



Pipe Welding Competition

ALL TEST COUPONS MUST BE PREPPED AND TACKED PRIOR TO COMPETITION. PART OF THE SCORING SHALL INCLUDE INSPECTION OF PROVIDED COUPONS BEFORE START OF COMPETITION.

ONLY CONTESTANTS AND JUDGES ARE ALLOWED IN WELDING AREA AND ALL JUDGES DECISIONS ARE FINAL.

Scope of Contest: The contestant has 45 minutes to make an open butt weld on 4" schedule 80 pipe in the 6G position. Welding parameters: 6010 root uphill 6010 hot pass uphill or downhill and 7018 uphill fill and cap. Note that tacks, root, and cap must be above flush not to exceed 1/8". Weave is not allowed in cap only stringers.

What Contestants Shall Provide: Contestants shall bring the following:

- Two 4" schedule 80 pipe that measure 3" in length (6" total). EACH shall be beveled on one end with a landing (1/16" min-3/32" max). Gap (0-3/32") WITH 3-4 Full Penetration tacks (1/4" to 3/8" Length-feather optional)
- All PPE (Personal Protective Equipment)
 - Welding Hood with at least a 10-shade lens
 - Safety Glasses
 - Ear Protection
 - Welding Gloves
 - Leather Work Boots
 - Welding Jacket
 - Welding Cap is OPTIONAL
 - Grinder (ALL GUARDS AND HANDLE MUST BE IN PLACE AND SHALL NOT BE MODIFIED IN ANY WAY) grinding disc/wire wheel/grinding rock/tiger paw basically anything you think you will use.
 - Face Shield
 - Chipping Hammer
 - File
 - Wire Brush
 - Please refer to the Skills USA Official Competitions uniform Chart for additional dress code requirements.

Items Provided for The Contestants: Welding machines and filler metal shall be provided.

Note: Every effort shall be made to return the weldment to each participant once judging is complete however SKILLS USA is not responsible for lost weldments. Any pieces not collected by end of day shall be recycled.