

SKILLSUSA

KANSAS

2011 Skills USA State Competition

Welding: Parameters

Process	Filler Material Type & Size	Polarity	Amps	WFS	Volts
GTAW	ER 4043 - 3/32	AC	100- 175		
GTAW	ER 70S-6-1/16 or 3/32	DCEN	60-100		
GTAW	ER 308L-3/32	DCEN	50-140		
SMAW	E6010-3/32	DCEP	40-70		
SMAW	E6010-1/8"	DCEP	65-130		
SMAW	E7018-3/32"	DCEP	70-100		
SMAW	E7018-1/8"	DCEP	90-130		
GMAW	ER70S-6-.035" dia	DCEP	100-200	165-350	16-21
FCAW	ER71T-1-.045" dia	DCEP	125-170	240-380	21-26

Values for Amp/WFS are approx.
 Voltage settings will be monitored
 All filler rods may not be used during the competition

Tack-weld or clamp the project to the steel bar in the welding booth for vertical up or overhead welding.

All welds must be made within the specified welding parameters given above.

Each project print has a box in the upper left corner titled "Welding Procedure" - follow the specified process, welding position and procedure for each weld.

Each contestant will be given 2 tungsten electrodes with both ends sharpened for the GTAW portion of the contest. Carefully ball the tungsten electrode for aluminum welding. **NO TUNGSTEN GRINDING WILL BE ALLOWED DURING THE CONTEST.** If you need an extra tungsten for welding please contact the SkillsUSA Official in the GTAW area.

You will be given 30 minutes to complete each section of the test. A 5-minutes warning will be given before the end of the allowed time