

PIPE COUPON

2025 WELDING COMPETITION FOR HIGH SCHOOL SENIORS

MATERIALS

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

3" Schedule 40 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.

