

PRACTICAL TEST MARK SHEET FOR
OXY-ACETYLENE GAS WELDING AND CUTTING



FILLET WELD

This sheet covers the following Units:

Level 2 Award and Certificate in Fabrication and Welding Practice

Unit 2: Oxy-Acetylene Gas Welding and Cutting

Level 3 Award, Certificate and Diploma in Fabrication and Welding Practice

- Unit 2: Oxy-Acetylene Gas Welding and Cutting - Vertical
- Unit 9: Oxy-Acetylene Gas Welding and Cutting - Overhead
- Unit 10: Oxy-Acetylene Gas Welding – Overhead (Aluminium)
- Unit 11: Oxy-Acetylene Gas Welding – Overhead (Pipe)

Learner's Name:

Centre Name:

To be completed by the course tutor:

Unit	Level 2		Level 3		Level 3		Level 3		Level 3	
	2	Time	2	Time	9	Time	10	Time	11	Time
Material										
Low Carbon Steel		45 mins		60 mins		60 mins				
Aluminium		45 mins		60 mins				60 mins		
Low Carbon Steel Pipe										90 mins
Position used	Horizontal Vertical		Vertical		Overhead		Overhead		Overhead	

Indicate the Unit and Material being tested by putting a tick **P** in the relevant box. The permitted time, in minutes, for carrying out the relevant practical test is given in the box next to where the tick is to be put.

To be completed by the learner, by hand:

1	Thickness of parent material	
2	Filler specification and diameter	
3	Gas pressures used	
4	Nozzle size	

Part 1: Visual Examination of Product

			Grade Awarded			
	Defect type	Specification and assessment criteria	D	M	P	F
1	Cracks	Cracks are NOT permitted. Pass or Fail only. If a Fail then do not proceed.				
2	Porosity / gas holes / oxide inclusion	Total joint length to be free of all inclusions: Distinction = 200mm Merit = 190mm Pass = 180mm Fail = < 180mm				
3	Lack of fusion	Side wall and root. Total joint length with complete fusion: Distinction = 190mm Merit = 170mm Pass = 150mm Fail = < 150mm				
4	Lack of penetration	Total length of full penetration: Distinction = 180mm Merit = 150mm Pass = 120mm Fail = < 120mm				
5	Undercut (measurable on both sides, i.e. 400mm)	Maximum permitted depth = 10% of thickness. Total joint length to be free of undercut: Distinction = 340mm Merit = 320mm Pass = 300mm Fail = < 300mm				
6	Excessive convexity / asymmetry	Reinforcement smooth, even ripples, uniform and equal leg lengths. Total joint length with complete and even leg lengths: Correct weld size: Distinction = 170mm Merit = 160mm Pass = 150mm Fail = < 150mm				
7	Overlap (measurable on both sides, i.e. 400mm)	Total joint length to be free from overlap: Distinction = 400mm Merit = 385mm Pass = 375mm Fail = < 375mm				
8	Angular misalignment	Angular misalignment at any point along the length not to exceed the following: Distinction = none Merit = up to 30% thickness Pass = up to 50% thickness Fail = > 50% thickness				
9	Linear misalignment	Linear misalignment at any point along the length not to exceed the following: Distinction = none Merit = up to 10% thickness Pass = up to 15% thickness Fail = > 15% thickness				
10	Incompletely filled groove	Maximum depth of 0.5mm, but only intermittent. Total joint length with completely filled groove: Distinction = 170mm Merit = 160mm Pass = 150mm Fail = < 150mm				
How to determine the grade for Part 1:			D	M	P	F
Distinction = 7 Distinctions and all other grades to be Pass or higher Merit = 7 Merits or greater and all other grades to be Pass or higher Pass = No Fail grade Fail = Any Fail grade		Grade Awarded for Part 1				

Key:

D = Distinction

M = Merit

P = Pass

F = Fail

Part 2: Destruction Examination

			Grade Awarded			
	Test	Assessment Criteria (Pass / Fail only)	D	M	P	F
1	Macro-etch examination	To be done at a stop/start position. Adequate side/root fusion. Internal defects – total cumulative faults no more than 10% of the surface area.				
2	Fracture test	Slag, porosity, gas pores, lack of fusion to walls. Total cumulative faults to be no more than 25% of the surface area.				
How to determine the grade for Part 2:			D	M	P	F
Pass = 2 Passes Fail = Any Fail grade			Grade Awarded for Part 2			

How to determine the overall grade for this practical test:			
Part 1	Part 2	Overall Grade Achieved	
			Course Tutor Signature
Distinction	Pass	Distinction	
Merit	Pass	Merit	
Pass	Pass	Pass	
Any Fail Grade		Fail	

Course Tutor Feedback	
Comment:	
Learner Signature:	Course Tutor Signature:
Date:	Date:
Internal Moderator / Verifier Feedback (if sampled)	
Comment:	
Internal Moderator / Verifier Signature:	Date:
External Moderator (if sampled)	
I have checked the information recorded in this document and am* / am not* satisfied of its accuracy, authenticity and validity (* Delete as appropriate and comment if required)	
External Moderator Signature:	Date:



DECLARATION OF AUTHENTICITY

This declaration must be completed and signed by the learner and countersigned by the tutor/assessor.

Learner Name:

Learner Number:

Centre:

Learner statement of authenticity

I confirm that the attached assignment/portfolio is all my own work* and does not include any work completed by anyone other than myself. I have completed the assignment/portfolio in accordance with the Awarding Body instructions and within the time limits set by my Centre.

Signature:

Date:

Centre confirmation of authenticity

On behalf of(insert centre name), I confirm that the above mentioned learner, to the best of my knowledge, is the sole author of the completed assignment/portfolio attached.

Signed:

Date:

Name:

Job Description:

*Unless otherwise stated e.g. for some entry level qualifications learners can work together but should show sections which are their own work.