodes size -2.5mm / 3.15mm
 7. Cleaning : Grinding is not allowed during and after welding. Hacksaw Blade, file and brush can be used for cleaning.
 8. Completion time : Three hours maximum
 9. **Acceptable Test:** The test coupons should qualify in Visual and Radiography Tests.
- B . Viva Voce Test : 20 Marks**
TOTAL MARKS:100