

“FABRICATION AND MACHINE COMPONENT MANUFACTURE”

INDUSTRIAL TRAINING REPORT

Submitted by

BODAR NIKSHIT MANISHBHAI

200140119081

In partial fulfilment for the award of the degree of

BACHELOR OF ENGINEERING

in

Mechanical Engineering

Government Engineering College, Bharuch



Gujarat Technological University, Ahmedabad

AUGUST, 2023



Government Engineering College, Bharuch

Bholav opp. Govt Guest House, Bharuch

CERTIFICATE

This is to certify that the project report submitted along with the project entitled **“FABRICATION AND MACHINE COMPONENT MANUFACTURE”** has been carried out by **BODAR NIKSHIT MANISHBHAI [200140119081]** under my guidance in partial fulfilment for the degree of Bachelor of Engineering in Mechanical Department, 7th Semester of Gujarat Technological University, Ahmadabad during the academic year 2023-24.

Prof. A. A. Shekh

Internal Guide

Dr. K. V. Modi

Head of the Department



Internship Approval Certificate

This is to certify that internship work titled “FABRICATION AND MACHINE COMPONENT MANUFACTURE” was carried out by BODAR NIKSHIT MANISHBHAI (200140119081) at DIVINE ENGINEERING SERVICES PVT. LTD., SURAT is approved for the degree of Bachelor of Engineering in Mechanical Engineering by Gujarat Technological University.

Date :

Place :

Examiner's Sign and Name:

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INDUSTRY CERTIFICATE

DIVINE

ENGINEERING SERVICES PVT. LTD.
CIN : U93000GJ2019PTC108950

M. 8866735967

Plot No. A-1/613, New Water Tank, Road No.6,
Sachin GIDC, Surat- 394230 (Gujarat)

No:

Date :- 07 / 08 / 2023

TO WHOM IT MAY CONCERN

This is to certify that, Mr. Bodar Nikshit Manishbhai Enrollment No 200140119081
Student of 7th Sem Mechanical, has successfully completed a two week Internship in the field of
Fabrication and Machine Components Manufacturing during the period of 25/07/2023 to
07/08/2023 During the period of his/her internship program with us, He/She had been
exposed to different processes and was found sincere and hardworking.

Authorised Signature


Mentor Signature

Institute Head





Government Engineering College, Bharuch

Bholav opp. Govt Guest House, Bharuch

DECLARATION

We hereby declare that the 2 Weeks Internship report submitted along with the 2 Weeks Internship entitled Fabrication and Machine Component Manufacture submitted in partial fulfilment for the degree of Bachelor of Engineering in Mechanical department to Gujarat Technological University, Ahmedabad, is a bonafide record of original project work carried out by me at DIVINE ENGINEERING SERVICES under the supervision of Manojbhai Bhamare and that no part of this report has been directly copied from any students' reports or taken from any other source, without providing due reference.

BODAR NIKSHIT MANISHBHAI

Name of the student:

Sign of student

ACKNOWLEDGEMENTS

We express our earnest gratitude to Advisor, Manojbhai at Divine Engineering Services. Who has given us all the necessary technical guidance in carrying out this project. We are grateful for his cooperation and his valuable suggestions.

The acknowledgements are extended to express gratitude and appreciation for the invaluable support and guidance received during the internship program. The internship experience has been a significant milestone in the academic and professional development of the intern, and the contributions of various individuals and organizations have been instrumental in making it a success.

The intern would like to express heartfelt gratitude to all parties involved in the internship program. The experience has been invaluable, and the intern is confident that the skills and knowledge gained will be beneficial in future endeavours.

Date:

BODAR NIKSHIT MANISHBHAI

Place: Olpad, Surat, Gujarat

(200140119081)

ABSTRACT

This report presents an overview of activities of my in-internship training at DIVINE ENGINEERING SERVICES PVT. LTD. Main objective of this internship is to study about the various equipment used in and the various processes in fabrication industry.

The fabrication industry is a vital sector that plays a significant role in the global economy. This industry is responsible for the production of various products, including machinery, equipment, and structures, among others. The fabrication process involves the use of various materials, such as metals, plastics, and composites, to create these products. the fabrication process including design, material selection, manufacturing, and quality control.

During my internship, I learned about equipment parameter, Safety, Production, Machining etc. This internship was a perfect opportunity to apply some of the Knowledge that I have learned in previous courses. In addition, I was able to Develop some additional soft skills like communication, teamwork, Flexibility. A detailed study of the various unit operations is done during this Training. This report discusses the Skills gained and Experience gathered during the Period of training and to make meaningful by reflecting unit operation and unit process at the company.

I am glade to present this internship training report which contains the contents regarding the concepts of practical training through which I passed.

LIST OF FIGURES

Fig 1. 1 Company Photo.....	1
Fig 2. 1 Lathe Machine.....	5
Fig 2. 2 Drilling Machine.....	6
Fig 2. 3 Bending Machine	7
Fig 2. 4 Shearing Machine	8
Fig 2. 5 Grinding Machine	9
Fig 2. 6 CNC Turning Machine.....	10
Fig 2. 7 VMC Machine	11
Fig 2. 8 Plasma Cutting Machine.....	12
Fig 2. 9 Rolling Machine	13
Fig 2. 10 Electric Hoist Travelling Crane	14
Fig 3. 1 MIG Welding	15
Fig 3. 2 Shielded Metal Arc Welding.....	16
Fig 3. 3 Argon (TIG) Welding.....	17
Fig 3. 4 Different welding joints	18
Fig 3. 5 Cruciform joint	20
Fig 4. 1 Personal protective equipment.....	22

LIST OF TABLES

Table 1 Types of Machine	4
Table 2 Workpiece thickness limits per joint type	21

Table of Contents

DECLARATION.....	i
ACKNOWLEDGEMENTS	ii
ABSTRACT.....	iii
LIST OF FIGURES	iv
LIST OF TABLES	iv
• CHAPTER-1 INTRODUCTION ABOUT COMPANY.....	1
1.1 About Company	1
1.2 Company Vision.....	2
1.3 Company Mission	2
1.4 Different Departments	2
1.5 Company Services	3
1.6 Company Clients	3
• CHAPTER-2 DIFFERENT MACHINES	4
2.1 Lathe Machine	5
2.2 Drilling Machine.....	6
2.3 Bending Machine.....	7
2.4 Shearing Machine	8
2.5 Grinding Machine	9
2.6 CNC Turning Machine	10
2.7 VMC Machine	11
2.8 CNC Plasma Cutting Machine.....	12
2.9 Rolling Machine	13
2.10 Electric Hoist Travelling Crane	14
• CHAPTER-3 WELDING.....	15
→ Types of Welding used in Company.....	15
→ Different Welding Joints:.....	18
• CHAPTER-4 INDUSTRIAL SAFETY.....	22
→ Personal Protective Equipment:	22
CONCLUSION	24
REFERENCES	25

🌈 CHAPTER-1 INTRODUCTION ABOUT COMPANY

1.1 About Company



Fig 1. 1 Company Photo

- An ISO 9001-2015 certified leading manufacturer of fabricated and machined components for bulk material handling and mechanical transmission equipment's; providing services for machining and fabrication.
- It gives immense pleasures to introduce ourselves as one of the leading engineering works in the field of unlimited engineering known as DIVINE ENGINEERING SERVICE. The organization is under modernization with various competent machineries for providing solutions to any sort of engineering. The motto of our skilled teams to provide delivery of quality-wise good and the ultimate satisfaction to our valued customers as they are our fundamental base and inspiration. We are specialized in heavy fabrication in SS, MS in precision works too. We strongly believe of saying "HARD WORK IS THE KEY TO SUCCESS".

1.2 Company Vision

- We understand that to build long-term relations with our customers, we have to ensure timely delivery of products with right quality. To ensure timely delivery we should have dedicated & experienced.
- ✓ Planning team for resource planning & detailing
- ✓ Strong field supervision team
- ✓ Skilled technicians

1.3 Company Mission

- We at DIVINE ENGINEERING SERVICE ensure that all our Products and related services conform to International Quality standards and our clients get perfect value for their money.
- Planning for new products and related services begins with understanding our Customers & Clients Requirement and creating the best user experience.

1.4 Different Departments

- Admin
- Design
- Material Requirement Planning
- Manufacturing
- Quality Control
- Painting & Blasting
- Packaging
- Dispatch

1.5 Company Services

- PEB Structure
- Framing
- Custom Fabrication
- Sheet Metal Fabrication
- Custom Welding
- Heavy Fabrication
- Rolling
- Painting & Blasting
- CNC Machining
- VMC Machining

1.6 Company Clients

- NTPC (National Thermal Power Corporation)
- L & T (Larsen & Toubro) Defence
- L & T Hydrocarbon Engineering
- L & T Howden
- L & T Heavy Engineering
- ESSAR
- Neo Structo Construction Pvt. Ltd.
- PRIMETALS Technologies
- ZEECO
- SMS GROUP

CHAPTER-2 DIFFERENT MACHINES

Table 1 Types of Machine

Sr no.	Types of Machines
1	CNC Turning
2	VMC Machine
3	Radial Drill
4	Hand Drill
5	Shearing machine
6	Bending machine
7	Portable Grinder
8	Lathe machine
9	CNC Plasma cutting
10	Rolling machine
11	MIG welding
12	Argon (TIG) welding

2.1 Lathe Machine



Fig 2. 1 Lathe Machine

- The lathe machine is a tool utilized in the manufacturing industry for shaping and cutting various materials, including wood, metal, and plastic. It is a versatile machine that can perform a range of operations, such as turning, drilling, and threading. The lathe machine consists of a rotating workpiece and a cutting tool that moves along the workpiece to remove material and create the desired shape. This machine has been in use for centuries and has undergone significant advancements in design and functionality over time. Its importance in the manufacturing industry cannot be overstated, as it plays a crucial role in the production of a wide range of products.

2.2 Drilling Machine



Fig 2. 2 Drilling Machine

- The drilling machine is a mechanical device utilized for creating holes in various materials, including metal, wood, and plastic. It is a versatile tool that can be operated manually or automatically, depending on the specific application. The machine typically consists of a motor, a drill bit, and a chuck that holds the bit in place. The drill bit rotates at high speeds, allowing it to penetrate the material and create a hole of the desired size and shape. The drilling machine is widely used in various industries, including construction, manufacturing, and woodworking, due to its efficiency and precision.
- Drilling machines are commonly used in manufacturing, construction, woodworking, metalworking, and DIY projects. They come in different types and sizes, such as benchtop, floor-mounted, portable, and magnetic drilling machines, to suit various applications and user preferences.

2.3 Bending Machine



Fig 2. 3 Bending Machine

- The bending machine is a mechanical device that is utilized to bend various materials, such as metal sheets, pipes, and wires, into specific shapes and angles. This machine is commonly used in industrial settings, particularly in the manufacturing and construction industries, to produce a wide range of products, including furniture, automotive parts, and building components.
- The bending process involves applying force to the material, causing it to deform and take on the desired shape. The bending machine typically consists of a frame, a bending tool, and a control system, which work together to ensure precise and accurate bending.
- The use of bending machines has revolutionized the production process, enabling manufacturers to produce complex shapes and designs with greater efficiency and accuracy.

2.4 Shearing Machine



Fig 2. 4 Shearing Machine

- The first step in fabricating a sheet metal component is cutting to size. Shearing machines and shearing machinery perform this function. Shearing machines are multipurpose devices used in the cutting of alloys and other sheet metal. Some shearing machines use a scissor-like, angular shear action to cut metal into sheets or strips. Other, larger machines use a straight shear action with the blade fixed at an angle as opposed to the angular movement.
- Shearing operations are performed by the action of two blades, one fixed in the shear bed and the other moving vertically with little or no clearance. Shear action moves progressively from one side of the material to the other. The angular configuration of the blades is called the rake. Both rake and clearance are a function of the type and thickness of the material to be cut. In press type shears, the upper blade is inclined in relation to the lower blade, about 0.5 to 2.5 degrees.
- The typical shear consists of a fixed bed to which one blade is mounted, a vertically advancing crosshead and a series of hold-down pins or feet that hold the material in place while the cutting occurs. A gauging system with stops is used to produce specific workpiece finish sizes.

2.5 Grinding Machine

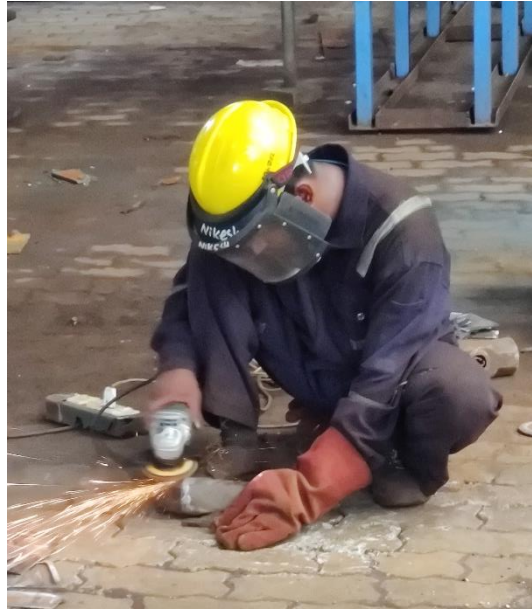


Fig 2. 5 Grinding Machine

- A grinding machine, often shortened to grinder, is a power tool (or machine tool) used for grinding. It is a type of machining using an abrasive wheel as the cutting tool. Each grain of abrasive on the wheel's surface cuts a small chip from the workpiece via shear deformation.

2.6 CNC Turning Machine



Fig 2. 6 CNC Turning Machine

- The CNC turning machine is a computer-controlled device utilized in the manufacturing industry for the purpose of shaping and cutting materials such as metal, plastic, and wood. This machine is capable of producing intricate and precise designs with high accuracy and consistency. The CNC turning machine is a vital tool in modern manufacturing processes, as it allows for the efficient and cost-effective production of complex parts and components. Its advanced technology and automated features have revolutionized the manufacturing industry, enabling manufacturers to produce high-quality products at a faster rate and with greater precision.
- The CNC turning machine is a advanced computer numerical control system enables it to execute complex operations with high accuracy and efficiency. This machine is widely used in the production of components for a diverse range of applications, including aerospace, automotive, medical, and electronics industries. Its versatility and reliability make it an indispensable tool for modern manufacturing processes.

2.7 VMC Machine

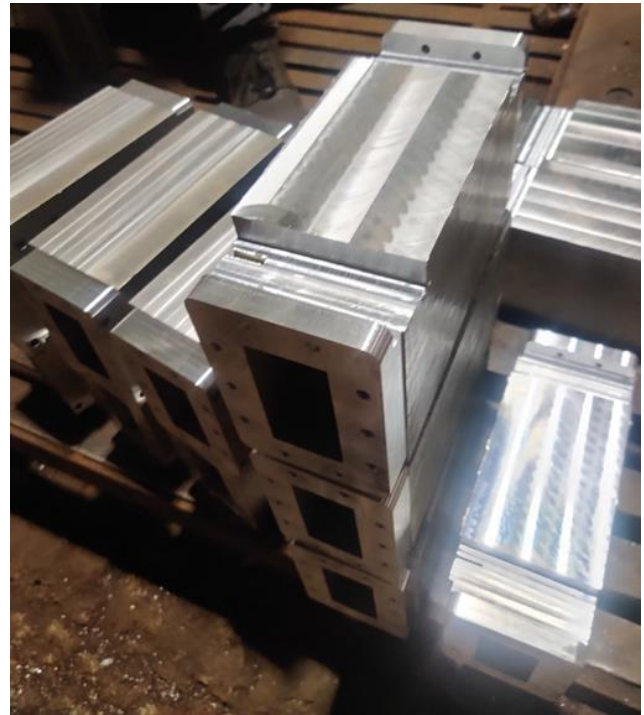


Fig 2. 7 VMC Machine

- The VMC machine, also known as a vertical machining centre, is a type of computer numerical control (CNC) machine tool that is commonly used in the manufacturing industry. This machine is designed to perform a variety of machining operations, including drilling, milling, and tapping, on a wide range of materials, such as metal, plastic, and wood. The VMC machine is characterized by its vertical spindle orientation, which allows for greater precision and accuracy in the machining process. It is a highly versatile and efficient tool that has become an essential component of modern manufacturing processes.
- The VMC machine is a highly advanced piece of equipment utilized in modern manufacturing processes. Its precision and efficiency make it an indispensable tool in the production of complex components and parts. The VMC machine is designed to operate with a high degree of accuracy and consistency, ensuring that the finished products meet the strictest quality standards. Its sophisticated technology and advanced features enable it to perform a wide range of tasks with ease, making it an essential asset in the manufacturing industry.

2.8 CNC Plasma Cutting Machine



Fig 2. 8 Plasma Cutting Machine

- The plasma cutting machine is a device utilized in the industrial sector for the purpose of cutting various materials, including metals, plastics, and wood. This machine employs a high-temperature plasma arc to melt and sever the material being cut. The plasma arc is generated by ionizing a gas, typically compressed air, and then directing it through a small orifice in the cutting nozzle. The resulting plasma jet is capable of reaching temperatures of up to 30,000 degrees Fahrenheit, which allows for precise and efficient cutting of the material. The plasma cutting machine is widely used in industries such as automotive, aerospace, and construction due to its ability to cut through thick materials quickly and accurately.

- A plasma cutting machine is a device for cutting various materials, including metal, using a plasma torch. This technology involves the use of a high-velocity jet of ionized gas, or plasma, to melt and sever the material being cut. Plasma cutting machines are commonly used in industrial settings for their precision and efficiency in cutting thick materials.

2.9 Rolling Machine



Fig 2. 9 Rolling Machine

- The rolling machine is a mechanical device that is utilized to shape and form various materials, such as metal, plastic, and paper, into desired shapes and sizes. This device is commonly used in industrial settings, particularly in manufacturing and production processes, where it plays a crucial role in the fabrication of products. The rolling machine operates by applying pressure to the material being processed, which causes it to deform and take on the desired shape. The machine is typically equipped with a set of rollers that are designed to apply the necessary force and pressure to the material, and can be adjusted to achieve different levels of deformation and shaping. it effortlessly transforms raw materials into perfectly formed cylinders. Overall, the rolling machine is an essential tool in modern manufacturing and production processes, and its versatility and efficiency make it a valuable asset in a wide range of industries.

2.10 Electric Hoist Travelling Crane



Fig 2. 10 Electric Hoist Travelling Crane

- The electric hoist travelling crane is a type of crane that utilizes an electric hoist to lift and move heavy loads. This type of crane is commonly used in industrial settings, such as factories and warehouses, where heavy materials need to be transported from one location to another. The electric hoist travelling crane is designed to be highly efficient and reliable, with a range of features that enable it to handle a variety of different loads and operating conditions. These features include advanced control systems, high-quality materials and components, and robust construction that ensures long-term durability and performance.
- The electric hoist travelling crane is equipped with a variety of safety features to ensure the safety of workers and the protection of the load being lifted. This type of crane is an essential tool for many industries and is widely used in construction, manufacturing, and transportation.
- Overall, the electric hoist travelling crane is a versatile and essential tool for many industries, providing a safe and efficient means of transporting heavy loads with ease and precision.

CHAPTER-3 WELDING

→ Types of Welding used in Company

3.1 MIG Welding

3.2 Shielded Metal Arc Welding

3.3 Argon (TIG) Welding

3.1 MIG Welding



Fig 3. 1 MIG Welding

- MIG welding, also known as Gas Metal Arc Welding (GMAW), is a welding process that utilizes a continuous wire electrode and a shielding gas to join two metal pieces together. This method is commonly used in industrial settings due to its efficiency and versatility. The process involves the use of a welding gun that feeds the wire electrode into the weld pool while simultaneously releasing the shielding gas to protect the weld from atmospheric contamination. MIG welding is a popular choice for welding materials such as aluminium, stainless steel, and mild steel.

- The arc heats the workpiece and melts the wire, which is then deposited to form a weld. MIG welding is known for its versatility, speed, and ease of use, making it a popular choice for both industrial and DIY applications. MIG welding is also known for producing high-quality welds with minimal spatter and distortion. However, it does require a certain level of skill and knowledge to achieve optimal results.

3.2 Shielded Metal Arc Welding

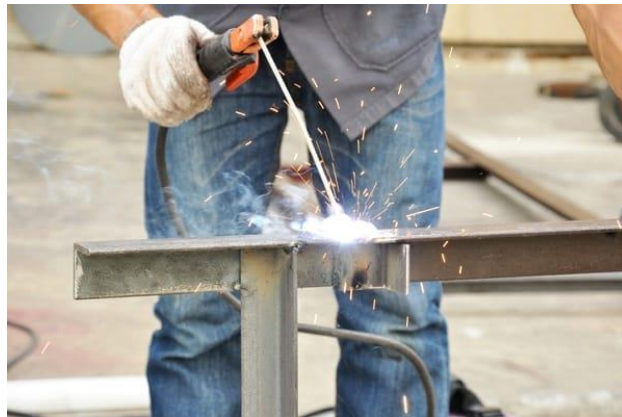


Fig 3. 2 Shielded Metal Arc Welding

- Shielded metal arc welding, also known as SMAW, is a welding process that utilizes a consumable electrode coated in flux to create an electric arc between the electrode and the workpiece. The flux coating on the electrode melts and forms a protective shield around the weld, preventing contamination from the surrounding atmosphere. SMAW is commonly used in industries such as construction, shipbuilding, and pipeline installation due to its versatility and ability to weld a variety of metals and thicknesses.
- SMAW is a versatile welding process that can be used on a variety of metals and in various positions, making it a popular choice in many industries. However, it requires a skilled operator to ensure proper technique and produce high-quality welds.

3.3 Argon (TIG) Welding



Fig 3. 3 Argon (TIG) Welding

- The process of Argon (Tungsten Inert Gas) welding involves the use of a non-consumable tungsten electrode to produce an electric arc that melts the base metal and filler material. The welding area is shielded from atmospheric contamination by a flow of inert gas, typically argon.
- This technique is commonly used in the welding of non-ferrous metals such as aluminium, magnesium, and titanium, as well as stainless steel and other alloys.
- Argon (TIG) welding is known for its high quality and precision, making it a popular choice in industries such as aerospace, automotive, and medical device manufacturing.

→ Different Welding Joints:

- Square butt joints
- V-joints
- J-joints
- U-joints
- Tee-Joints
- Cruciform joint

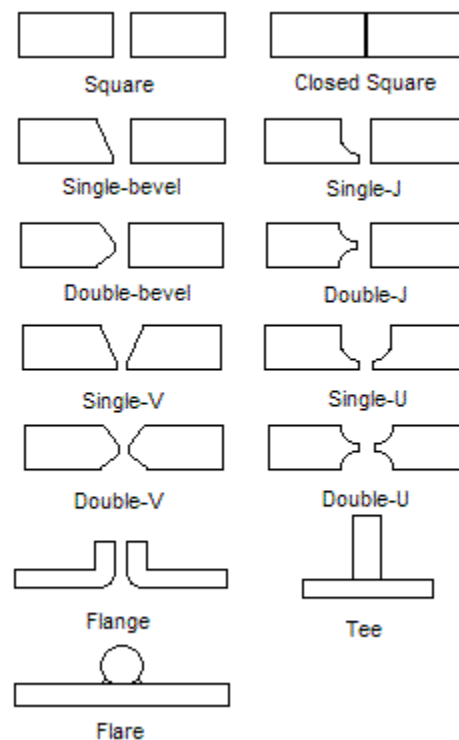


Fig 3. 4 Different welding joints

➤ Square butt joints:

The square groove is a butt welding joint with the two pieces being flat and parallel to each other. This joint is simple to prepare, economical to use, and provides satisfactory strength but is limited by joint thickness. The closed square butt weld is a type of square-groove joint with no spacing in between the pieces. This joint type is common with gas and arc welding. For thicker joints, the edge of each member of the joint must be prepared to a particular geometry

to provide accessibility for welding and to ensure the desired weld soundness and strength. The opening or gap at the root of the joint and the included angle of the groove should be selected to require the least weld metal necessary to give needed access and meet strength requirements. Only metal up to 4.5mm thick is usually used for square butt joints.

➤ **V-joints:**

Single V welds are similar to a bevel joint, but instead of only one side having the bevelled edge, both sides of the weld joint are bevelled. In thick metals, and when welding can be performed from both sides of the work piece, a double-V joint is used. When welding thicker metals, a double-V joint requires less filler material because there are two narrower V-joints compared to a wider single-V joint. Also the double-V joint helps compensate for warping forces. With a single-V joint, stress tends to warp the piece in one direction when the V-joint is filled, but with a double-V-joint, there are welds on both sides of the material, having opposing stresses, straightening the material.

➤ **J-joints:**

Single-J butt ore piece is square. A J-groove is formed either with special cutting machinery or by grinding the joint edge into the form of a J. Although a J-groove is more difficult and costly to prepare than a V-groove, a single J-groove on metal between a half an inch and three-quarters of an inch thick provides a stronger weld that requires less filler material.

➤ **U-joints:**

Single-U butt welds are welds that have both edges of the weld surface shaped like a J, but once they come together, they form U. Double-U joints have a U formation on both the top and bottom of the prepared joint. U-joints are the most expensive edge to prepare and weld. They are usually used on thick base metals where a V-groove would be at such an extreme angle that it would cost too much to fill.

➤ **Tee-Joints:**

The Tee Weld Joint is formed when two bars or sheets are joined perpendicular to each other in the form of a *T* shape. This weld is made from the resistance butt welding process. It can also be performed by Extrusion Welding. Usually, two flat pieces of poly are welded at 90 degrees to each other, and extrusion welded on both sides.

➤ **Cruciform joint:**

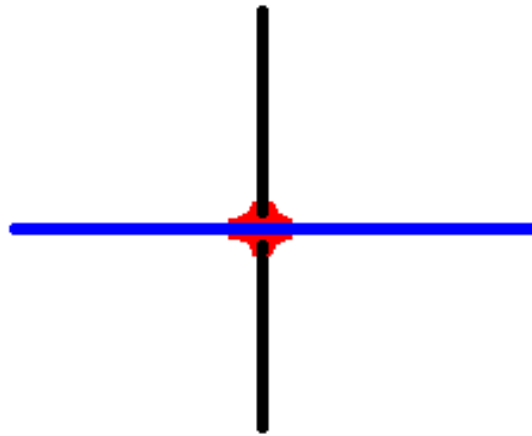


Fig 3. 5 Cruciform joint

- A cruciform joint is a specific joint in which four spaces are created by the welding of three plates of metal at right angles. Cruciform joints suffer fatigue when subjected to continuously varying loads.
- In the American Bureau of Shipping Rules for Steel Vessels, cruciform joints may be considered a double barrier if the two substances requiring a double barrier are in opposite corners diagonally. Double barriers are often required to separate oil and seawater, chemicals and potable water, etc.

Table 2 Workpiece thickness limits per joint type

Workpiece thickness limits per joint type	
Joint type	Thickness
Square butt joint	Up to 6.35 mm
Single-bevel joint	4.76–9.53 mm
Double-bevel joint	Over 9.53 mm
Single-V butt joint	Up to 9.53 mm
Double-V butt joint	Over 9.53 mm
Single-J joint	12.70–19.05 mm
Double-J joint	Over 19.05 mm
Single-U joint	Up to 19.05 mm
Double-U joint	Over 19.05 mm
Flange edge of corner)	Sheet_metals less than 2.657 mm
Flare groove	All thickness

CHAPTER-4 INDUSTRIAL SAFETY

→ Personal Protective Equipment:

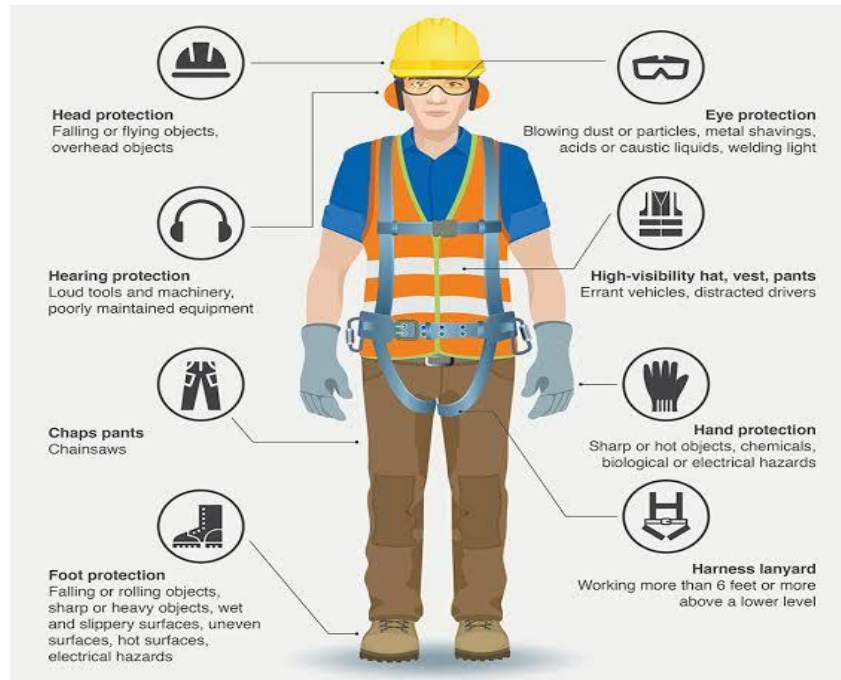


Fig 4. 1 Personal protective equipment

- **Personal Protective Equipment (PPE):** Workers in the fabrication industry must wear appropriate PPE to protect themselves from hazards such as flying debris, hot metal, and chemical exposure. This may include safety glasses, face shields, gloves, protective clothing, and respirators.
- **Electrical Safety:** Electrical hazards are a common concern in the fabrication industry, and workers must be trained to identify and avoid electrical hazards. This includes proper grounding of equipment and avoiding the use of damaged or frayed electrical cords.
- **Wear Protective Eyewear:** Welders should always wear protective eyewear when performing welding operations. This includes safety glasses with side shields or welding helmets with appropriate shading filters to protect against the bright light produced during welding.

- **Wear Protective Gloves:** Workers should always wear protective gloves when performing fabrication operations. This includes gloves made from materials that can protect against cuts, abrasions, punctures, and heat.
- Safety is of paramount importance in the fabrication industry to protect the workers, the environment, and the equipment used in the fabrication process. Here are some key safety considerations for the fabrication industry:
 - **Proper Training:** All workers should receive appropriate training and certification for the tools and equipment they will use. Workers should also receive training on safety procedures, including the use of personal protective equipment (PPE) and emergency response plans.
 - **Hazard Identification:** It is important to identify all potential hazards in the fabrication environment, such as electrical hazards, chemical hazards, and slip, trip and fall hazards. Risk assessments should be conducted regularly to identify hazards and develop control measures to mitigate the risks.
 - **Use of PPE:** Workers must wear appropriate PPE, including hard hats, safety glasses, earplugs, gloves, and steel-toed boots. Respiratory protection may also be necessary if workers are exposed to hazardous airborne particles or gases.
 - **Equipment Safety:** All machinery and equipment used in the fabrication process should be inspected regularly for proper function and safety. Guards and other safety features should be in place and functioning correctly.
 - **Fire Safety:** Fire prevention and response plans should be in place and understood by all workers. Fire extinguishers, smoke detectors, and sprinkler systems should be available and regularly tested.
 - **Material Handling:** Workers should receive training on safe material handling practices, including lifting techniques and the use of lifting equipment, such as cranes or forklifts.
 - **Emergency Response Plan:** All workers should know the emergency response plan and be trained in emergency procedures, such as evacuations and first aid.

Conclusion

- The duration of the program, I have gained valuable experience and knowledge in various field. The internship has provided an opportunity to apply theoretical concepts learned in the classroom to real-world situations.
- Additionally, I quickly learned that success in this field requires not only technical skills, but also a strong work ethic, adaptability, and a willingness to take on new challenges and conducting research and analysis to developing marketing strategies and creating content.
- Overall, my two weeks as an intern have been an invaluable experience, and one that I will carry with me as I continue to pursue my career goals. I am excited to see where this journey will take me, and I am confident that the lessons I have learned will serve me well in the years to come.
- I am grateful for the guidance and support of my colleagues, who have been helping me. I am also proud of the progress I have made, and the skills I have developed over the duration of my internship.

References

<https://www.divineengineering.in/>

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<https://images.app.goo.gl/VHEVBP6CDFGngoue9>

https://en.wikipedia.org/wiki/Welding_joint