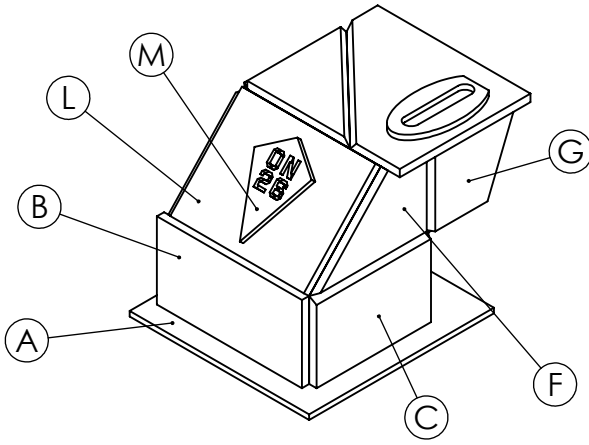
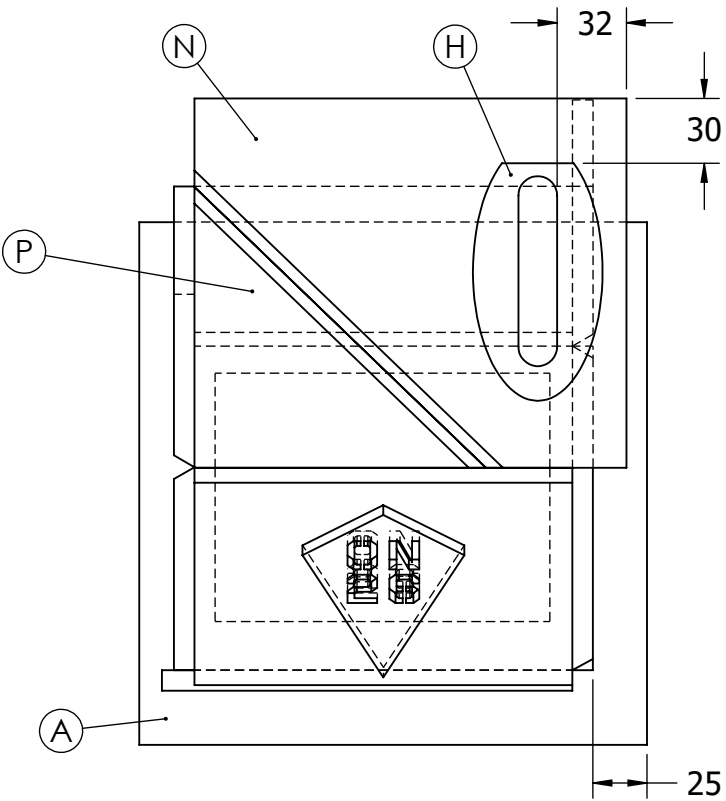
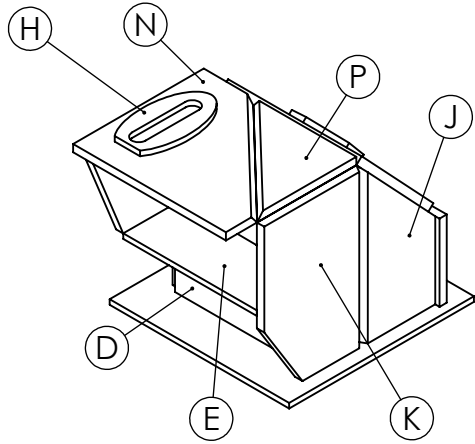


ITEM	QTY /QTE	T / ÉP.	W / LARGEUR	L / LONGEUR
A	1	6.35	235	242
B	1	9.53	100	190
C	1	9.53	100	150
D	1	6.35	94	175
E	1	6.35	74	175
F	1	9.53	100	150
G	1	9.53	100	114
H	1	6.35	60	120
J	1	9.53	94	200
K	1	9.53	130	200
L	1	9.53	137	175
M	1	6.35	75	110
N	1	9.53	171	200
P	1	9.53	130	135

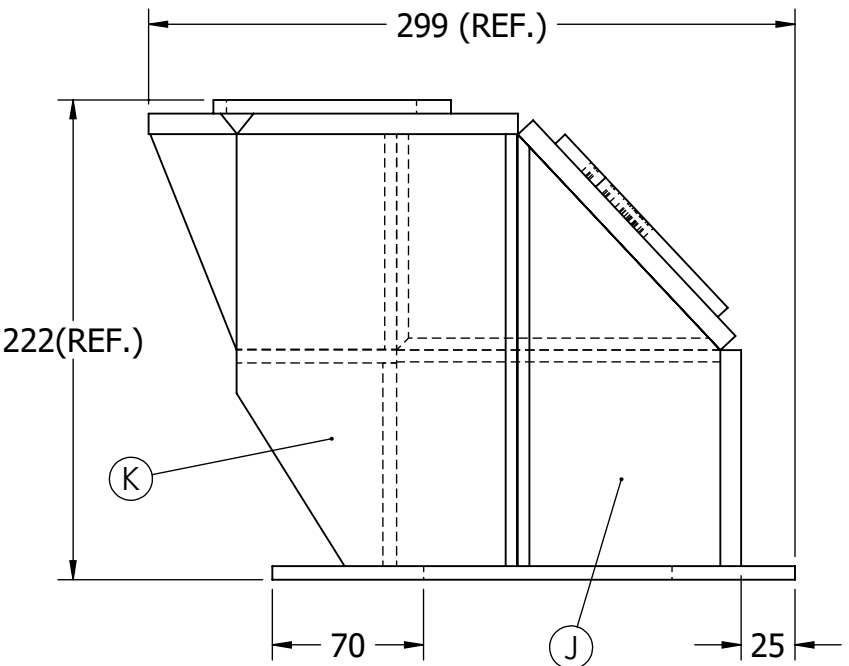
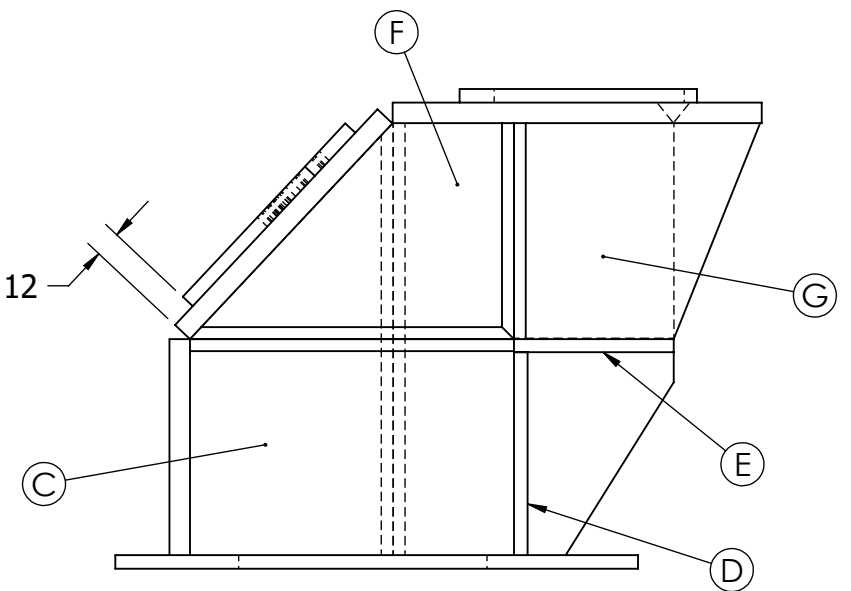
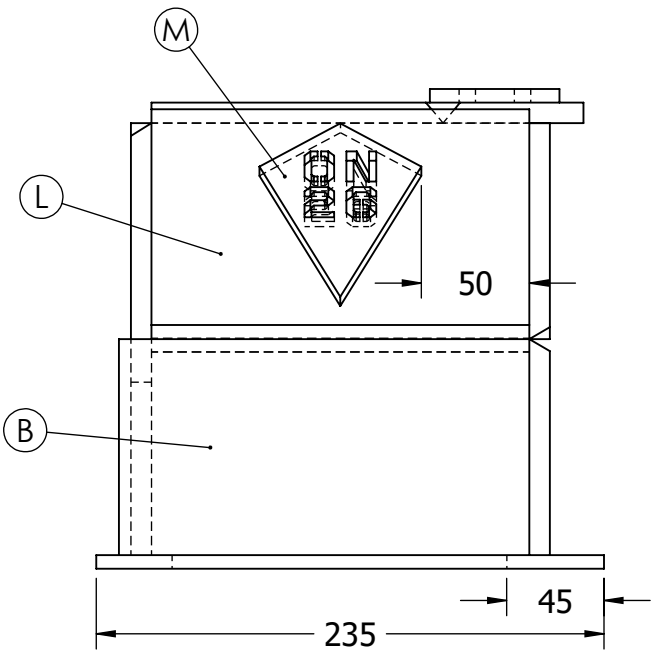
TOTAL ESTIMATED WEIGHT BEFORE WELDING /
ESTIMATION DU POIDS AVANT SOUDAGE (KG):
14.6 KG



VIEW A / VUE A
SCALE 1:7

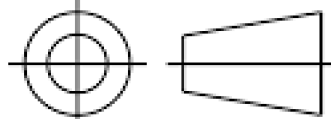


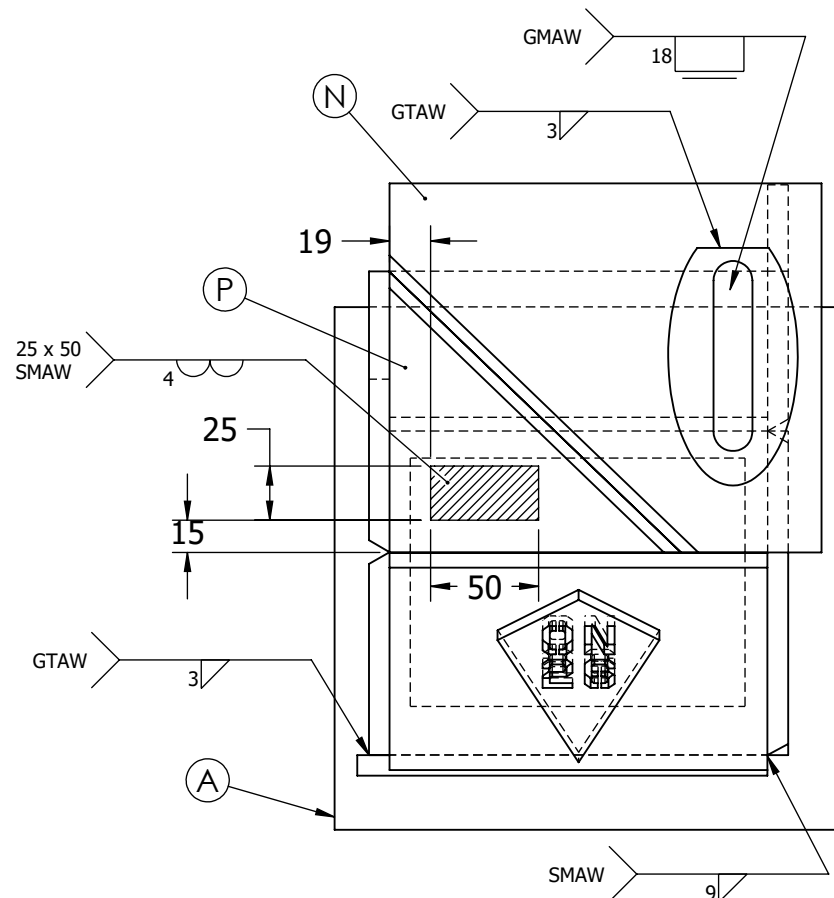
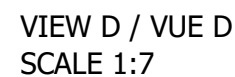
VIEW B / VUE B
SCALE 1:7



ALL DIMENSIONS IN MILLIMETERS/TOUTES LES DIMENSIONS SONT EN MILLIMÈTRES



TITLE / TITRE: SKILLS ONTARIO COMPETITION - POST-SECONDARY - MILD STEEL ASSEMBLY COMPÉTITION COMPÉTENCES ONTARIO – POSTSECONDAIRE - ACIER DOUX ASSEMBLAGE				SHEET # NO. DE PAGE: 1 OF 3	SIZE / TAILLE: B
DWG. NO. / NO DESSIN: SOC26-PS1	REV.: 0	SCALE ÉCHELLE: 1:3.5	DRAWN BY / DESSINÉ PAR: J. HYDE DATE: 2026-01-17		

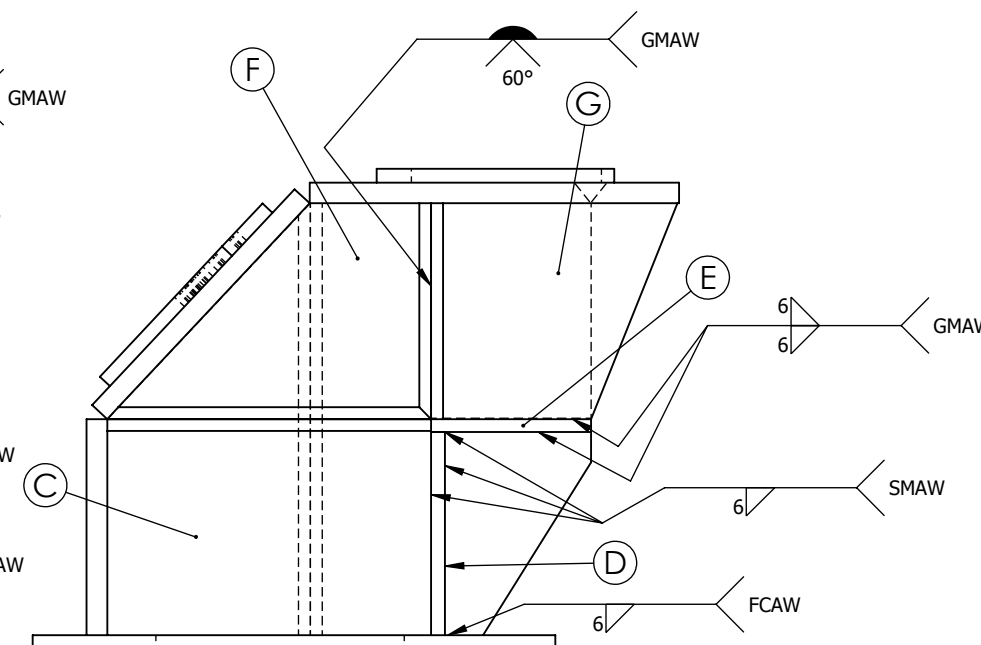
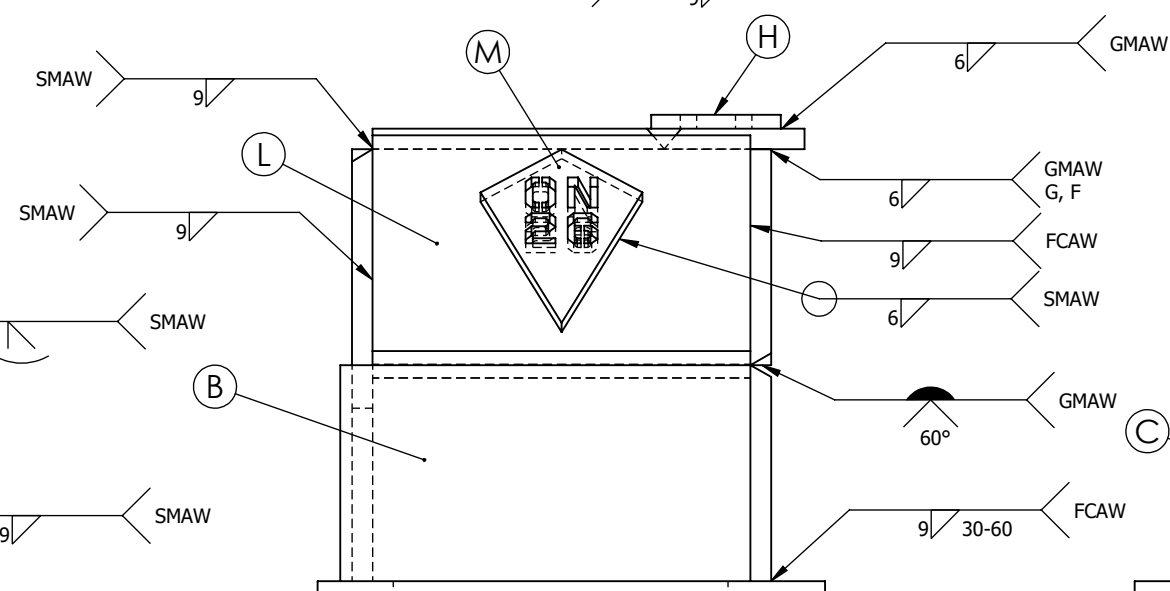
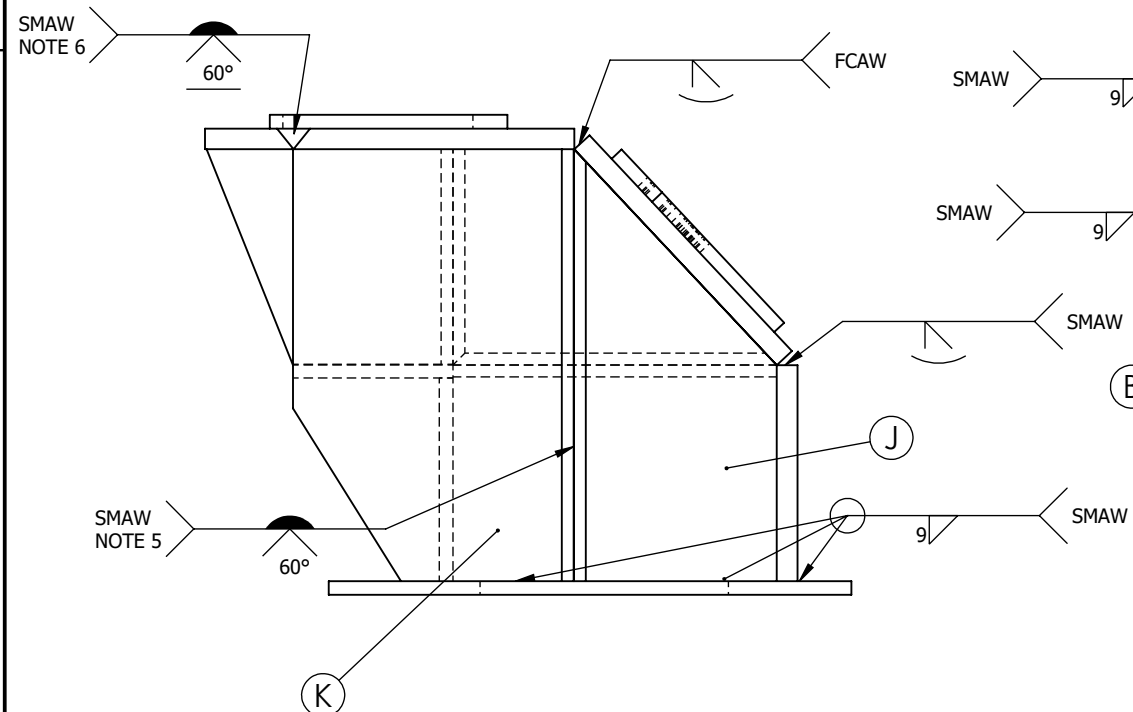


NOTE:

1. ALL WELDING TO BE COMPLETED WITH BASE PLATE "A" IN THE FLAT POSITION
2. ASSEMBLY MUST BE TACKED (WITH ANY WELDING PROCESS) AND SIGNED OFF BY AN OFFICIAL BEFORE WELDING
3. REMOVE ALL SLAG AND SPATTER, CLEANING OF THE WELDS SHALL BE MADE USING HAND TOOLS ONLY
4. UNLESS OTHERWISE NOTED, ALL SMAW USE E4918, ALL GMAW USE ER49S-6, ALL FCAW USE E491T-9-CH
5. FOR WELDS WITH THIS NOTE: USE E4310 FOR ROOT AND E4918 FOR SUBSEQUENT PASSES
6. FOR WELDS WITH THIS NOTE: USE GTAW FOR ROOT AND E4918 FOR SUBSEQUENT PASSES
7. ALL VERTICAL WELDING TO BE DONE IN UPHILL PROGRESSION

REMARQUE:

1. TOUTES LES SOUDURES DE LA PLAQUE DE BASE "A" DOIVENT ÊTRE EFFECTUÉES EN POSITION À PLAT
2. ASSEMBLAGE DOIT ÊTRE SOUDÉ PAR POINTS (AVEC TOUT PROCÉDÉ DE SOUDAGE) ET APPROUVÉ PAR UN REPRÉSENTANT AVANT LA SOUDURE
3. ENLEVER TOUTES LES SCORIES ET ÉCLABOUSSURES, LE NETTOYAGE DES SOUDURES DOIT ÊTRE EFFECTUÉ À L'AIDE D'OUTILS À MAIN UNIQUEMENT
4. SAUF INDICATION CONTRAIRE, TOUS LES SMAW UTILISENT E4918, TOUS LES GMAW UTILISENT ER49S-6, TOUS LES FCAW UTILISENT E491T-9-CH
5. POUR LES SOUDURES AVEC CETTE NOTE, E4310 POUR LA RACINE ET E4918 POUR LES PASSES SUIVANTES
6. POUR LES SOUDURES AVEC CETTE NOTE, GTAW POUR LA RACINE ET E4918 POUR LES PASSES SUIVANTES
7. TOUTES LES SOUDURES VERTICALES SONT EN SONDAGE VERTICAL MONTANT



ALL DIMENSIONS IN MILLIMETERS/TOUTES LES DIMENSIONS SONT EN MILLIMÈTRES

TITLE / TITRE:
SKILLS ONTARIO COMPETITION - POST-SECONDARY - MILD STEEL WELDING DETAILS
COMPÉTITION COMPÉTENCES ONTARIO – POSTSECONDAIRE - DÉTAILS DE SOUDAGE EN
ACIER DOUX

SHEET # NO. DE PAGE: 2 OF 3

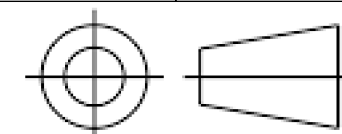
SIZE / TAILLE:	B
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DWG. NO. / NO DESSIN:
SOC26-PS1

REV.:	0
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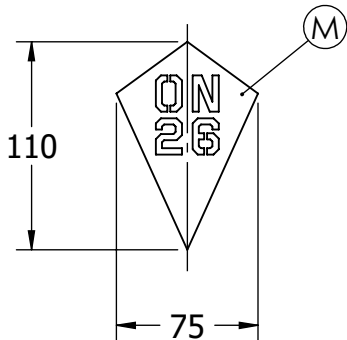
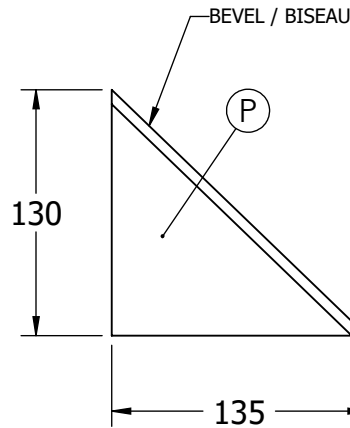
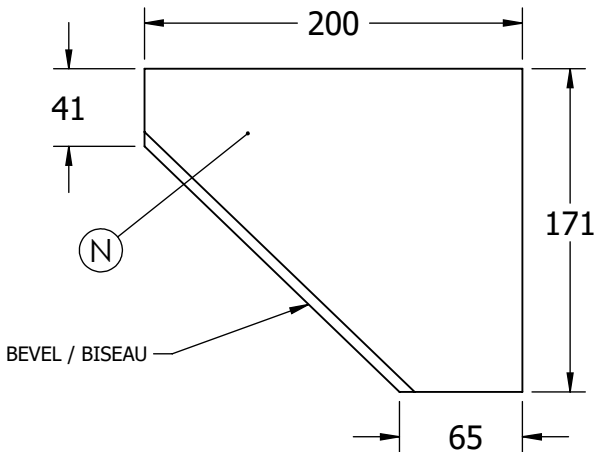
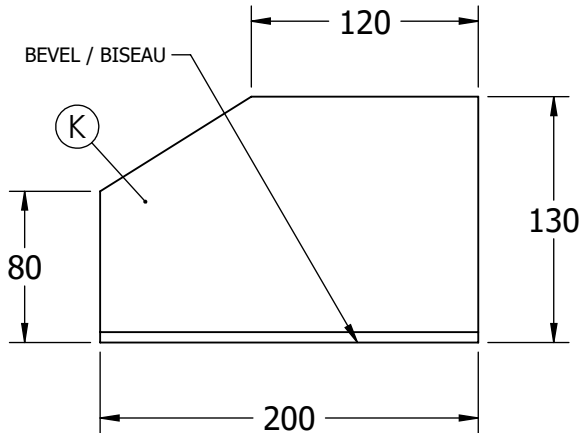
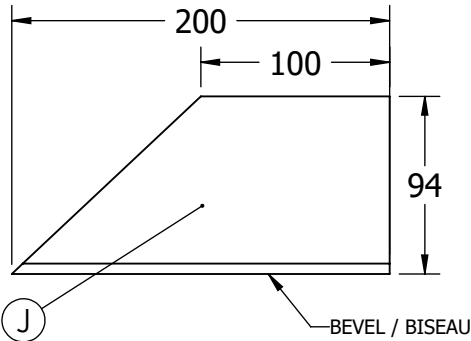
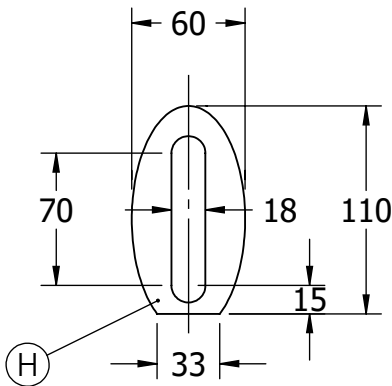
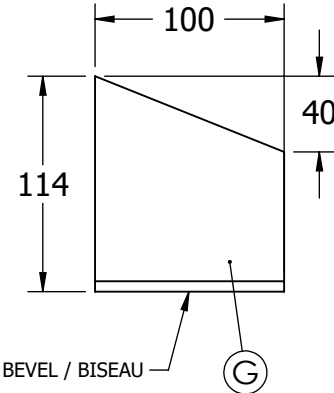
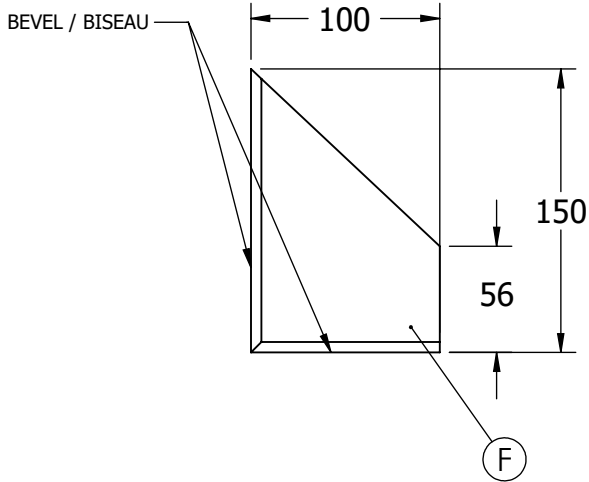
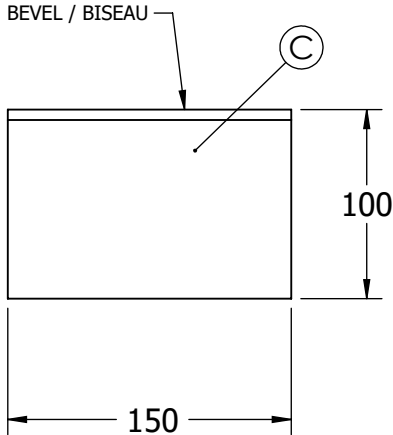
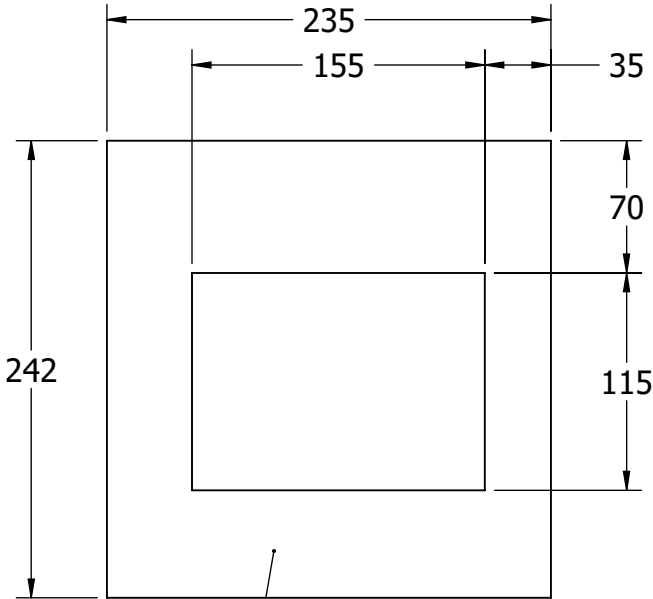
SCALE ÉCHELLE:	1:3.5
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DRAWN BY / DESSINÉ PAR: J. HYDE
DATE: 2026-01-17

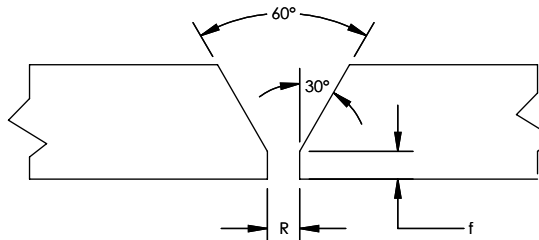


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TOTAL ESTIMATED WEIGHT BEFORE WELDING /
ESTIMATION DU POIDS AVANT SOUDAGE (KG):
14.6 KG



PREPARED GROOVE DIMENSIONS / DIMENSIONS DES RAINURES PRÉPARÉES



* = ALL BEVEL AND VEE PREPARATIONS AS FOLLOWS:
* = PRÉPARER TOUTES LES SOUDURES EN V ET EN BISEAU
COMME CECI :

R and f are prepared to the preference of the competitor.
The dimension for the plates shown is to a feathered edge and
any root gap must be accomodated in overall fitting dimensions.

R et f sont préparés selon les préférences du concurrent ou de la
concurrente. Les dimensions des plaques présentées tiennent
compte d'un rebord aminci et tout espacement des racines doit
être pris en compte dans l'ensemble des dimensions
d'assemblage.

ALL DIMENSIONS IN MILLIMETERS/TOUTES LES DIMENSIONS SONT EN MILLIMÈTRES

TITLE / TITRE:

SKILLS ONTARIO COMPETITION - POST-SECONDARY - MILD STEEL PARTS
COMPÉTITION COMPÉTENCES ONTARIO – POSTSECONDAIRE - PIÈCES EN ACIER DOUX

SHEET #
NO. DE PAGE:

3 OF 3

SIZE / TAILLE:

B

DWG. NO. / NO DESSIN:

SOC26-PS1

REV.:

0

SCALE
ÉCHELLE:

1:4

DRAWN BY / DESSINÉ PAR: J. HYDE

DATE: 2026-01-17

