Procedure:

You will be issued (4) pieces of material; (1) piece of 1-1/2" black pipe and (3) pieces of 3/8" x 4" x 4" hot rolled flat. Assemble the material according to the specifications below, using the welding rod of your choice. You are allowed to tack-weld the assembly together in any position, but the actual welding must be done as specified below. Any contestants caught welding in an incorrect position will lose the points for that particular weld. When you are finished, quench your project, make sure your contestant number is written on your project and the backside of this sheet, and submit your project to the judges.

- **3/8" x 4" x 4" HR**
- **Single fillet, full open corner, any position**
- **1-1/2" black pipe centered on vertical plate**
- **3 pass fillet, any position: 1st pass - full length, 2nd pass - 2/3 length, 3rd pass - 1/3 length**
- **Vertical fillet uphand, 1 pass**
- **3/8" x 4" x 4" HR**
- **Single pass, flush corner, horizontal only**