

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 1st, 2nd, and 3rd place Pipe Teams accordingly.

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

