

# STRUCTURAL COUPON

## MATERIALS

3/8" X 6" X 6" Flat Bar

1/4" X 4" X 4" Flat Bar

3/32" E7018 SMAW

Electrodes

## INSTRUCTIONS

*2 Weld Passes on each side*

1st Pass/Root on each side - 3/32" E7018

2nd Pass/Cap on each side - 3/32" E7018

Vertical Uphill Progression (Weld 2 & 3)

Weld made in either direction (Weld 1 & 4)

Cap Pass should be a 5/16" Fillet Weld

*Weld each side in sequence from bottom to top*

**WELD 1: OVERHEAD 4F**

**WELD 2: VERTICAL 3F**

**WELD 3: VERTICAL 3F**

**WELD 4: HORIZONTAL 2F**

**Weld all the way out.**

**Staggered welds are for reference only.**

## 2025 WELDING COMPETITION FOR HIGH SCHOOL SENIORS

