

# CONNECT WORKFORCE 4

## PIPE WELDING REQUIREMENTS

### 1F/1G FLAT

POSITION	ELECTRODE		MATERIAL
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BEFORE CUTTING NEW PLATE BE SURE TO CHECK USED METAL BIN

1	STRINGER BEADING	3/16" 6010		1/4" PLATE
2	WEAVE BEADING	3/16" 6010		1/4" PLATE
3	STRINGER BEADING	1/8" 7018		1/4" PLATE
4	WEAVE BEADING	1/8" 7018		1/4" PLATE
5	LAP JOINT	3/16" 6010	10 PCS	3/16" PLATE
6	LAP JOINT	1/8" 7018	10 PCS	3/16" PLATE
7	TEE JOINT (Weld out)	3/16" 6010		1/4" PLATE
8	TEE JOINT (Weld Out)	1/8" 7018		1/4" PLATE
9	OFC (OXYGEN FUEL CUTTING)	OXY-ACETYLENE FLAME CUTTING	STRAIGHT LINES AND SHAPES	
10	SQ BUTT JOINT	3/16" 6010	USE OLD TEE JOINTS	
11	V-BUTT JOINT	1/8" 6010 ROOT PASS 1/8" 7018 FILLER AND CAP		3/8" PLATE
12	V-BUTT OPEN ROOT TEST	AWS BEND/BREAK		ROOT FACE 3/32" ROOT GAP 3/32"-1/8" 3/8" X 6" X 10"

### 2F/2G HORIZONTAL POSITION

13	STRINGER BEADING	3/16" 6010		1/4" PLATE
14	LAP JOINT	3/16" 6010	10 PCS	3/16" PLATE
15	LAP JOINT	1/8" 7018	10 PCS	3/16" PLATE
16	TEE JOINT (Weld out)	3/16" 6010		1/4" PLATE
17	TEE JOINT (Weld out)	1/8" 7018		1/4" PLATE
18	SQ. BUTT JOINT	1/8" 6010		1/4" PLATE
19	BACKING PLATE REMOVAL/ GOUGING TORCH/CARBON ARC TORCH (CAC-A)			
20	V-BUTT WITH BACKING *	6010/7018		3/8" PLATE
21	V-BUTT OPEN ROOT**	6010/7018		3/8" PLATE
22	V-BUTT OPEN ROOT TEST	AWS BEND/BREAK		1 PCS 3/8" X 6" X 10"

\*ROOT FACE 1/16", ROOT GAP 3/16"

\*\* ROOT FACE 3/32", ROOT GAP 3/32"-1/8"

# CONNECT WORKFORCE 4

## 3F/3G UPHILL

POSITION	ELECTRODE		MATERIAL
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BEFORE CUTTING NEW PLATE BE SURE TO CHECK USED METAL BIN

23	STRINGER BEADING	3/16" 6010		1/4" PLATE
24	WEAVE BEADING	3/16" 6010		1/4" PLATE
25	STRINGER BEADING	1/8" 7018		1/4" PLATE
26	WEAVE BEADING	1/8" 7018		1/4" PLATE
27	LAP JOINT	3/16" 6010	10 PCS	3/16" PLATE
28	LAP JOINT	1/8" 7018	10 PCS	3/16" PLATE
29	TEE JOINT (Weld out)	3/16" 6010		1/4" PLATE
30	TEE JOINT (Weld Out)	1/8" 7018		1/4" PLATE
31	OFC (OXYGEN FUEL CUTTING)	OXY-ACETYLENE FLAME CUTTING	STRAIGHT LINES AND SHAPES	
32	SQ BUTT JOINT	3/16" 6010	USE OLD TEE JOINTS	
33	V-BUTT JOINT	1/8" 6010 ROOT PASS		3/8" PLATE
		1/8" 7018 FILLER AND CAP		
	OPEN ROOT			ROOT FACE 3/32"
				ROOT GAP 3/32"-1/8"
34	V-BUTT OPEN ROOT TEST	AWS BEND/BREAK		3/8" X 6" X 10"

## 4F/4G HORIZONTAL POSITION

35	STRINGER BEADING	3/16" 6010		1/4" PLATE
36	LAP JOINT	3/16" 6010	10 PCS	3/16" PLATE
37	LAP JOINT	1/8" 7018	10 PCS	3/16" PLATE
38	TEE JOINT (Weld out)	3/16" 6010		1/4" PLATE
39	TEE JOINT (Weld out)	1/8" 7018		1/4" PLATE
40	SQ. BUTT JOINT	1/8" 6010		1/4" PLATE
41	BACKING PLATE REMOVAL/ GOUGING TORCH/CARBON ARC TORCH (CAC-A)			
42	V-BUTT WITH BACKING *	6010/7018		3/8" PLATE
43	V-BUTT OPEN ROOT**	6010/7018		3/8" PLATE
44	V-BUTT OPEN ROOT TEST	AWS BEND/BREAK		1 PCS 3/8" X 6" X 10"

\*ROOT FACE 1/16", ROOT GAP 3/16"

\*\* ROOT FACE 3/32", ROOT GAP 3/32"-1/8"

45	3G AWS PLATE WELD	1/8" 7018	D1.1	1" PLATE
46	4G AWS PLATE WELD	1/8" 7018	D1.1	1" PLATE

# CONNECT WORKFORCE 4

## 1G-6G PIPE WELDS

POSITION	ELECTRODE	MATERIAL
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**BEFORE CUTTING NEW PIPE BE SURE TO CHECK USED METAL BIN**

1	Horizontal PIPE ROLLED	1/8" 6010 3/32 7018	SCH 40
2	Horizontal PIPE Fixed	1/8" 6010 3/32 7018	SCH 40
3	UPHILL PIPE Rolled	1/8" 6010 3/32 7018	SCH 40
4	UPHILL PIPE FIXED	1/8" 6010 3/32 7018	SCH 40
5	Horizontal PIPE ROLLED	1/8" ER70	SCH 40
6	Horizontal PIPE Fixed	1/8" ER70	SCH 40
7	UPHILL PIPE Rolled	1/8" ER70	SCH 40
8	UPHILL PIPE FIXED	1/8" ER70	SCH 40
9	OFC (OXYGEN FUEL CUTTING)	OXY-ACETYLENE STRAIGHT LINES AND SADDLE CUTS	
10	6G AWS TEST	1/8" 6010 3/32 7018	SCH 40
11	6G AWS TEST	1/8" ER70	SCH 40
12	RESTRICTOR PLATE TEST	1/8" 6010 3/32 7018	SCH 40
13	RESTRICTOR PLATE TEST	1/8" ER70	SCH 40
14	6G AWS HEAVY WALL	1/8" 6010 3/32 7018	SCH 120
15	6G AWS HEAVY WALL	1/8" ER70	SCH 120

Once AWS test are complete and certificates are awarded the JOB Prep and assistance begins.