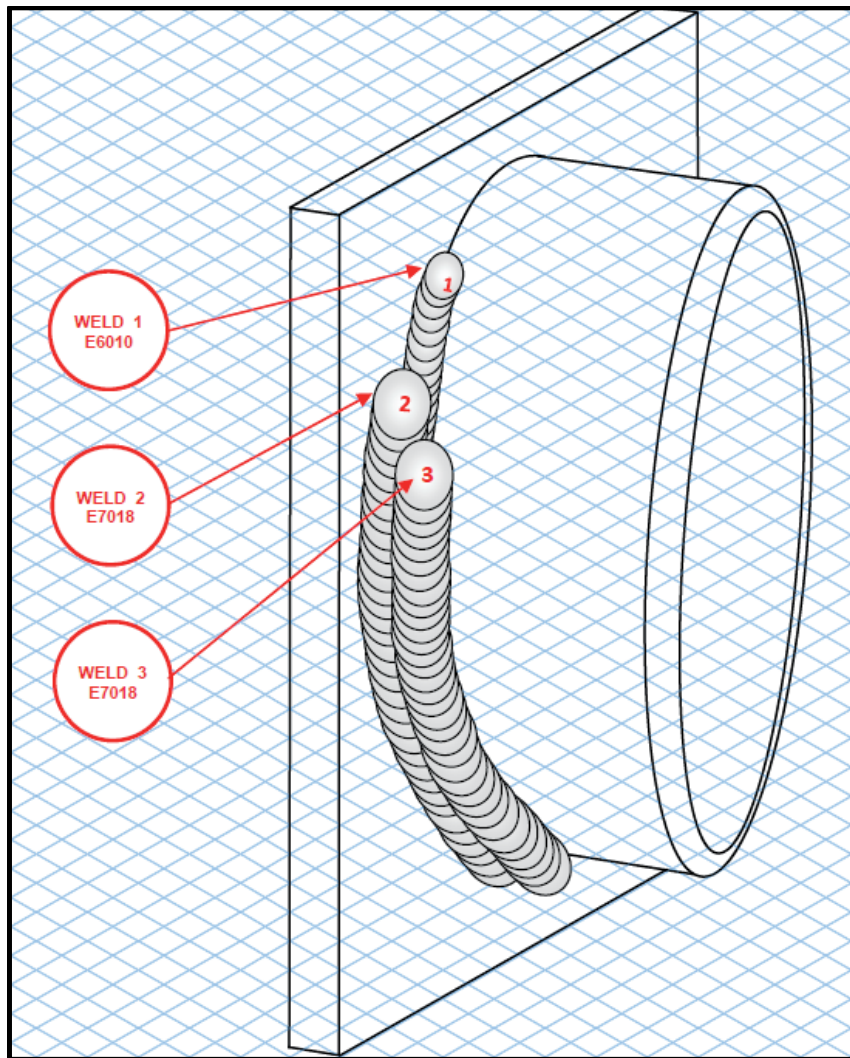


COMPETITION COUPON



MATERIALS

1/4"x4"x4" Flat Bar

2" Sch 80 Pipe

1/8" E6010 SMAW Electrodes

3/32" E7018 SMAW Electrodes

INSTRUCTIONS

3 Weld Passes on each side

1st Pass/Root - 1/8" E6010

2nd Pass/Cap - 3/32" E7018

3rd Pass/Cap - 3/32" E7018

Vertical Uphill Progression

Each pass no more than 3 times

rod diameter/stringer beads

Weld all the way out.

Staggered welds are for reference only.