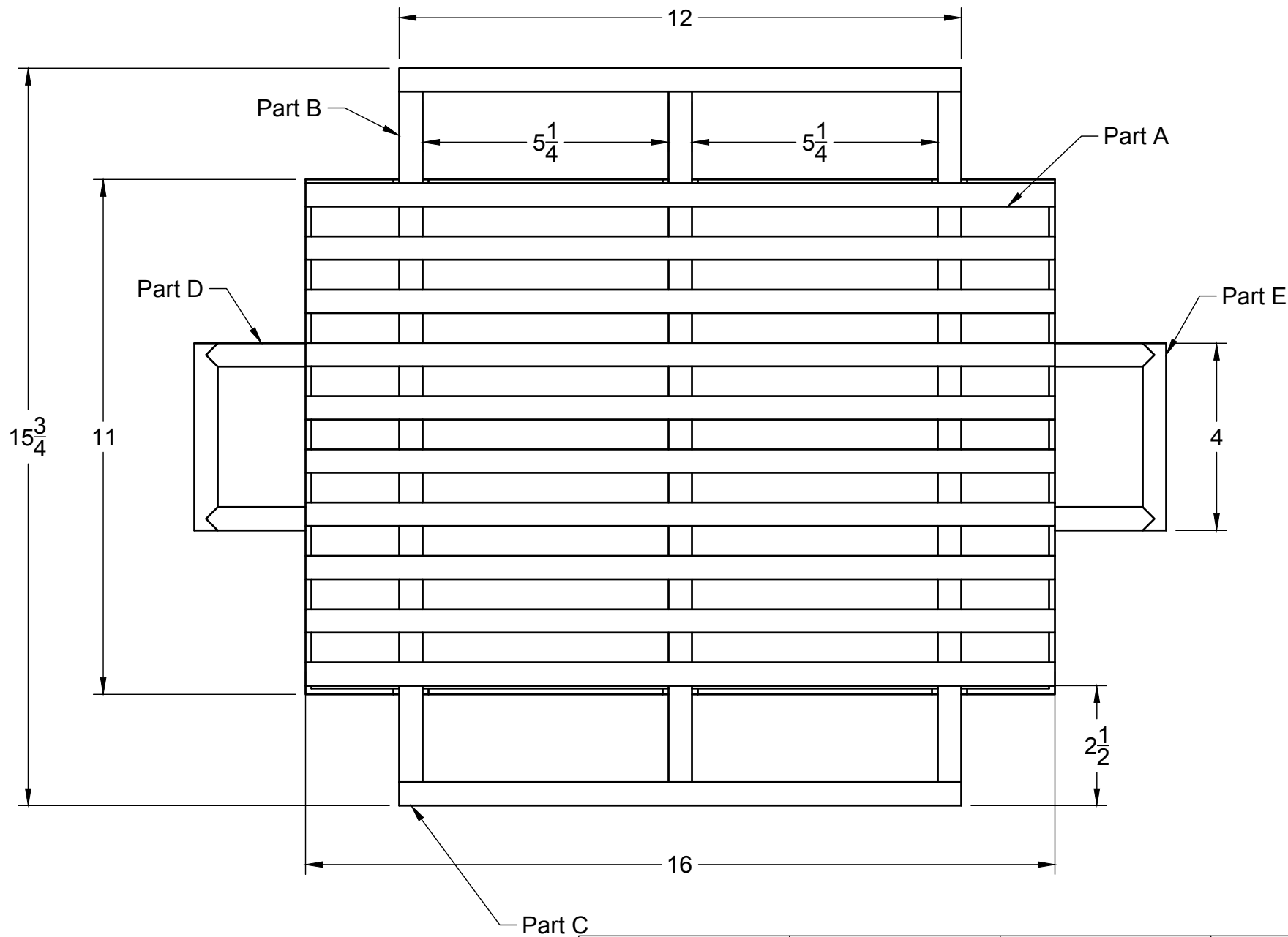
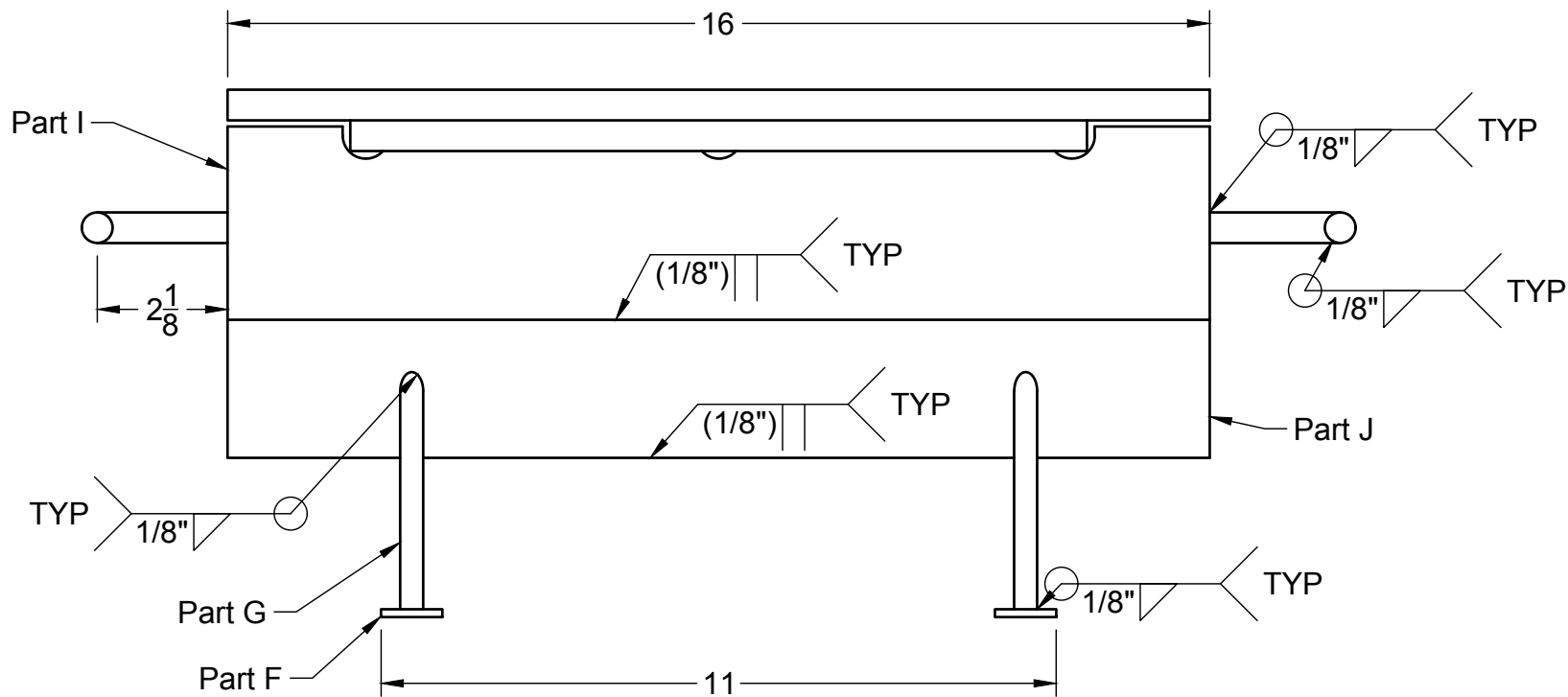


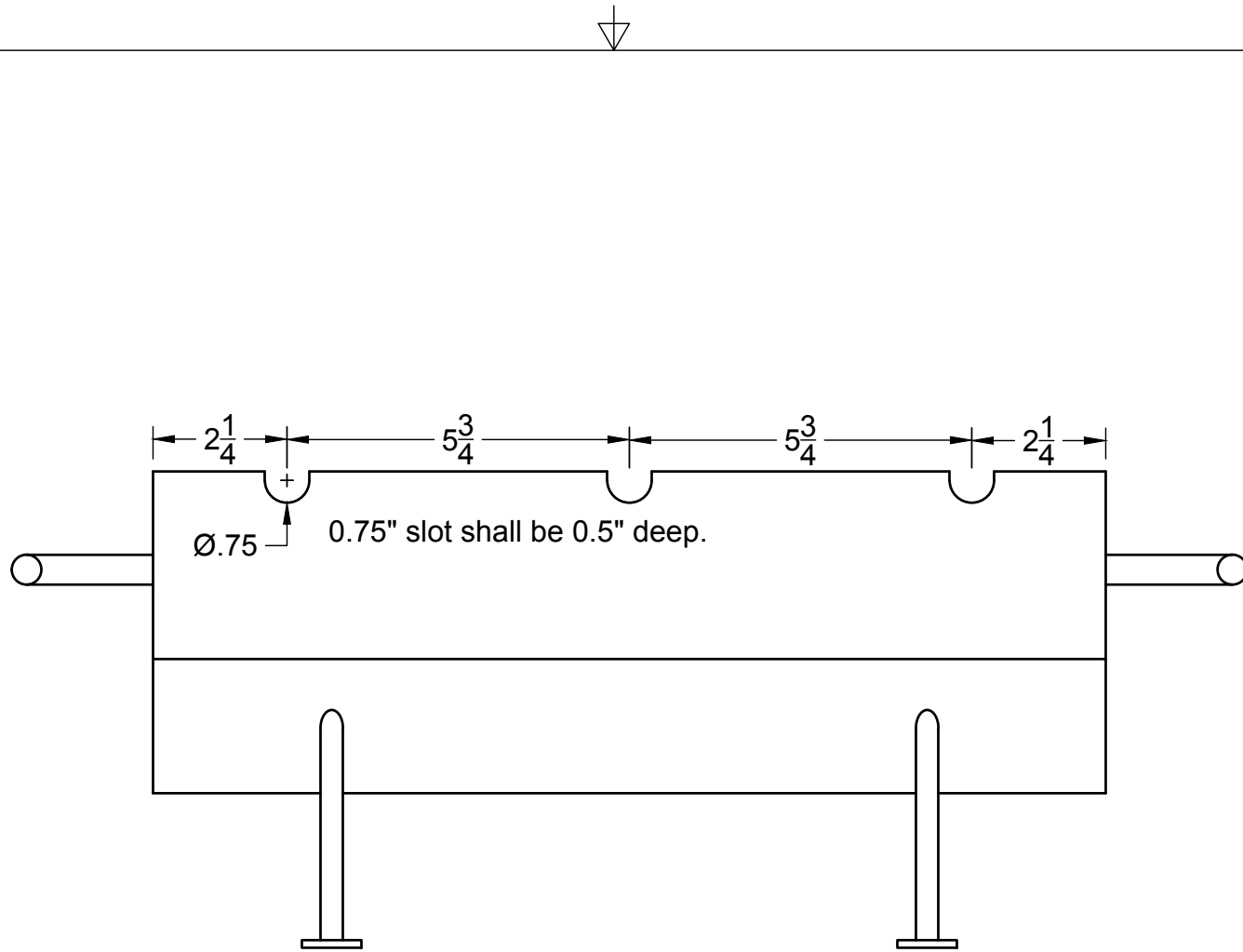
Rev 1	Drawn by: AMU	Scale: 1:4	1 of 6
Hibachi Grill - SkillsUSA Texas Secondary Team Fabrication			



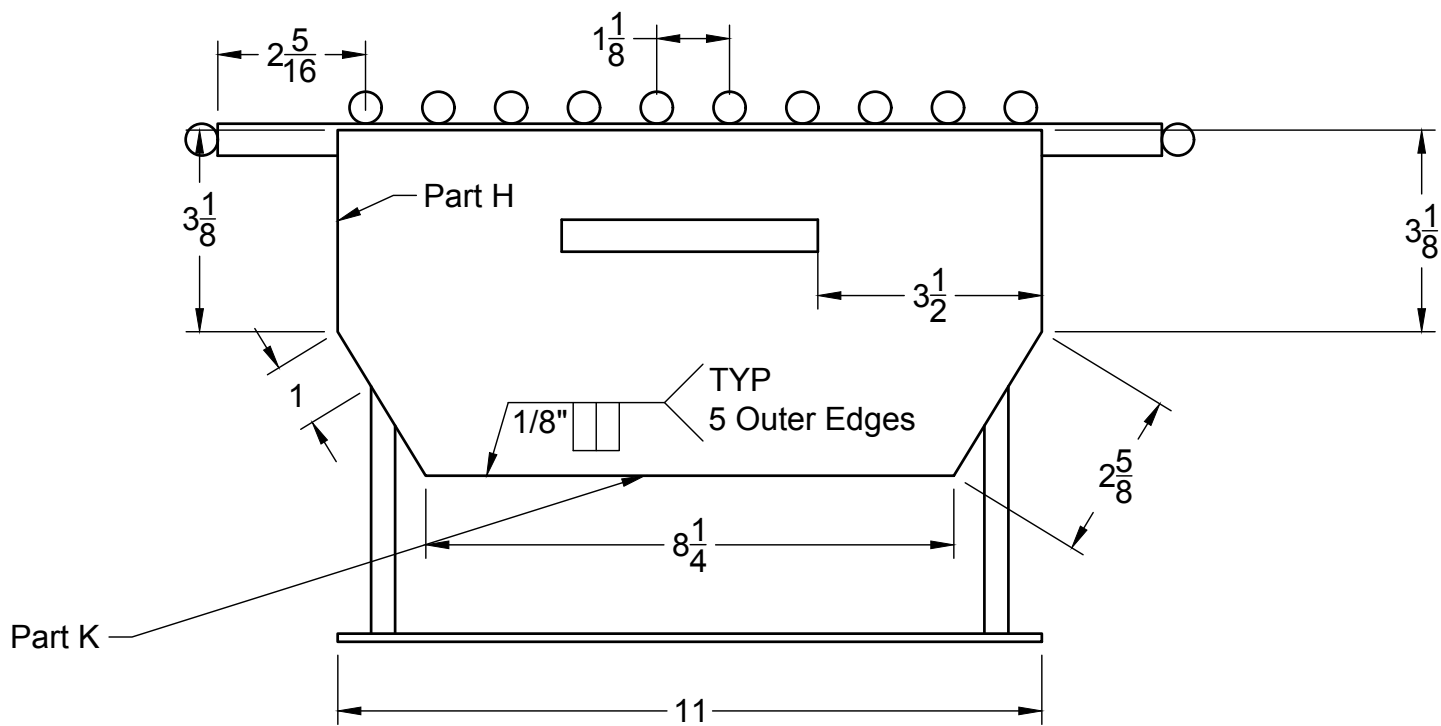
Rev 1	Drawn by: AMU	Scale: 1:4	2 of 6
Hibachi Grill - SkillsUSA Texas Secondary Team Fabrication			



Rev 1	Drawn by: AMU	Scale: 1:4	3 of 6
Hibachi Grill - SkillsUSA Texas Secondary Team Fabrication			



Rev 1	Drawn by: AMU	Scale: 1:4	4 of 6
Hibachi Grill - SkillsUSA Texas Secondary Team Fabrication			



Rev 1	Drawn by: AMU	Scale: 1:4	5 of 6
Hibachi Grill - SkillsUSA Texas Secondary Team Fabrication			



Parts List			
Part	Quantity	Description	Material
A	10	$\frac{1}{2}$ " x 16"	$\frac{1}{2}$ " rebar
B	3	$\frac{1}{2}$ " x 15-1/2"	$\frac{1}{2}$ " rebar
C	2	$\frac{1}{2}$ " x 12"	$\frac{1}{2}$ " rebar
D	4	$\frac{1}{2}$ " x 2"	$\frac{1}{2}$ " rebar
E	2	$\frac{1}{2}$ " x 4"	$\frac{1}{2}$ " rebar
F	2	1" x 11"	$\frac{1}{8}$ " x 1" flat bar
G	4	$\frac{1}{2}$ " x 3-3/4"	$\frac{1}{2}$ " rebar
H	2	$\frac{1}{8}$ " x 11" x 5-3/8"	$\frac{1}{8}$ " plate
I	2	$\frac{1}{8}$ " x 16" x 3-1/8"	$\frac{1}{8}$ " plate
J	2	$\frac{1}{8}$ " x 16" 2-5/8"	$\frac{1}{8}$ " plate
K	1	$\frac{1}{8}$ " x 16" 8-1/4"	$\frac{1}{8}$ " Plate

Use WPS **FCAW1_WPS** for square groove and edge welds.

Use WPS **FCAW2_WPS** for fillet welds.

Rev 1	Drawn by: AMU	Scale: 1:4	6 of 6
Hibachi Grill - SkillsUSA Texas Secondary Team Fabrication			



**Sample WPS Form (GTAW & SMAW)
WELDING PROCEDURE SPECIFICATION (WPS)**

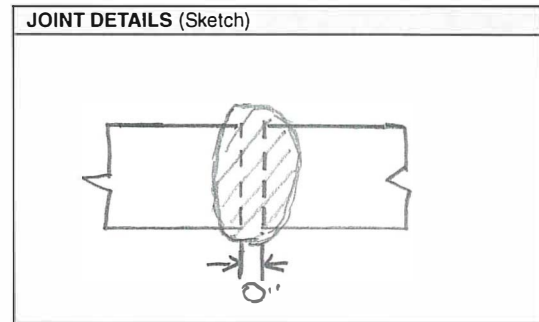
SkillsUSA Texas
 Company Name _____
 AMU _____ 01.23.2024
 Authorized by _____ Date _____

FCAW1_WPS _____ 0 _____ 01/23/2024
 WPS No. _____ Rev. No. _____ Date _____
 None (Prequalified) _____ No _____
 Supporting PQR(s) _____ CVN Report _____

BASE METALS	Specification	Type or Grade	AWS Group No.
Base Material	A36	-	1
Welded To	A36	-	1
Backing Material	-		
Other			

BASE METAL THICKNESS	As-Welded	With PWHT
CJP Groove Welds	-	
CJP Groove w/CVN	-	
PJP Groove Welds	1/8 - 3/16 in	
Fillet Welds	-	
DIAMETER	-	

JOINT DETAILS	
Groove Type	Square Groove
Groove Angle	
Root Opening	0
Root Face	
Backgouging	None
Method	



POSTWELD HEAT TREATMENT	
Temperature	N/A
Time at Temperature	-
Other	-

PROCEDURE									
Weld Layer(s)	1								
Weld Pass(es)	1								
Process	FCAW-S								
Type (Manual, Mechanized, etc.)	Manual								
Position	Flat								
Vertical Progression	N/A								
Filler Metal (AWS Spec.)	A5.29								
AWS Classification	E71TG-G								
Diameter	0.035								
Manufacturer/Trade Name	Innershield NR								
Shielding Gas Compos. (GTAW)	None								
Flow Rate (GTAW)	-								
Nozzle Size (GTAW)	-								
Preheat Temperature	N/A								
Interpass Temperature	-								
Electrical Characteristics									
Electrode Diameter (GTAW)									
Current Type & Polarity	DCEN								
Amps	60								
Volts	15-16								
Cold or Hot Wire Feed (GTAW)	-								
Travel Speed	6-7 ipm								
Maximum Heat Input									
Technique									
Stringer or Weave	Stringer								
Multi or Single Pass (per side)	Single								
Oscillation (GTAW Mech./Auto.)	-								
Traverse Length	-								
Traverse Speed	-								
Dwell Time	-								
Peening	-								
Interpass Cleaning	Wire Wheel								
Other	-								

**Sample WPS Form (GTAW & SMAW)
WELDING PROCEDURE SPECIFICATION (WPS)**

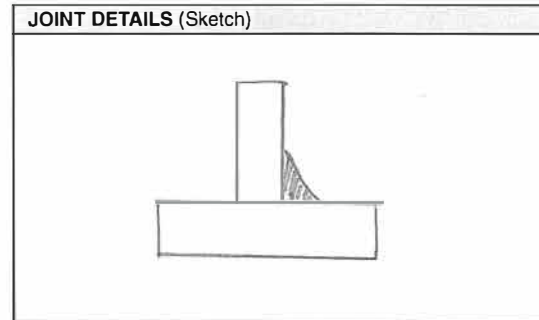
SkillsUSA Texas
 Company Name _____
 AMU _____ Date 01.23.2024
 Authorized by _____ Date _____

FCAW2_WPS _____ 0 _____ 01/23/2024
 WPS No. _____ Rev. No. _____ Date _____
 None (Prequalified) _____ No _____
 Supporting PQR(s) _____ CVN Report _____

BASE METALS	Specification	Type or Grade	AWS Group No.
Base Material	A36	-	1
Welded To	A36	-	1
Backing Material	-	-	-
Other			

BASE METAL THICKNESS	As-Welded	With PWHT
CJP Groove Welds	-	-
CJP Groove w/CVN	-	-
PJP Groove Welds	-	-
Fillet Welds	1/8 - 3/16 in	-
DIAMETER	-	-

JOINT DETAILS	
Groove Type	T-Joint
Groove Angle	-
Root Opening	-
Root Face	-
Backgouging	None
Method	



POSTWELD HEAT TREATMENT	
Temperature	N/A
Time at Temperature	-
Other	-

PROCEDURE								
Weld Layer(s)	1							
Weld Pass(es)	1							
Process	FCAW-S							
Type (<i>Manual, Mechanized, etc.</i>)	Manual							
Position	Horizontal							
Vertical Progression	N/A							
Filler Metal (AWS Spec.)	A5.29							
AWS Classification	E71TG-G							
Diameter	0.035							
Manufacturer/Trade Name	Innershield NR							
Shielding Gas Compos. (GTAW)	None							
Flow Rate (GTAW)	-							
Nozzle Size (GTAW)	-							
Preheat Temperature	N/A							
Interpass Temperature	-							
Electrical Characteristics	---	---	---	---	---	---	---	---
Electrode Diameter (GTAW)								
Current Type & Polarity	DCEN							
Amps	60							
Volts	15-16							
Cold or Hot Wire Feed (GTAW)	-							
Travel Speed	6-7 ipm							
Maximum Heat Input								
Technique	---	---	---	---	---	---	---	---
Stringer or Weave	Stringer							
Multi or Single Pass (per side)	Single							
Oscillation (GTAW Mech./Auto.)	-							
Traverse Length	-							
Traverse Speed	-							
Dwell Time	-							
Peening	-							
Interpass Cleaning	Wire Wheel							
Other	-							