

15<sup>TH</sup> ANNUAL NCJLS A WS MIKE MYLNAR MEMORIAL  
WELDING CONTEST

SCHEDULE OF EVENTS

9:00 – 9:30 – OPENING INTRODUCTIONS & SAFETY MTG

9:30 – 10:15 – SERIES A PLATE COMPETITION (8 BOOTHS)

9:30 – 9:50 – SERIES A PIPE FIT UP & TACK (8 BOOTHS)

10:00 – 10:40 – SERIES A PIPE WELD OUT

10:15 – 11:00 – SERIES B PLATE COMPETITION (8 BOOTHS)

10:40 – 11:00 – SERIES B PIPE FIT UP & TACK (8 BOOTHS)

11:00 – 11:40 – SERIES B PIPE WELD OUT

11:00 – 11:30 – LUNCH

1:00 – 1:30 – JUDGING OF PLATE & PIPE COUPONS AND  
AWARDS CEREMONY

1:30 – 2:00 – TEARDOWN AND CLEANUP!

DURING COMPETITION, NO ONE IS ALLOWED IN THE BOOTH,  
BUT THE CONTESTANTS AND THE JUDGES.

American Welding Society Nueces County  
Junior Livestock Show 15TH Annual Mike  
Mylnar Memorial High School Welding  
Contest Registration Form

Student's Name: \_\_\_\_\_

School: \_\_\_\_\_

Instructor: \_\_\_\_\_

Grade Level: \_\_\_\_\_

AS the instructor, of the above student, I recommend this student for competition in the High School Welding Competition. The Student is in good standing with his/her school.

\_\_\_\_\_  
Instructor's Signature Date

I agree to assume all liability, while competing, in the High School Welding Contest and hold harmless anyone person or company connected with the High School Welding Contest and/or the AWS, Nueces County Junior Livestock Show.

\_\_\_\_\_  
Contestant's Signature Date

\_\_\_\_\_  
Parent/Guardian's Signature Date

Please return by January 5, 2018

Email, Mail or Fax completed entries to:

ellery.francisco@gasandsupply.com

GAS AND SUPPLY  
5125 IH 37 @ Navigation  
Corpus Christi, Tx. 78408  
Fax#361-888-9089

## Pipe Welding Contest Rules and Scoring

1. Pipe teams will consist of two (2) contestants, one fitter and one welder.
2. Competing High Schools and High School Technical Schools may enter as many as three (3) Pipe teams per High School depending on the number of teams entered.
3. All standard tools used for Pipe Fitting and Weld Out will be allowed.
4. Pipe Contestants must use the welding tables provided and may use their own manual Roll Out wheel if they wish.
5. Pipe Welding contestants will use the SMAW Electrodes provided and will not be allowed to supply their own E6010 1/8" or E7018 3/32" electrodes.  
Note: If a contestant is caught using SMAW electrodes not provided by the Contest they will be disqualified immediately.

### Scoring:

The first five (5) scoring categories: 1. Bevel & End Prep- 2. Tack and Fit-Up- 3. Weld Out (Visual)- 4. Safety- 5. Team Work- will be scored using a 1 to 10 point system, with 10 points being the highest score attainable in each category.

Time Limits/Hold Points are as follows:

20 minutes to fit and tack weld coupons, couplet, and flange as per the Pipe WPS  
40 minutes to weld out the pipe coupon as per the Pipe WPS

At the end of each Time Limit/Hold Point all work will stop. The judges will score each team after every Time Limit/Hold Point. If the work in each category is not completed within the time allotted, the team will be allowed to finish the task. But, a deduction of 5 points will be assessed for each time limit infraction.

If the pipe team passes X-ray they will receive 50 points for passing. If the pipe team does not pass X-ray they will receive a deduction of 10 points for the following weld flaws: Slag Inclusions, Porosity, Inadequate Penetration, and Excessive Penetration.

The Pipe Contest judges will read the X-rays and consult with the X-ray Technician, and in conjunction with the scoring listed above determine the 1<sup>st</sup>, 2<sup>nd</sup>, and 3<sup>rd</sup> place Pipe Teams accordingly.

Digital X-ray standard used shall be ASME B31.3

## Plate Welding Contest Rules and Scoring

1. Plate T-Butt 3f contest is an individual event.
2. Competing High Schools and High School Technical Schools may enter as many Plate contestants as time constraints will allow.
3. All standard tools used for plate welding and weld out will be allowed.
4. Plate T-Butt 3f contestants must use the welding tables provided for the contest.
5. Plate T-Butt 3f contestants will use the E7018 3/32" SMAW electrodes provided for the contest and will not be allowed to supply their own electrodes.  
Note: If a contestant is caught using E7018 3/32" electrodes not provided by the contest. That contestant will be disqualified immediately.

### Scoring:

The T-Butt Joints welded in 3f position will be scored according to AWS Standards set forth in AWS D1.1/D1.1M:2015 Part C- Performance Qualifications 4.30.1 Visual Inspection.

Judges will grade the T-Butt Weld Coupons based on quality of fillet welds, fillet size, porosity, undercut, convexity, concavity, safety, and time allotted using a scoring system of 1 to 10.

Judges may resort to Digital X-ray to determine the winner of the T-Butt 3f contest if the winner cannot be determined using visual inspection methods provided for in AWS D1.1/D1.1M:2015 Part C- Performance Qualifications 4.30.1 Visual Inspection.

Digital X-ray if required will be conducted in accordance with AWS D1.1 Part C- Performance Qualifications 4.30.3 Radiographic Test and judged according to AWS D1.1 Part C- Performance Qualifications 4.30.3.1 Radiographic Test Acceptance Criteria.

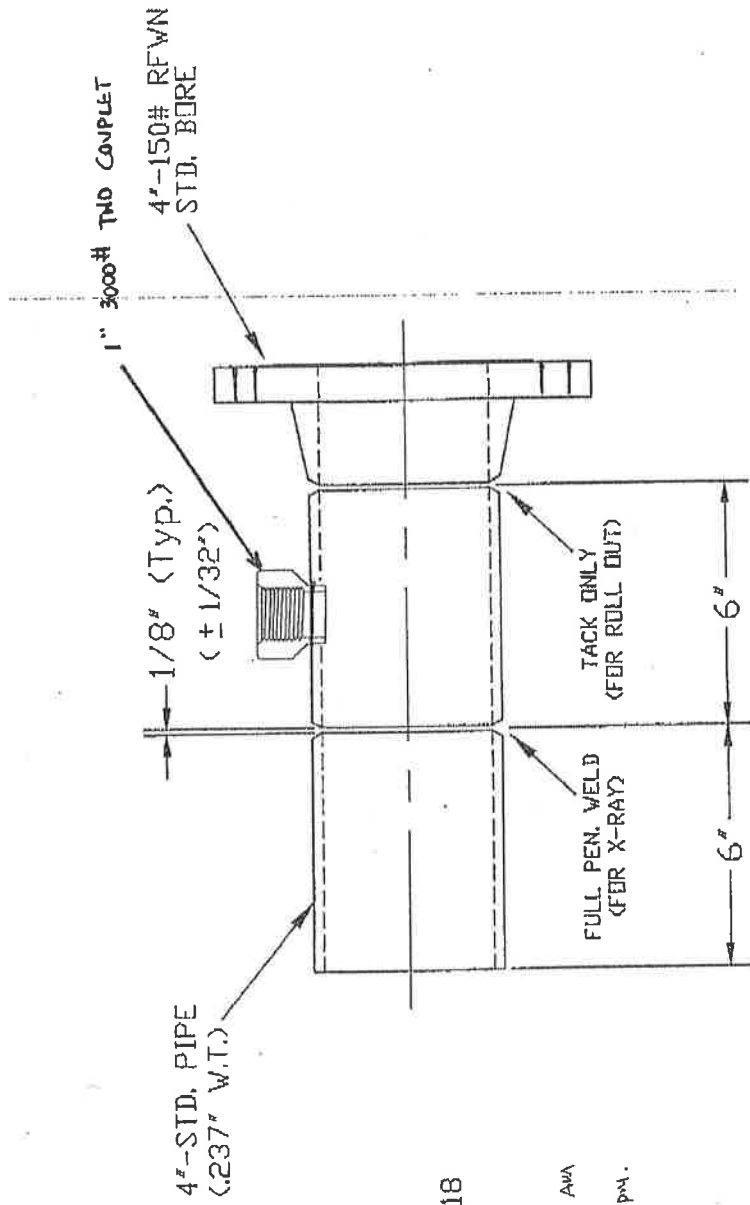
# Pipe Spool for 15th Annual High School Welding Contest

9:00 AM – 2:00 PM, Friday – January 12, 2018 • Richard M Borchard Fairgrounds (Exhibit Hall A)

Mail completed entries to: Gas and Supply, 5125 IH37 @ Navigation, Corpus Christi, TX 78408

For more information contact Ellery D. Francisco CWI [ellery.francisco@gasandsupply.com](mailto:ellery.francisco@gasandsupply.com) or the NCJLS Show Office at 361-387-5395

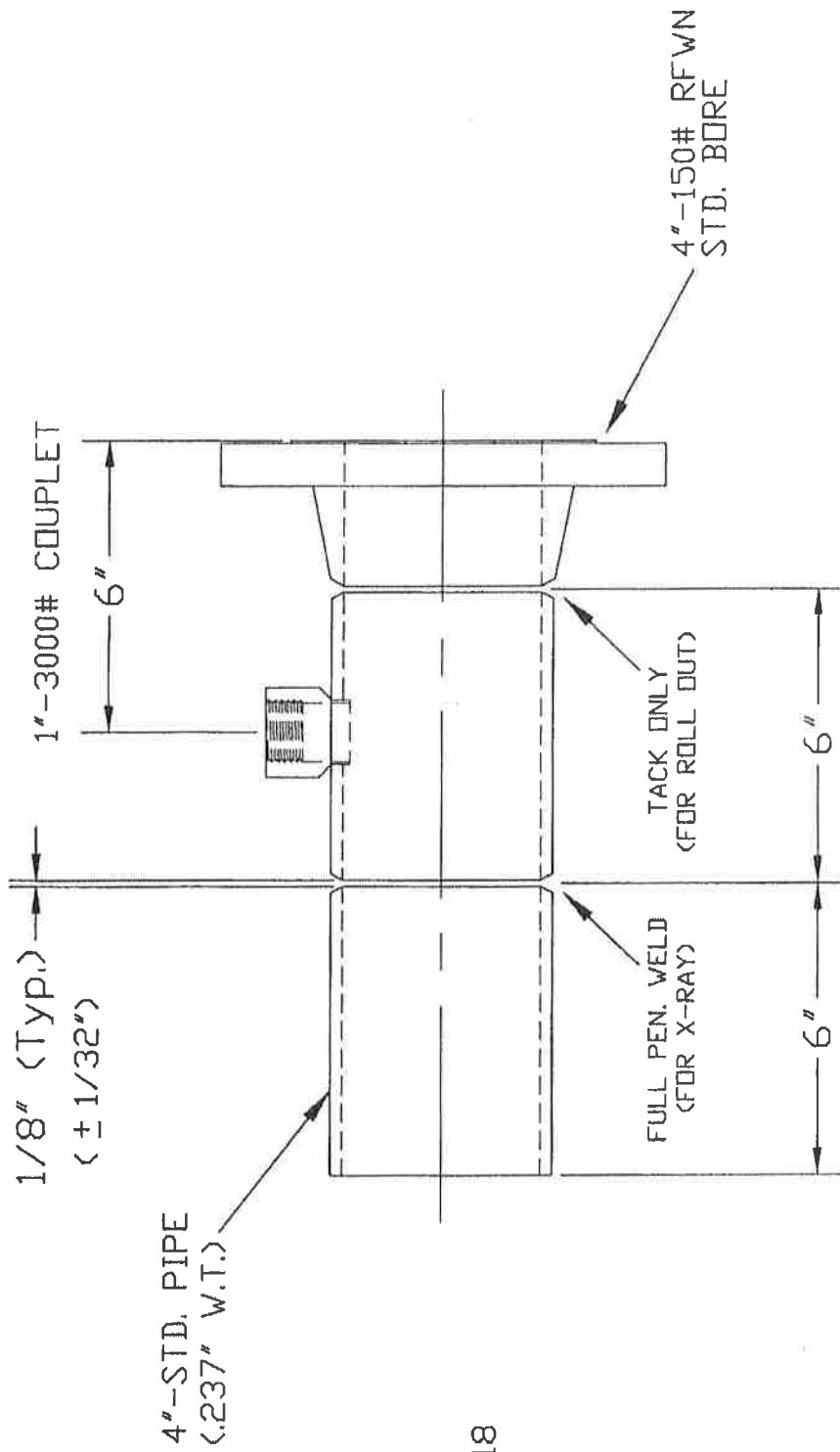
- 2 Person Prep Bevels
- 2 Person Team to Tack Weld Pipe Coupons and Flange
- 2 Person Team to Perform Weld Out on 4" Pipe and 1" Couplet (Couplet Must be two holed to Flange)



ROD #

ROOT PASS = 6010  
 HOT PASS = 6010  
 FILLER & CAP = 7018

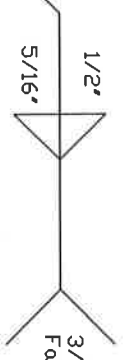
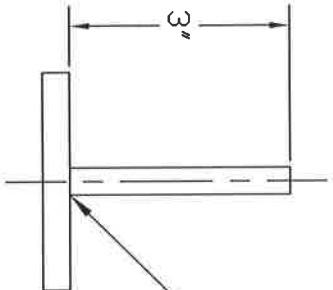
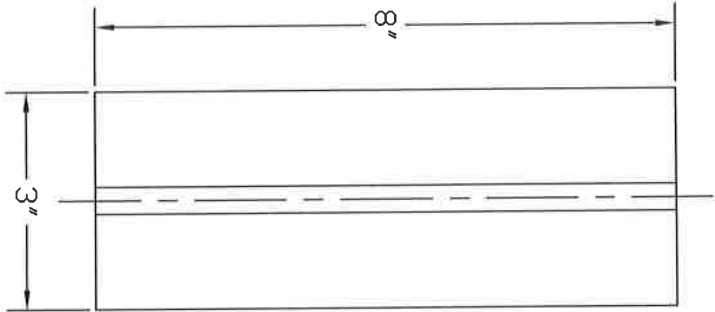
PLATE 10:00 AM – 11:00 AM  
 PIPE 12:00 Noon - 2:00 PM



ROOT PASS = 6010  
HOT PASS = 6010  
FILLER & CAP = 7018

~PARTS LIST~

R	PART	DESCRIPTION	LENGTH	QTY	PROCESS	MATERIAL



3/32" E7018  
Far side shall consist of 3 passes.

NOTES

- ~TOLERANCES ARE +- 1/8"
- ~REMOVE ALL SLAG
- ~ALL PLATE 3/8"
- ~WELD IN 3F POSITION

DRAWN BY: CL

NCJLS-WC

DATE: 1/9/13

JOB: T JOINT

DWG: 1 OF 1

# Welding Safety & Procedures

1. All equipment including grinders and welding buckets will be inspected. Outside welding rods are not allowed in the competition area.
2. All PPE must meet OSHA standards.
3. All contestants must have proper safety glasses, face shields, ear plugs, and proper footwear.
4. Double protection is required for all grinding and chipping. (Double protection is defined as safety glasses plus either a clear face shield or welding hood in the down position.
5. Gloves must be worn when operating any power tool & welding machine. All metal is considered "HOT" at all times!
6. Electronic devices, especially cell phones, are not allowed during competition, possession of devices during competition will result in immediate disqualification.
7. All contestants will be escorted to and from the restroom.
8. All injuries are to be reported immediately to a judge or safety representative.
9. Minor Safety Violations during competition will result in deduction of points.
10. Major Safety Violations will result in immediate disqualification.
11. Contestants will be allowed to become familiar with the welding equipment. Instructions will be provided upon request.

Note: Remember to set the proper polarity for the SMAW electrodes being used.