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An American National Standard

Structural Welding Code—Steel



American Welding Society®



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An American National Standard

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Structural Welding Code—Steel

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Prepared by the
American Welding Society (AWS) D1 Committee on Structural Welding

Under the Direction of the
AWS Technical Activities Committee

Approved by the
AWS Board of Directors

Abstract

This code covers the welding requirements for any type of welded structure made from the commonly used carbon and low-alloy constructional steels. Clauses 1 through 11 constitute a body of rules for the regulation of welding in steel construction. There are eight normative and eleven informative annexes in this code. A Commentary of the code is included with the document.

American Welding Society®

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Foreword

This foreword is not part of AWS D1.1/D1.1M:2025, *Structural Welding Code—Steel*, but is included for informational purposes only.

The first edition of the *Code for Fusion Welding and Gas Cutting in Building Construction* was published by the American Welding Society in 1928 and called Code 1 Part A. It was revised in 1930 and 1937 under the same title. It was revised again in 1941 and given the designation D1.0. D1.0 was revised again in 1946, 1963, 1966, and 1969. The 1963 edition published an amended version in 1965, and the 1966 edition published an amended version in 1967. The code was combined with D2.0, *Specifications for Welding Highway and Railway Bridges*, in 1972, given the designation D1.1, and retitled AWS *Structural Welding Code*. D1.1 was revised again in 1975, 1979, 1980, 1981, 1982, 1983, 1984, 1985, 1986, 1988, 1990, 1992, 1994, 1996, 1998, 2000, 2002, 2004, 2006, 2008, 2010, 2015, and 2020. A second printing of AWS D1.1/D1.1M:2010, 2015, and 2020 were published in 2011, 2016, and 2022, respectively. From 1972 to 1988, the D1.1 code covered the welding of both buildings and bridges.

In 1988, AWS published its first edition of AASHTO/AWS D1.5M/D1.5, *Bridge Welding Code*; coincident with this, the D1.1 code changed references of buildings and bridges to statically loaded and dynamically loaded structures, respectively, in order to make the document applicable to a broader range of structural applications. After the publishing of the 2010 edition, it was decided that the AWS *Structural Welding Code—Steel* would be published on a five year revision cycle instead of a two year revision cycle. This was done in order to sync the publication cycle of AWS Structural Welding Code-Steel with the publication cycles of the ANSI/AISC 360, *Specification for Structural Steel Buildings* and the *International Building Code*. This 2025 edition is the 25th edition of D1.1.

Changes in Code Requirements, underlined text in the clauses, subclauses, tables, figures, or forms indicates a change from the 2020 edition. A vertical line in the margin of a table or figure also indicates a change from the 2015 edition.

The following is a summary of the most significant technical changes contained in AWS D1.1/D1.1M:2025:

Summary of Changes

Clause/Table/Figure/Annex	Modification
General	AWS A5.36 filler metal classifications and properties have been removed throughout the standard.
Clause 2—Normative References	The normative references were amended.
Clause 3—Terms and Definitions	New terms and definitions were added.
Clause 4—Design of Welded Connections	Clarified base metal and filler metal strength requirements, added provisions for matching filler metals, added provisions for toughness, added a new subclause 4.7 on Load and Resistance Factor Design (LRFD), added a new Table 4.3 for available strength of welded joints, and added a new Figure 4.7, clarifying the maximum specified fillet weld size along edges.
Clause 5—Prequalification of WPSs	Revised subclause 5.6.1 on matching and undermatching filler metal strength, converted Table 5.1 on prequalified WPS requirements from the previous edition into 4 separate tables, added Group V metals to Table 5.7 on filler metals for matching strengths, and replaced the joint details in Figures 5.1 and 5.2 with new drawings.
Clause 6—Qualification	Qualification for preheat and interpass temperatures were revised, acceptance criteria for macroetch testing was updated, and the WPS qualification tables were changed.
Clause 7—Fabrication	Text was introduced, clarifying production welding requirements and preheat and interpass temperatures, and new weld tab exemptions were listed.

(Continued)

Summary of Changes (Continued)

Clause/Table/Figure/Annex	Modification
Clause 8—Inspection	Additional provisions for Magnetic Particle Testing (MT) and Penetrant Testing (PT) were added, language was included to clarify the certification of personnel performing nondestructive testing (NDT), and the acceptance criteria for visual inspection was updated.
Clause 9—Stud Welding	New provisions for type D studs were added.
Clause 10—Tubular Structures	Revised the requirements for tubular connections and clarified the requirements for T-, Y-, and K- connection procedures.
Annex M	It was presented as Annex N in the previous edition.
Annex N	It was presented as Annex O in the previous edition.
Annex O	It was presented as Annex P in the previous edition.
Annex P	It was presented as Annex Q in the previous edition.
Annex R	It was presented as Annex S in the previous edition and new reference documents were listed.
Annex Q	It was presented as Annex R in the previous edition.
Annex S	New annex that addresses the addition of base materials to AWS D1.1/D1.1M.

Commentary. The Commentary is nonmandatory and is intended only to provide insightful information into provision rationale.

Normative Annexes. These annexes address specific subjects in the code and their requirements are mandatory requirements that supplement the code provisions.

Informative Annexes. These annexes are not code requirements but are provided to clarify code provisions by showing examples, providing information, or suggesting alternative good practices.

Index. As in previous codes, the entries in the Index are referred to by subclause number rather than by page number. This should enable the user of the Index to locate a particular item of interest in minimum time.

Errata. It is the Structural Welding Committee's Policy that all errata should be made available to users of the code. Therefore, any significant errata will be published in the Society News Section of the *Welding Journal* and posted on the AWS web site at: http://www.aws.org/standards/page/errata.

This amendment to AWS D15.1/D15.1M includes a change to Table 8.1(7)(1)(b) and incorporates the errata changes.

Suggestions. Your comments for improving AWS D1.1/D1.1M:2025, *Structural Welding Code—Steel* are welcome. Submit comments to the Secretary of the D1Q Subcommittee, American Welding Society, 8669 NW 36 St, # 130, Miami, FL 33166.

Amendment

The following amendment has been identified and is incorporated in this reprint.

AWS Standard: D1.1/D1.1M:2025

Amendment Number: 1

Subject: Table 8.1, *Visual Inspection Acceptance Criteria (see 8.9)*

Page 246, Table 8.1(7)(1)(b): add "no" before "greater than" as follows:

(7) Undercut

(A)

(1) For material less than 1 in [25 mm] thick, undercut shall not exceed 1/32 in [1 mm] in depth, with the following exceptions:

(a) For welds equal to or greater than 12 in [300 mm] in length, undercut shall not exceed 1/16 in [2 mm] in depth for any accumulated length up to 2 in [50 mm] in any 12 in [300 mm] length of weld, and

(b) For welds less than 12 in [300 mm] in length, the accumulated undercut length with undercut depth no greater than 1/16 in [2 mm] shall not exceed the weld length multiplied by 0.16 for each length of weld.

(2) For material equal to or greater than 1 in [25 mm] thick, undercut shall not exceed 1/16 in [2 mm] in depth.

Errata

The following errata have been identified and are incorporated in this reprint.

Page 5, ASTM 2339, title: change “ASTM 2339” to “ASTM E2339”

Page 5, ASTM 2339, title: change “Nodestructive” to “Nondestructive”

Page 19, 4.5.2: move “4.5.2 Fillet Welds” from the bottom of page 19 to the top of page 20

Page 62, list: add a hard return after “Part A – WPS Development” so that “Part B – Base Metal” is a separate line

Page 64, 5.4.4: add a period after the title and change “4.4.5.1, 4.4.5.2, 4.4.5.4, and 4.10” to “4.5.5.1, 4.5.5.2, 4.5.5.4, and 4.11”

Page 65, 5.6.2: Change the parenthesis around “(70 MPa)” to brackets

Page 68, Table 5.1, column *Requirement*, 1st row: change “[0.8 mm]” to “[8 mm]”

Page 68, Table 5.1, column *Exceptions*, last row: change “5.6.2” to “5.6.3”

Page 69, Table 5.2, column *Exceptions*, 5th row: change “5.6.2” to “5.6.3”

Page 70, Table 5.3, column *Exceptions*, 6th row: change “5.6.2” to “5.6.3”

Page 70, Table 5.3, column *Position*, 9th and 10th row: insert horizontal dividing lines between each position

Page 71, Table 5.4, column *Exceptions*, 5th row: change “5.6.2” to “5.6.3” and add a period to the end of the sentence

Pages 76–77, Table 5.7, column *WELDING PROCESS(ES)*, subheading *SAW*, subheading *A5.23[c], Low-Alloy Steel*: delete superscript “[c]”

Page 88, Figure 5.1, column *Groove Preparation*, subheading *Root Opening Root Face Groove Angle*, last row: change “f – 5/8 max.” to “f = 5/8 max.”

Page 122, Figure 5.2, column *Root Opening Root Face Bend Radius*, all 3 rows: change all 3 instances of “$r = \frac{3T_1}{4}$ *min.*” to “$r = \frac{3T_1}{2}$ *min.*”

Page 138, 6.17.3, last sentence: change “6.16.1 and 6.16.2” to “6.17.1 and 6.17.2”

Page 138, 6.18.1.2, last sentence: change “6.9 or 6.10” to “6.8 or 6.9”

Page 139, 6.22, 1st sentence: change “6.12” to “6.11”

Page 143, 6.27.7, 1st sentence: change “engineer to “Engineer”

Page 145, Table 6.1, column *Qualification Test*, subheading *Weld Type*, 3rd row: delete superscript and comma “[a,]” after “fillet”

Page 148, Table 6.5, column *Test Coupon*, 1st row: change “6.16” to “6.17”

Page 150, Table 6.6, essential variable (17): delete superscript “[d]” after “speed”

Page 154, Table 6.8, (2)(a): delete “less than” before “1/4 in [6 mm]”

Page 160, Table 6.11, column *Qualification Test*, subheading *Weld Type*, 1st row: delete superscript “[g]” after “Groove”

Page 180, Figure 6.17, Note 2: change “6.6” to “6.5”

Page 194, 7.3.1.2, 2nd sentence: change “A5.32/A5.32M” to “A5.32M/A5.32”

Page 207, 7.22.11: bold title, “Tolerance on Stiffeners”

Page 208, 7.23: change “10.15” to “10.14”

Page 224, 8.1.4.5 (4): underline “NDT,” “VT,” “the company’s written practice developed in accordance with,” and “Testing”

Page 231, 8.17.1, 4th line: change “10.16, and 10.17” to “10.15, and 10.16”

Page 235, 8.19.1, 2nd sentence: change “Annex O” to “Annex N”

Page 235, 8.19.2, 1st sentence: change “Annex O” to “Annex N”

Page 244, 8.32, 1st sentence: delete “or Clause 8” before “or Part F of Clause 10”

Page 255, Figure 8.1, note 3: change “253” to “254”

Page 293, 10.5.3, 1st sentence: change “4.4.1.5” to “4.5.1.5”

Page 294, 10.5.4: delete the last 4 lines in italics

Page 297, 10.14.4.1, 1st sentence: change “Table 10.8” to “Tables 10.8 and 10.9”

Page 298, 10.16.1, 2nd paragraph, 1st sentence: change “10.8” with “10.12”

Page 299, 10.18, 1st sentence: change “Table 10.8” to “Tables 10.8 and 10.12”

Page 306, Table 10.2, column *Allowable Stress Design (ASD)*, subheading *Allowable Stress*, 6th row: change superscript “e” to superscript “d”

Page 307, Table 10.2, footnotes: change superscript “*e*” to superscript “*d*”

Page 313, Table 10.8, column *Production Pipe Welding Qualified*, subheading *Butt Joint*: change “PJP[b,c]” to “CJP[b,c]”

Page 313, Table 10.8, column *Production Pipe Welding Qualified*, subheading *T-, Y-, K-Connections*[c,d]: delete comma before superscript “d”

Page 313, Table 10.8, column *Production Box Tubing Welding Qualified*, subheading *T-, Y-, K-Connections*[d], subheading *PJP*, 2nd row: change “F, H, V, OH” to “F, H”

Page 313, Table 10.8, column *Production Box Tubing Welding Qualified*, subheading *T-, Y-, K-Connections*[d], subheading *Fillet*, 2nd row: replace blank cell with “F, H”

Page 313, Table 10.8, column *Qualification Test*, subheading *Test Positions*[a], 6th row: change superscript “j” to superscript “e”

Page 313, Table 10.8, column *Qualification Test*, subheading *Test Positions*[a], 8th row: change “10.22” to “10.21”

Page 317, Table 10.12, 13th row under table title, *Box Groove (Fig. 10.20)*[j], 6th column: change Nominal Pipe Size Qualified Min. from “24” to “4”

Page 317, Table 10.12, 13th row under table title, *Box Groove (Fig. 10.20)*[j], 8th column: change Nominal Pipe Size Qualified Max. from “4” to “24”

Page 317, Table 10.12, footnote a: change “See Table 10.11 for appropriate groove details.” to “See Table 10.8 for qualified groove position details.”

Page 318, Table 10.12, 13th row under table title, *Box Groove (Fig. 10.20)*[j], 6th column: change Nominal Pipe Size Qualified Min. from “610” to “100”

Page 318, Table 10.12, 13th row under table title, *Box Groove (Fig. 10.20)*[j], 8th column: change Nominal Pipe Size Qualified Max. from “100” to “610”

Page 318, Table 10.12, footnote a: change “See Table 10.11 for appropriate groove details.” to “See Table 10.8 for qualified groove position details.”

Page 390, H5.7.2, last paragraph, 1st sentence: change “sensitivty” to “sensitivity”

Page 392, H7.4.5: add “that” after “configurations”

Page 408, Index of Forms, page numbers: change numbering from “405” to “409,” “411” to “415,” “416” to “420,” “417” to “421,” “419” to “423,” “421” to “425,” “422” to “426,” and “423” to “427”

Page 429, Annex K, subclauses, left column: change “4.4.1.4” to “4.5.1.4,” “4.4.4.2” to “4.5.4.2,” and “4.4.3” to “4.5.3”

Page 445, N2., 3rd line: delete “the” before “shipbuilding”

Page 449, N10.4, 2nd sentence: change “in regards” to “with regard”

Page 462, Form O-8, 2nd to last line: insert space in between “Form” and “O-9”

Page 463, Form O-8, SUPPLEMENTAL INSTRUCTIONS, numbered list: change numbering from “9-16” to “1-8”

Page 483, Annex R: delete “American Institute of Steel Construction (AISC) standard:

ANSI/AISC 360, *Specification for Structural Steel Buildings*”

Page 501, C-4.7.3(4), last paragraph, last sentence: change “4.6.3” to “4.7.3”

Page 531, C-7.3.2.1, 4th paragraph, 6th line: delete hyphen and space from “deposits”

Page 531, C-7.3.2.1, 4th paragraph, last sentence: delete space from “low-hydrogen”

Page 532, C-7.3.2.1, 6th line from the top of the page: delete hyphen and space from “acceptable”

Page 536, C-7.14.2, title: change “Mill-Induced” to “Base Metal”

Page 611, Index, *Faying Surface*: change “7.21.2”to “7.21.1”

Table of Contents

Page No.

Personnel (Amendment) v
Personnel (Original) xi
Foreword xvii
Amendment xix
Errata xx
List of Tables xxviii
List of Figures xxx

1. General Requirements 1
1.1 Scope 1
1.2 Standard Units of Measurement 1
1.3 Safety Precautions 2
1.4 Limitations 2
1.5 Responsibilities 2
1.6 Approval 3
1.7 Mandatory and Nonmandatory Provisions 3
1.8 Welding Symbols 3

2. Normative References 4

3. Terms and Definitions 6

4. Design of Welded Connections 17
4.1 Scope 17

Part A—Common Requirements for Design of Welded Connections (Nontubular and Tubular Members) 17
4.2 General 17
4.3 Contract Plans and Specifications 17
4.4 Base Metal/Filler Metal Strength Requirements 19
4.5 Effective Areas 19

Part B—Specific Requirements for Design of Nontubular Connections (Statically or Cyclically Loaded) 22
4.6 General 22
4.7 Strength 22
4.8 Joint Configuration and Details 24
4.9 Joint Configuration and Details—Groove Welds 25
4.10 Joint Configuration and Details—Fillet Welded Joints 25
4.11 Joint Configuration and Details—Plug and Slot Welds 26
4.12 Filler Plates 26
4.13 Built-Up Members 26

Part C—Specific Requirements for Design of Nontubular Connections (Cyclically Loaded) 27
4.14 General 27
4.15 Limitations 27
4.16 Calculation of Stresses 27
4.17 Available Strength and Allowable Stress Ranges 28
4.18 Detailing, Fabrication, and Erection 29
4.19 Prohibited Joints and Welds 30
4.20 Inspection 30

5. Prequalification of WPSs 62
5.1 Scope 62

Part A—WPS Development 62
5.2 General WPS Requirements 62

Part B—Base Metal 63
5.3 Base Metal 63

Part C—Weld Joints 63
5.4 Weld Joints 63

Part D—Welding Processes 65
5.5 Welding Processes 65

Part E—Filler Metals and Shielding Gases 65
5.6 Filler Metal and Shielding Gas 65

Part F—Preheat and Interpass Temperature Requirements 66
5.7 Preheat and Interpass Temperature Requirements 66

Part G—WPS Requirements 67
5.8 WPS requirements 67

Part H—Postweld Heat Treatment 67
5.9 Postweld Heat Treatment 67

6. Qualification 128
6.1 Scope 128

Part A—General Requirements 128
6.2 General 128
6.3 Common Requirements for WPS and Welding Personnel Performance Qualification 129

Part B—Welding Procedure Specification (WPS) Qualification 129
6.4 Production Welding Positions Qualified 129
6.5 Type of Qualification Tests 129
6.6 Weld Types for WPS Qualification 130
6.7 Preparation of WPS 130
6.8 Essential Variables 130
6.9 WPS Requirements for Production Welding Using Existing Non-Waveform or Waveform WPSs 132
6.10 Methods of Testing and Acceptance Criteria for WPS Qualification 132
6.11 CJP Groove Welds 134
6.12 PJP Groove Welds 134
6.13 Fillet Welds 135
6.14 Plug and Slot Welds 136
6.15 Consumable Verification Test 136
6.16 Welding Processes Requiring Qualification 137

Part C—Performance Qualification 137
6.17 General 137
6.18 Type of Qualification Tests Required 138
6.19 Weld Types for Welder and Welding Operator Performance Qualification 139
6.20 Preparation of Performance Qualification Forms 139
6.21 Essential Variables 139
6.22 CJP Groove Welds for Nontubular Connections 139
6.23 Methods of Testing and Acceptance Criteria for Welder and Welding Operator Qualification 140
6.24 Method of Testing and Acceptance Criteria for Tack Welder Qualification 141
6.25 Retest 141

Part D—Requirements for CVN Toughness Testing 141
6.26 General: CVN Testing 141
6.27 CVN Tests 142

6.28 Combining FCAW-S with Other Welding Processes in a Single Joint . . . 143
6.29 Reporting . . . 144

7. Fabrication . . . 193
7.1 Scope . . . 193
7.2 Base Metal . . . 193
7.3 Welding Consumables and Electrode Requirements . . . 193
7.4 ESW and EGW Processes . . . 196
7.5 Production Welding . . . 196
7.6 Preheat and Interpass Temperatures . . . 196
7.7 Heat Input Control for Quenched and Tempered Steels . . . 197
7.8 Postweld Heat Treatment (PWHT) for Stress Relief . . . 197
7.9 Backing . . . 198
7.10 Welding and Cutting Equipment . . . 199
7.11 Welding Environment . . . 199
7.12 Conformance with Design . . . 199
7.13 Minimum Fillet Weld Sizes . . . 199
7.14 Preparation of Base Metal . . . 199
7.15 Reentrant Corners . . . 202
7.16 Weld Access Holes, Beam Copes, and Connection Material . . . 202
7.17 Tack Welds and Construction Aid Welds . . . 202
7.18 Camber in Built-Up Members . . . 203
7.19 Subassembly Sequence . . . 203
7.20 Control of Distortion and Shrinkage . . . 203
7.21 Tolerance of Joint Dimensions . . . 204
7.22 Dimensional Tolerance of Welded Structural Members . . . 205
7.23 Weld Profiles . . . 208
7.24 Technique for Plug and Slot Welds . . . 208
7.25 Repairs . . . 208
7.26 Peening . . . 210
7.27 Caulking . . . 210
7.28 Arc Strikes . . . 210
7.29 Weld Cleaning . . . 210
7.30 Weld Tabs . . . 210

8. Inspection . . . 223

Part A—General Requirements . . . 223
8.1 Scope . . . 223
8.2 Inspection of Materials and Equipment . . . 225
8.3 Inspection of WPSs . . . 225
8.4 Inspection of Welder, Welding Operator, and Tack Welder Qualifications . . . 225
8.5 Inspection of Work and Records . . . 225

Part B—Contractor Responsibilities . . . 226
8.6 Obligations of the Contractor . . . 226

Part C—Acceptance Criteria . . . 226
8.7 Scope . . . 226
8.8 Engineer's Approval for Alternate Acceptance Criteria . . . 226
8.9 Visual Inspection . . . 226
8.10 Magnetic Particle Testing (MT) and Penetrant Testing (PT) . . . 227
8.11 Nondestructive Testing (NDT) . . . 227
8.12 Radiographic Testing (RT) . . . 227
8.13 Ultrasonic Testing (UT) . . . 229

Part D—NDT Procedures . . . 229
8.14 Procedures . . . 229
8.15 Extent of Testing . . . 230

Part E—Radiographic Testing (RT) 231
8.16 RT of Groove Welds in Butt Joints. . . . 231
8.17 RT Procedures 231
8.18 Examination, Report, and Disposition of Radiographs 234

Part F—Ultrasonic Testing (UT) of Groove Welds 235
8.19 General 235
8.20 Qualification Requirements 235
8.21 UT Equipment 235
8.22 Reference Standards 236
8.23 Equipment Qualification 237
8.24 Calibration for Testing 237
8.25 Testing Procedures 238
8.26 Preparation and Disposition of Reports 239
8.27 Calibration of the UT Unit with IIW Type or Other Approved Reference Blocks (Annex G) 240
8.28 Equipment Qualification Procedures 241
8.29 Discontinuity Size Evaluation Procedures 243
8.30 Scanning Patterns 243
8.31 Examples of dB Accuracy Certification. . . . 244

Part G—Other Examination Methods 244
8.32 General Requirements 244
8.33 Radiation Imaging Systems 244
8.34 Advanced Ultrasonic Systems 244
8.35 Additional Requirements 245

9. Stud Welding 278
9.1 Scope 278
9.2 General Requirements 278
9.3 Mechanical Requirements 279
9.4 Workmanship/Fabrication 279
9.5 Technique 280
9.6 Stud Application Qualification Requirements 281
9.7 Production Control 282
9.8 Fabrication and Verification Inspection Requirements 283
9.9 Manufacturers' Stud Base Qualification Requirements 283

10. Tubular Structures 291
10.1 Scope 291

Part A—Design of Tubular Connections 291
10.2 Design Criteria 291
10.3 Identification and Parts of Tubular Connections 293
10.4 Symbols 293
10.5 Weld Design 293
10.6 Thickness Transition. . . . 294
10.7 Material Limitations 294

Part B—Prequalification of Welding Procedure Specifications (WPSs) 295
10.8 Fillet Weld Requirements 295
10.9 PJP Requirements 295
10.10 CJP Groove Weld Requirements 295

Part C—Welding Procedure Specification (WPS) Qualification 296
10.11 Common Requirements for WPS and Welding Personnel Performance Qualification 296
10.12 Production Welding Positions Qualified 296
10.13 Type of Qualification Tests, Methods of Testing, and Acceptance Criteria for WPS Qualification 296
10.14 CJP Groove Welds for Tubular Connections 297
10.15 PJP and Fillet Welds Tubular T-, Y-, or K-Connections and Butt Joints 298

Part D—Performance Qualification 298
10.16 Production Welding Positions, Thicknesses, and Diameters Qualified 298
10.17 Weld Types for Welder and Welding Operator Performance Qualification 298
10.18 CJP Groove Welds for Tubular Connections 299
10.19 PJP Groove Welds for Tubular Connections 299
10.20 Fillet Welds for Tubular Connections. 299
10.21 Methods of Testing and Acceptance Criteria for Welder and Welding Operator Qualification 299

Part E—Fabrication 300
10.22 Backing. 300
10.23 Tolerance of Joint Dimensions 300

Part F—Inspection 301
10.24 Visual Inspection 301
10.25 NDT 301
10.26 UT. 301
10.27 RT Procedures 301
10.28 Supplementary RT Requirements for Tubular Connections. 302
10.29 UT of Tubular T-, Y-, and K-Connections 302

11. Strengthening and Repair of Existing Structures 353
11.1 Scope 353
11.2 General 353
11.3 Base Metal 353
11.4 Design for Strengthening and Repair 353
11.5 Fatigue Life Enhancement 354
11.6 Workmanship and Technique 354
11.7 Quality 354

Annexes
Annex A (Normative)—Effective Throats of Fillet Welds in Skewed T-Joints 355
Annex B (Normative)—Guideline on Alternative Methods for Determining Preheat 357
Annex D (Normative)—Temperature-Moisture Content Charts 369
Annex E (Normative)—Flatness of Girder Webs—Statically Loaded Structures 373
Annex F (Normative)—Flatness of Girder Webs—Cyclically Loaded Structures. 377
Annex G (Normative)—Qualification and Calibration of UT Units with Other Approved Reference Blocks 383
Annex H (Normative)—Phased Array Ultrasonic Testing (PAUT) 387
Annex I (Normative)—Symbols for Tubular Connection Weld Design. 403
Annex J (Informative)—Sample Welding Forms 407
Annex K (Informative)—Contents of Prequalified WPS 429
Annex L (Informative)—Filler Metal Strength Properties 431
Annex M (Informative)—Guide for Specification Writers 443
Annex N (Informative)—UT Examination of Welds by Alternative Techniques. 445
Annex O (Informative)—UT Equipment Qualification and Inspection Forms 461
Annex P (Informative)—Local Dihedral Angle 471
Annex Q (Informative)—Preliminary Design Circular Tube Connections 477
Annex R (Informative)—List of Reference Documents. 483
Annex S (Informative)—Guidelines for the Preparation of Proposals for Additions of Base Materials not Listed in D1.1 485
Annex T (Informative)—Guidelines for the Preparation of Technical Inquiries for the Structural Welding Committee 487

Commentary 489
List of AWS Documents on Structural Welding 607
Index 609

List of Tables

Table		Page No.
4.1	Effective Size of Flare-Groove Welds Filled Flush.	31
4.2	Z Loss Dimension (Nontubular)	31
4.3	Available Strength of Welded Joints	32
4.4	Equivalent Strength Coefficients for Obliquely Loaded Fillet Welds	33
4.5	Fatigue Stress Design Parameters	34
5.1	Prequalified SMAW WPS Requirements.	68
5.2	Prequalified SAW WPS Requirements	69
5.3	Prequalified GMAW (solid wire) WPS Requirements	70
5.4	Prequalified FCAW and GMAW Metal Cored WPS Requirements	71
5.5	Essential Variables for Prequalified WPSs.	72
5.6	Approved Base Metals for Prequalified WPSs	73
5.7	Filler Metals for Matching Strength for Table 5.6, Groups I, II, III, IV , and IV Metals—SMAW and SAW	76
5.8	Minimum Prequalified PJP Groove Weld Size (S)	80
5.9	Filler Metal Requirements for Exposed Bare Applications of Weathering Steels	80
5.10	Prequalified WPS Shielding Gas Options for GMAW Electrodes Conforming to AWS A5.18/A5.18M	80
5.11	Prequalified Minimum Preheat and Interpass Temperature	81
6.1	WPS Qualification—Production Welding Positions Qualified by Plate Tests.	145
6.2	WPS Qualification—CJP Groove Welds: Number and Type of Test Specimens and Range of Thickness Qualified	146
6.3	WPS Qualification—PJP Groove Welds: Number and Type of Test Specimens and Range of Thickness Qualified	146
6.4	WPS Qualification—Fillet Welds: Number and Type of Test Specimens and Range of Thickness Qualified	147
6.5	WPS Qualification—Plug and Slot Welds: Number and Type of Test Specimens and Range of Thickness Qualified	148
6.6	PQR Essential Variable Changes Requiring WPS Requalification for SMAW, SAW, GMAW, FCAW, and GTAW.	149
6.7	PQR Essential Variable Changes Requiring WPS Requalification for ESW or EGW	152
6.8	PQR Supplementary Essential Variable Changes for CVN Testing Applications Requiring WPS Requalification for SMAW, SAW, GMAW, FCAW, GTAW, and ESW/ EGW	154
6.9	Table 5.6, Table 6.10, and Unlisted Steels Qualified by PQR	155
6.10	Code-Approved Base Metals and Filler Metals Requiring Qualification per Clause 6.	156
6.11	Welding Personnel Qualification—Production Welding Positions Qualified by Plate Tests.	160
6.12	Welder and Welding Operator Qualification—Tests on Plate – Number and Type of Specimens and Range of Thickness Qualified	161
6.13	Welding Personnel Performance Essential Variable Changes Requiring Requalification	162
6.14	Electrode Classification Groups.	162
6.15	CVN Test Temperature Reduction	163
6.16	Charpy V-Notch Test Acceptance Criteria for Various Sub-Size Specimens.	163
6.17	Filler Metal Essential Variables—FCAW-S Substrate/Root	164
7.1	Allowable Atmospheric Exposure of Low-Hydrogen Electrodes	212
7.2	Minimum Holding Time	212
7.3	Alternate Stress-Relief Heat Treatment	212
7.4	Limits on Acceptability and Repair of Mill Induced Laminar Discontinuities in Cut Surfaces	213

7.5 Camber Tolerance for Typical Girder . . . 213
7.6 Camber Tolerance for Girders without a Designed Concrete Haunch . . . 214
7.7 Minimum Fillet Weld Sizes . . . 214
7.8 Weld Profiles . . . 215
7.9 Weld Profile Schedules . . . 215
8.1 Visual Inspection Acceptance Criteria . . . 246
8.2 UT Acceptance-Rejection Criteria (Statically Loaded Nontubular Connections and Cyclically Loaded Nontubular Connections in Compression) . . . 248
8.3 UT Acceptance-Rejection Criteria (Cyclically Loaded Nontubular Connections in Tension) . . . 249
8.4 Hole-Type IQI Requirements . . . 250
8.5 Wire IQI Requirements . . . 250
8.6 IQI Selection and Placement . . . 250
8.7 Testing Angle . . . 251
8.8 UT Equipment Qualification and Calibration Requirements . . . 253
9.1 Mechanical Property Requirements for Studs . . . 285
9.2 Minimum Fillet Weld Size for Studs . . . 285
10.1 Fatigue Stress Design Parameters . . . 305
10.2 Available Stresses in Tubular Connection Welds . . . 306
10.3 Stress Categories for Type and Location of Material for Circular Sections . . . 308
10.4 Fatigue Category Limitations on Weld Size or Thickness and Weld Profile (Tubular Connections) . . . 310
10.5 Z Loss Dimensions for Calculating Prequalified PJP T-,Y-, and K-Tubular Connection Minimum Weld Sizes . . . 310
10.6 Joint Detail Applications for Prequalified CJP T-, Y-, and K-Tubular Connections . . . 311
10.7 Prequalified Joint Dimensions and Groove Angles for CJP Groove Welds in Tubular T-, Y, and K-Connections Made by SMAW, GMAW-S, and FCAW . . . 312
10.8 WPS, Welder and Welding Operator Qualification—Production Welding Positions Qualified by Pipe and Box Tube Tests . . . 313
10.9 WPS Qualification—CJP Groove Welds: Number and Type of Test Specimens and Range of Thickness and Diameter Qualified . . . 314
10.10 WPS Qualification—PJP Groove Welds: Number and Type of Test Specimens and Range of Thickness Qualified . . . 316
10.11 WPS Qualification—Fillet Welds: Number and Type of Test Specimens and Range of Thickness Qualified . . . 316
10.12 Welder and Welding Operator Qualification—Number and Type of Specimens and Range of Thickness and Diameter Qualified . . . 317
10.13 Tubular Root Opening Tolerances, Butt Joints Welded Without Backing . . . 319
10.14 Visual Inspection Acceptance Criteria . . . 320
10.15 Hole-Type IQI Requirements . . . 321
10.16 Wire IQI Requirements . . . 321
10.17 IQI Selection and Placement . . . 321
A.1 Equivalent Fillet Weld Leg Size Factors for Skewed T-Joints . . . 356
B.1 Susceptibility Index Grouping as Function of Hydrogen Level “H” and Composition Parameter P_{cm} . . . 361
B.2 Minimum Preheat and Interpass Temperatures for Three Levels of Restraint . . . 361
E.1 Intermediate Stiffeners on Both Sides of Web . . . 374
E.2 No Intermediate Stiffeners . . . 374
E.3 Intermediate Stiffeners on One Side Only of Web . . . 375
F.1 Intermediate Stiffeners on Both Sides of Web, Interior Girders . . . 378
F.2 Intermediate Stiffeners on One Side Only of Web, Fascia Girders . . . 379
F.3 Intermediate Stiffeners on One Side Only of Web, Interior Girders . . . 380
F.4 Intermediate Stiffeners on Both Sides of Web, Fascia Girders . . . 381
F.5 No Intermediate Stiffeners, Interior or Fascia Girders . . . 382
H.1 Essential Variables for PAUT . . . 397
H.2 PAUT Acceptance Criteria . . . 397
H.3 Discontinuity Classification . . . 397

N.1 Acceptance-Rejection Criteria 451
Q.1 Terms for Strength of Connections (Circular Sections). 480
Commentary
C-5.1 Typical Current Ranges for GMAW-S on Steel 520
C-10.1 Structural Steel Plates 585
C-10.2 Structural Steel Pipe and Tubular Shapes 586
C-10.3 Structural Steel Shapes. 586
C-10.4 Classification Matrix for Applications 587
C-10.5 CVN Testing Conditions 587
C-10.6 CVN Test Values 588
C-10.7 HAZ CVN Test Values 588
C-11.1 Guide to Welding Suitability 597
C-11.2 Relationship Between Plate Thickness and Burr Radius 597

List of Figures

Figure **Page No.**

4.1 Fillet Weld 51
4.2 Unreinforced Bevel Groove Weld 52
4.3 Bevel Groove Weld with Reinforcing Fillet Weld 52
4.4 Bevel Groove Weld with Reinforcing Fillet Weld 53
4.5 Unreinforced Flare Bevel Groove Weld. 53
4.6 Flare Bevel Groove Weld with Reinforcing Fillet Weld 54
4.7 Maximum Specified Fillet Weld Size Along Edges. 54
4.8 Transition of Thickness (Statically Loaded Nontubular). 55
4.9 Transversely Loaded Fillet Welds 55
4.10 Minimum Length of Longitudinal Fillet Welds at End of Plate or Flat Bar Members 56
4.11 Termination of Welds Near Edges Subject to Tension. 56
4.12 End Return at Flexible Connections 57
4.13 Fillet Welds on Opposite Sides of a Common Plane 57
4.14 Thin Filler Plates in Splice Joint 58
4.15 Thick Filler Plates in Splice Joint 58
4.16 Allowable Stress Range for Cyclically Applied Load (Fatigue) in Nontubular Connections (Graphical Plot of Table 4.5) 59
4.17 Transition of Butt Joints in Parts of Unequal Thickness (Cyclically Loaded Nontubular) 60
4.18 Transition of Width (Cyclically Loaded Nontubular) 61
5.1 Prequalified CJP Groove Welded Joint Details (Dimensions in Inches) 86
5.1 Prequalified CJP Groove Welded Joint Details (Dimensions in Millimeters) 97
5.2 Prequalified PJP Groove Welded Joint Details (Dimensions in Inches) 108
5.2 Prequalified PJP Groove Welded Joint Details (Dimensions in Millimeters) 116
5.3 Prequalified Fillet Weld Joint Details (Dimensions in Inches) 124
5.3 Prequalified Fillet Weld Joint Details (Dimensions in Millimeters) 125
5.4 Prequalified Skewed T-Joint Details (Nontubular) 126
5.5 Prequalified CJP Groove, T-, and Corner Joint 127
5.6 Weld Bead in which Depth and Width Exceed the Width of the Weld Face 127
6.1 Positions of Groove Welds. 165
6.2 Positions of Fillet Welds 166
6.3 Positions of Test Plates for Groove Welds. 167
6.4 Positions of Test Plate for Fillet Welds 168
6.5 Location of Test Specimens on Welded Test Plates—ESW and EGW—WPS Qualification 169

6.6 Location of Test Specimens on Welded Test Plate Over 3/8 in [10 mm] Thick—WPS Qualification. 170
6.7 Location of Test Specimens on Welded Test Plate 3/8 in [10 mm] Thick and Under—WPS Qualification 171
6.8 Face and Root Bend Specimens. 172
6.9 Side Bend Specimens. 173
6.10 Reduced-Section Tension Specimens. 174
6.11 Guided Bend Test Jig 175
6.12 Alternative Wraparound Guided Bend Test Jig 176
6.13 Alternative Roller-Equipped Guided Bend Test Jig for Bottom Ejection of Test Specimen 176
6.14 All-Weld-Metal Tension Specimen 177
6.15 Macroetch Test Assemblies for Determination of PJP Weld Size 178
6.16 Fillet Weld Soundness Tests for WPS Qualification 179
6.17 Plug and Slot Weld WPS Qualification Test Coupon 180
6.18 Location of Test Specimen on Welded Test Plate 1 in [25 mm] Thick—Consumables Verification for Fillet Weld WPS Qualification 181
6.19 Plug and Slot Weld Test Coupon—WPS Qualification or Welder or Welding Operator Qualification. . . 182
6.20 Method of Rupturing Specimen—Tack Welder Qualification. 183
6.21 Test Coupon – Performance Qualification Welder and Welding Operator for SMAW, SAW, GMAW, FCAW, and GTAW 184
6.22 Butt Joint for Welding Operator Qualification—ESW and EGW 185
6.23 Fillet Weld Break and Macroetch Test Plate—Welder or Welding Operator Qualification—Option 1 . . . 186
6.24 Fillet Weld Root Bend Test Coupon—Welder or Welding Operator Qualification—Option 2 187
6.25 Fillet Weld Test Coupon—Welder or Welding Operator Qualification—Option 3 188
6.26 Fillet Acute Angle Heel Test for Welder or Welding Operator Qualification 188
6.27 Fillet Weld Break Specimen—Tack Welder Qualification. 189
6.28 CVN Test Specimen Locations 190
6.29 Intermix Test Plate 191
6.30 Interface Scribe Line Location. 192
6.31 Intermix CVN Test Specimen Location 192
7.1 Edge Discontinuities in Cut Material. 216
7.2 Weld Access Hole Geometry 217
7.3 Workmanship Tolerances in Assembly of Groove Welded Joints 218
7.4 Requirements for Weld Profiles 219
8.1 Discontinuity Acceptance Criteria for Statically Loaded Nontubular and Statically or Cyclically Loaded Tubular Connections 255
8.2 Discontinuity Acceptance Criteria for Cyclically Loaded Nontubular Connections in Tension (Limitations of Porosity and Fusion Discontinuities) 259
8.3 Discontinuity Acceptance Criteria for Cyclically Loaded Nontubular Connections in Compression (Limitations of Porosity or Fusion-Type Discontinuities) 263
8.4 Hole-Type IQI 267
8.5 Wire IQI 268
8.6 RT Identification and Hole-Type or Wire IQI Locations on Approximately Equal Thickness Joints 10 in [250 mm] and Greater in Length 269
8.7 RT Identification and Hole-Type or Wire IQI Locations on Approximately Equal Thickness Joints Less than 10 in [250 mm] in Length 269
8.8 RT Identification and Hole-Type or Wire IQI Locations on Transition Joints 10 in [250 mm] and Greater in Length 270
8.9 RT Identification and Hole-Type or Wire IQI Locations on Transition Joints Less than 10 in [250 mm] in Length 271
8.10 RT Edge Blocks 271
8.11 Transducer Crystal 272
8.12 Qualification Procedure of Search Unit Using IIW Reference Block 272
8.13 Typical IIW Type Block 273
8.14 Qualification Blocks. 274
8.15 Plan View of UT Scanning Patterns. 276

8.16 Transducer Positions (Typical). . . . 277
9.1 Dimension and Tolerances of Standard-Type Headed Studs 286
9.2 Typical Tension Test Fixture 287
9.3 Torque Testing Arrangement and Table of Testing Torques. . . . 288
9.4 Bend Testing Device 289
9.5 Suggested Type of Device for Qualification Testing of Small Studs. . . . 290
10.1 Allowable Fatigue Stress and Strain Ranges for Stress Categories, Tubular Structures for Atmospheric Service 322
10.2 Parts of a Tubular Connection 323
10.3 Fillet Welded Lap Joint (Tubular) 326
10.4 Transition of Thickness of Butt Joints in Parts of Unequal Thickness (Tubular) 327
10.5 Fillet Welded Prequalified Tubular Joints Made by SMAW, GMAW, and FCAW 328
10.6 Prequalified Joint Details for PJP T-, Y-, and K-Tubular Connections 329
10.7 Prequalified Joint Details for CJP T-, Y-, and K-Tubular Connections 332
10.8 Definitions and Detailed Selections for Prequalified CJP T-, Y-, and K-Tubular Connections. . . . 333
10.9 Prequalified Joint Details for CJP Groove Welds in Tubular T-, Y-, and K-Connections—Standard Flat Profiles for Limited Thickness 334
10.10 Prequalified Joint Details for CJP Groove Welds in Tubular T-, Y-, and K-Connections—Profile with Toe Fillet for Intermediate Thickness 335
10.11 Prequalified Joint Details for CJP Groove Welds in Tubular T-, Y-, and K-Connections—Concave Improved Profile for Heavy Sections or Fatigue 336
10.12 Positions of Test Pipe or Tubing for Groove Welds. . . . 337
10.13 Positions of Test Pipes or Tubing for Fillet Welds. . . . 338
10.14 Location of Test Specimens on Welded Test Pipe—WPS Qualification 339
10.15 Location of Test Specimens for Welded Box Tubing—WPS Qualification 340
10.16 Pipe Fillet Weld Soundness Test—WPS Qualification 341
10.17 Tubular Butt Joint—Welder and WPS Qualification without and with Backing 342
10.18 Acute Angle Heel Test (Restraints not Shown) 342
10.19 Test Joint for T-, Y-, and K-Connections without Backing on Pipe or Box Tubing (> 4 in [100 mm] O.D.)—Welder and WPS Qualification 343
10.20 Test Joint for T-, Y-, and K-Connections without Backing on Pipe or Box Tubing (≤ 4 in [100 mm] O.D.)—Welder and WPS Qualification. . . . 344
10.21 Corner Macroetch Test Joint for T-, Y-, and K-Connections without Backing on Box Tubing for CJP Groove Welds—Welder and WPS Qualification 345
10.22 Location of Test Specimens on Welded Test Pipe and Box Tubing—Welder Qualification 346
10.23 Class R Indications. . . . 347
10.24 Class X Indications 349
10.25 Single-Wall Exposure—Single-Wall View 350
10.26 Double-Wall Exposure—Single-Wall View. . . . 350
10.27 Double-Wall Exposure—Double-Wall (Elliptical) View, Minimum Two Exposures 351
10.28 Double-Wall Exposure—Double-Wall View, Minimum Three Exposures 351
10.29 Scanning Techniques 352
B.1 Zone Classification of Steels 363
B.2 Critical Cooling Rate for 350 HV and 400 HV 363
B.3 Graphs to Determine Cooling Rates for Single-Pass SAW Fillet Welds 364
B.4 Relation Between Fillet Weld Size and Energy Input 367
D.1 Temperature-Moisture Content Chart to be Used in Conjunction with Testing Program to Determine Extended Atmospheric Exposure Time of Low-Hydrogen SMAW Electrodes 370
D.2 Application of Temperature-Moisture Content Chart in Determining Atmospheric Exposure Time of Low-Hydrogen SMAW Electrodes. . . . 371
G.1 Other Approved Blocks and Typical Transducer Position 385
H.1 Phased Array Imaging Views 398
H.2 Example of a Supplemental Reference Block 398
H.3 Example Standard Reflector Locations in Weld Mockup 399

H.4 Sensitivity Levels . . . 399
H.5 Example of Time Based Linearity Verification . . . 400
H.6 Linearity Verification Report Form . . . 401
N.1 Standard Reference Reflector . . . 452
N.2 Recommended Calibration Block . . . 452
N.3 Typical Standard Reflector (Located in Weld Mock-Ups and Production Welds) . . . 453
N.4 Transfer Correction . . . 454
N.5 Compression Wave Depth (Horizontal Sweep Calibration) . . . 454
N.6 Compression Wave Sensitivity Calibration . . . 455
N.7 Shear Wave Distance and Sensitivity Calibration . . . 455
N.8 Scanning Methods . . . 456
N.9 Spherical Discontinuity Characteristics . . . 457
N.10 Cylindrical Discontinuity Characteristics . . . 457
N.11 Planar Discontinuity Characteristics . . . 458
N.12 Discontinuity Height Dimension . . . 458
N.13 Discontinuity Length Dimension . . . 459
N.14 Display Screen Marking . . . 459
N.15 Report of UT (Alternative Procedure) . . . 460
Q.1 Simplified Concept of Punching Shear . . . 481
Q.2 Reliability of Punching Shear Criteria Using Computed Alpha . . . 481
Q.3 Definition of Terms for Computed Alpha . . . 482
Commentary
C-4.1 Balancing of Fillet Welds About a Neutral Axis . . . 508
C-4.2 Shear Planes for Fillet and Groove Welds . . . 508
C-4.3 Eccentric Loading . . . 509
C-4.4 Load Deformation Relationship for Welds . . . 509
C-4.5 Example of an Obliquely Loaded Weld Group . . . 510
C-4.6 Graphical Solution of the Capacity of an Obliquely Loaded Weld Group . . . 511
C-4.7 Single Fillet Welded Lap Joints . . . 512
C-5.1 Examples of Centerline Cracking . . . 520
C-5.2 Details of Alternative Groove Preparations for Prequalified Corner Joints . . . 521
C-5.3 Oscillograms and Sketches of GMAW-S Metal Transfer . . . 521
C-6.1 Type of Welding on Pipe That Does Not Require Pipe Qualification . . . 527
C-7.1 Examples of Unacceptable Reentrant Corners . . . 542
C-7.2 Examples of Good Practice for Cutting Copes . . . 542
C-7.3 Permissible Offset in Abutting Members . . . 542
C-7.4 Correction of Misaligned Members . . . 543
C-7.5 Typical Method to Determine Variations in Girder Web Flatness . . . 543
C-7.6 Illustration Showing Camber Measurement Methods . . . 544
C-7.7 Measurement of Flange Warpage and Tilt . . . 545
C-7.8 Tolerances at Bearing Points . . . 546
C-8.1 90° T- or Corner Joints with Steel Backing . . . 561
C-8.2 Skewed T- or Corner Joints . . . 561
C-8.3 Butt Joints with Separation Between Backing and Joint . . . 562
C-8.4 Effect of Root Opening on Butt Joints with Steel Backing . . . 562
C-8.5 Resolutions for Scanning with Seal Welded Steel Backing . . . 563
C-8.6 Scanning with Seal Welded Steel Backing . . . 563
C-8.7 Illustration of Discontinuity Acceptance Criteria for Statically Loaded Nontubular and Statically or Cyclically Loaded Tubular Connections . . . 564
C-8.8 Illustration of Discontinuity Acceptance Criteria for Statically Loaded Nontubular and Statically or Cyclically Loaded Tubular Connections 1-1/8 in [30 mm] and Greater, Typical of Random Acceptable Discontinuities . . . 565
C-8.9 Illustration of Discontinuity Acceptance Criteria for Cyclically Loaded Nontubular Connections in Tension . . . 566
C-9.1 Allowable Defects in the Heads of Headed Studs . . . 570

C-10.1 Illustrations of Branch Member Stresses Corresponding to Mode of Loading 588
C-10.2 Improved Weld Profile Requirements 589
C-10.3 Upper Bound Theorem 589
C-10.4 Yield Line Patterns 590
C-11.1 Microscopic Intrusions 598
C-11.2 Fatigue Life 598
C-11.3 Toe Dressing with Burr Grinder 599
C-11.4 Toe Dressing Normal to Stress 599
C-11.5 Effective Toe Grinding 600
C-11.6 End Grinding 600
C-11.7 Hammer Peening 601
C-11.8 Toe Remelting 601

Dedication

The D1 Committee on Structural Welding dedicates this 25th edition of AWS D1.1/D1.1M, Structural Welding Code—Steel, in honor of Philip "Phil" Torchio, III. The D1Q Subcommittee is eternally grateful for Phil's leadership, mentorship, and more importantly his friendship as a member and Chairman of the D1Q Subcommittee. The members of D1 and D1Q are forever thankful for his devotion to improving the AWS D1 Codes.

Structural Welding Code—Steel

1. General Requirements

1.1 Scope

This code contains the requirements for fabricating and erecting welded steel structures. When this code is stipulated in contract documents, conformance with all provisions of the code shall be required, except for those provisions that the Engineer (see 1.5.1) or contract documents specifically modifies or exempts.

The following is a summary of the code clauses:

1. General Requirements. This clause contains basic information on the scope and limitations of the code, key definitions, and the major responsibilities of the parties involved with steel fabrication.

2. Normative References. This clause contains a list of reference documents that assist the user in implementation of this code or are required for implementation.

3. Terms and Definitions. This clause contains terms and definitions as they relate to this code.

4. Design of Welded Connections. This clause contains requirements for the design of welded connections composed of tubular, or nontubular, product form members.

5. Prequalification of WPSs. This clause contains the requirements for exempting a Welding Procedure Specification (WPS) from the WPS qualification requirements of this code.

6. Qualification. This clause contains the requirements for WPS qualification and the performance qualification tests required to be passed by all welding personnel (welders, welding operators, and tack welders).

7. Fabrication. This clause contains general fabrication and erection requirements applicable to welded steel structures governed by this code, including the requirements for base metals, welding consumables, welding technique, welded details, material preparation and assembly, workmanship, weld repair, and other requirements.

8. Inspection. This clause contains criteria for the qualifications and responsibilities of inspectors, acceptance criteria for production welds, and standard procedures for performing visual inspection and nondestructive testing (NDT).

9. Stud Welding. This clause contains the requirements for the welding of studs to structural steel.

10. Tubular Structures. This clause contains exclusive tubular requirements. Additionally, the requirements of all other clauses apply to tubulars, unless specifically noted otherwise.

11. Strengthening and Repair of Existing Structures. This clause contains basic information pertinent to the welded modification or repair of existing steel structures.

1.2 Standard Units of Measurement

This standard makes use of both U.S. Customary Units and the International System of Units (SI). The latter are shown within brackets ([ ]) or in appropriate columns in tables and figures. The measurements may not be exact equivalents; therefore, each system must be used independently.

1.3 Safety Precautions

Safety and health issues and concerns are beyond the scope of this standard and therefore are not fully addressed herein. It is the responsibility of the user to establish appropriate safety and health practices. Safety and health information is available from the following sources:

American Welding Society:

(1) ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*

(2) AWS Safety and Health Fact Sheets

(3) Other safety and health information on the AWS website

Material or Equipment Manufacturers:

(1) Safety Data Sheets supplied by materials manufacturers

(2) Operating Manuals supplied by equipment manufacturers

Applicable Regulatory Agencies

Work performed in accordance with this standard may involve the use of materials that have been deemed hazardous, and may involve operations or equipment that may cause injury or death. This standard does not purport to address all safety and health risks that may be encountered. The user of this standard should establish an appropriate safety program to address such risks as well as to meet applicable regulatory requirements. ANSI Z49.1 should be considered when developing the safety program.

1.4 Limitations

The code was specifically developed for welded steel structures that utilize carbon or low-alloy steels that are 1/8 in [3 mm] or thicker with a minimum specified yield strength of 100 ksi [690 MPa] or less. The code may be suitable to govern structural fabrications outside the scope of the intended purpose. However, the Engineer should evaluate such suitability, and based upon such evaluations, incorporate into contract documents any necessary changes to code requirements to address the specific requirements of the application that is outside the scope of the code. The Structural Welding Committee encourages the Engineer to consider the applicability of other AWS D1 codes for applications involving aluminum (AWS D1.2/D1.2M), sheet steel equal to or less than 3/16 in [5 mm] thick (AWS D1.3/D1.3M), reinforcing steel (AWS D1.4/D1.4M), stainless steel (AWS D1.6/D1.6M), strengthening and repair of existing structures (AWS D1.7/D1.7M), seismic supplement (AWS D1.8/D1.8M), and titanium (AWS D1.9/D1.9M). The AASHTO/AWS D1.5M/D1.5 *Bridge Welding Code* was specifically developed for welding highway bridge components and is recommended for those applications.

1.5 Responsibilities

1.5.1 Engineer's Responsibilities. The Engineer shall be responsible for the development of the contract documents that govern products or structural assemblies produced under this code. The Engineer may add to, delete from, or otherwise modify, the requirements of this code to meet the particular requirements of a specific structure. All requirements that modify this code shall be incorporated into contract documents. The Engineer shall determine the suitability of all joint details to be used in a welded assembly.

The Engineer shall specify in contract documents, as necessary, and as applicable, the following:

(1) Code requirements that are applicable only when specified by the Engineer.

(2) All additional NDT that is not specifically addressed in the code.

(3) Extent of verification inspection, when required.

(4) Weld acceptance criteria other than that specified in Clause 8.

(5) CVN toughness criteria for weld metal, base metal, and/or HAZ when required.

(6) For tubular and nontubular applications, whether the structure is statically or cyclically loaded.

(7) Which welded joints are loaded in tension.

(8) All additional requirements that are not specifically addressed in the code.

(9) For OEM applications, the responsibilities of the parties involved.

1.5.2 Contractor's Responsibilities. The Contractor shall be responsible for WPSs, qualification of welding personnel, the Contractor's inspection, and performing work in conformance with the requirements of this code and contract documents.

1.5.3 Inspector's Responsibilities

1.5.3.1 Contractor Inspection. Contractor inspection shall be supplied by the Contractor and shall be performed as necessary to ensure that materials and workmanship meet the requirements of the contract documents.

1.5.3.2 Verification Inspection. The Engineer shall determine if verification inspection shall be performed. Responsibilities for verification inspection shall be established between the Engineer and the Verification Inspector.

1.6 Approval

All references to the need for approval shall be interpreted to mean approval by the Authority Having Jurisdiction or the Engineer.

1.7 Mandatory and Nonmandatory Provisions

1.7.1 Code Terms "Shall," "Should," and "May." "Shall," "should," and "may" have the following significance:

1.7.1.1 Shall. Code provisions that use "shall" are mandatory unless specifically modified in contract documents by the Engineer.

1.7.1.2 Should. The word "should" is used to recommend practices that are considered beneficial, but are not requirements.

1.7.1.3 May. The word "may" in a provision allows the use of optional procedures or practices that can be used as an alternative or supplement to code requirements. Those optional procedures that require the Engineer's approval shall either be specified in the contract documents, or require the Engineer's approval. The Contractor may use any option without the Engineer's approval when the code does not specify that the Engineer's approval shall be required.

1.8 Welding Symbols

Welding symbols shall be those shown in AWS A2.4, *Standard Symbols for Welding, Brazing, and Nondestructive Examination*. Special conditions shall be fully explained by added notes or details.

2. Normative References

The documents listed below are referenced within this publication and are mandatory to the extent specified herein. For undated references, the latest edition of the referenced standard shall apply. For dated references, subsequent amendments or revisions of the publications may not apply since the relevant requirements may have changed.

American Welding Society (AWS) Standards:

AWS A2.4, *Standard Symbols for Welding, Brazing, and Nondestructive Examination*

AWS A3.0M/A3.0, *Standard Welding Terms and Definitions, Including Terms for Adhesive Bonding, Brazing, Soldering, Thermal Cutting, and Thermal Spraying*

AWS A4.3, *Standard Methods for Determination of the Diffusible Hydrogen Content of Martensitic, Bainitic, and Ferritic Steel Weld Metal Produced by Arc Welding*

AWS A5.01M/A5.01 (ISO 14344:2010 MOD), *Welding and Brazing Consumables—Procurement of Filler Materials and Fluxes*

AWS A5.1/A5.1M, *Specification for Carbon Steel Electrodes for Shielded Metal Arc Welding*

AWS A5.5/A5.5M, *Specification for Low-Alloy Steel Electrodes for Shielded Metal Arc Welding*

AWS A5.12M/A5.12 (ISO 6848 MOD), *Specification for Tungsten and Oxide Dispersed Tungsten Electrodes for Arc Welding and Cutting*

AWS A5.17/A5.17M, *Specification for Carbon Steel Electrodes and Fluxes for Submerged Arc Welding*

AWS A5.18/A5.18M, *Specification for Carbon Steel Electrodes and Rods for Gas Shielded Arc Welding*

AWS A5.20/A5.20M, *Specification for Carbon Steel Electrodes for Flux Cored Arc Welding*

AWS A5.23/A5.23M, *Specification for Low-Alloy and High Manganese Steel Electrodes and Fluxes for Submerged Arc Welding*

AWS A5.25/A5.25M, *Specification for Carbon and Low-Alloy Steel Electrodes and Fluxes for Electroslag Welding*

AWS A5.26/A5.26M, *Specification for Carbon and Low-Alloy Steel Electrodes for Electrogas Welding*

AWS A5.28/A5.28M, *Specification for Low-Alloy Steel Electrodes and Rods For Gas Shielded Arc Welding*

AWS A5.29/A5.29M, *Specification for Low-Alloy Steel Electrodes for Flux Cored Arc Welding*

AWS A5.30/A5.30M, *Specification for Consumable Inserts*

AWS A5.32M/A5.32 (ISO 14175:2008 MOD), *Welding Consumables—Gases and Gas Mixtures for Fusion Welding and Allied Processes*

AWS B5.1, *Specification for the Qualification of Welding Inspectors*

AWS B4.0, *Standard Methods for Mechanical Testing of Welds*

AWS C4.1-77, *Set, Criteria for Describing Oxygen-Cut Surfaces, and Oxygen Cutting Surface Roughness Gauge*

AWS D1.0, *Code for Welding in Building Construction*

AWS D1.8/D1.8M, *Structural Welding Code—Seismic Supplement*

AWS D2.0, *Specifications for Welded Highway and Railway Bridges*

AWS QC1, *Standard for AWS Certification of Welding Inspectors*

ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*

American Institute of Steel Construction (AISC) Standards:

ANSI/AISC 360, *Specification for Structural Steel Buildings*

American Petroleum Institute (API) Standards:

API Spec 2W, *Specification for Steel Plates for Offshore Structures, Produced by Thermo-Mechanical Control Processing (TMCP)*

API Spec 2Y, *Specification for Steel Plates, Quenched and- Tempered, for Offshore Structures*

American Society of Mechanical Engineers (ASME) Standards:

ASME *Boiler and Pressure Vessel Code*, Section V, Article 2

ASME B46.1, *Surface Texture (Surface Roughness, Waviness, and Lay)*

American Society for Nondestructive Testing (ASNT) Standards:

ASNT CP–189, *ASNT Standard for Qualification and Certification of Nondestructive Testing Personnel*

ASNT Recommended Practice No. SNT-TC-1A, *Personnel Qualification and Certification in Nondestructive Testing*

American Society for Testing and Materials (ASTM) Standards:

All ASTM base metals listed in Table 5.6 and Table 6.10 are found in ASTM Volume 01.01, *Steel-Piping, Tubing, Fittings,* ASTM Volume 01.02, *Ferrous Castings; Ferroalloys,* ASTM Volume 01.03, *Steel-Plate, Sheet, Strip, Wire; Stainless Steel Bar*, or ASTM Volume 01.04, *Steel—Structural, Reinforcing, Pressure Vessel, Railway*

ASTM A6/A6M, *Standard Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling*

ASTM A109/A109M, *Standard Specification for Steel, Strip, Carbon, (0.25 Maximum Percent), Cold–Rolled*

ASTM A370, *Standard Test Methods and Definitions for Mechanical Testing of Steel Products*

ASTM A435/A435M, *Standard Specification for Straight Beam Ultrasonic Examination of Steel Plates*

ASTM A673/A673M, *Standard Specification for Sampling Procedure for Impact Testing of Structural Steel*

ASTM E23, *Standard Test Methods for Notched Bar Impact Testing of Metallic Materials*

ASTM E92, *Standard Test Methods for Vickers Hardness and Knoop Hardness of Metallic Materials*

ASTM E94/E94M, *Standard Guide for Radiographic Examination Using Industrial Radiographic Film*

ASTM E140, *Standard Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, Scleroscope Hardness, and Leeb Hardness*

ASTM E165/E165M, *Standard Practice for Liquid Penetrant Testing for General Industry*

ASTM E747, *Standard Practice for Design, Manufacture and Material Grouping Classification of Wire Image Quality Indicators (IQI) Used for Radiography*

ASTM E1032, *Standard Practice for Radiographic Examination of Weldments Using Industrial X-Ray Film*

ASTM E1254, *Standard Guide for Storage of Radiographs and Unexposed Industrial Radiographic Films*

ASTM E2033/E2033M, *Standard Practice for Radiographic Examination Using Computed Radiology (Photostimulable Luminescence Method)*

ASTM E2339, *Standard Practice for Digital Imaging and Communication in Nondestructive Evaluation (DICONDE)*

ASTM E2445/E2445M, *Standard Practice for Performance Evaluation and Long-Term Stability of Computed Radiography Systems*

ASTM E2698, *Standard Practice for Radiological Examination Using Digital Detector Arrays*

ASTM E2699, *Standard Practice for Digital Imaging and Communication in Nondestructive Evaluation (DICONDE) for Digital X-ray (DR) Test Methods*.

ASTM E2737, *Standard Practice for Digital Detector Array Performance Evaluation and Long-Term Stability*

ASTM E3024/E3024M, *Standard Practice for Magnetic Particle Testing for General Industry*

The Association for Materials Protection and Performance (AMPP) Standards:

SSPC-SP2, *Surface Preparation Standard No. 2—Hand Tool Cleaning*

Canadian Standards Association (CSA) Standards:

CSA W178.2, *Certification of Welding Inspectors*

International Institute of Welding (IIW) Ultrasonic Reference Block

3. Terms and Definitions

AWS A3.0M/A3.0, *Standard Welding Terms and Definitions, Including Terms for Adhesive Bonding, Brazing, Soldering, Thermal Cutting, and Thermal Spraying*, provides the basis for terms and definitions used herein. However, the following terms and definitions are included below to accommodate usage specific to this document.

The terms and definitions in this glossary are divided into three categories: (1) general welding terms compiled by the AWS Committee on Definitions and Symbols; (2) terms, defined by the AWS Structural Welding Committee, which apply only to UT, designated by (UT) following the term; and (3) other terms, preceded by asterisks, which are defined as they relate to this code.

For the purposes of this document, the following terms and definitions apply:

A

***allowable strength.** The strength of an element when compared to Allowable Strength Design (ASD) loads calculated as nominal strength divided by the safety factor, Rn.

***alloy flux.** A flux upon which the alloy content of the weld metal is largely dependent.

***all-weld-metal test specimen.** A test specimen with the reduced section composed wholly of weld metal.

***amplitude length rejection level (UT).** The maximum length of discontinuity allowed by various indication ratings associated with weld size, as indicated in Tables 8.2 and 8.3.

***angle of bevel.** See **bevel angle**.

arc gouging. Thermal gouging that uses an arc cutting process variation to form a bevel or groove.

as-welded. The condition of weld metal, welded joints, and weldments after welding, but prior to any subsequent thermal, mechanical, or chemical treatments.

***attenuation (UT).** The loss in acoustic energy which occurs between any two points of travel. This loss may be due to absorption, reflection, etc. (In this code, using the shear wave pulse-echo method of testing, the attenuation factor is 2 dB per inch of sound path distance after the first inch.)

automatic welding. Welding with equipment that requires only occasional or no observation of the welding, and no manual adjustment of the equipment controls. Variations of this term are **automatic brazing, automatic soldering, automatic thermal cutting**, and **automatic thermal spraying**.

***auxiliary attachments.** Members or appurtenances attached to main stress-carrying members by welding. Such members may or may not carry loads.

***available strength.** The design strength (LRFD) or allowable strength (ASD), as applicable.

average instantaneous power (AIP), *waveform-controlled welding*. The average of products of amperages and voltages determined at sampling frequencies sufficient to quantify waveform changes during a welding interval.

axis of a weld. See **weld axis.**

B

backgouging. The removal of weld metal and base metal from the weld root side of a welded joint to facilitate complete fusion and CJP upon subsequent welding from that side.

backing. A material or device placed against the back side of the joint, or at both sides of a weld in ESW and EGW, to support and retain molten weld metal. The material may be partially fused or remain unfused during welding and may be either metal or nonmetal.

backing pass. A weld pass made for a backing weld.

backing ring. Backing in the form of a ring, generally used in the welding of pipe.

backing weld. Backing in the form of a weld.

***backup weld (tubular structures).** The initial closing pass in a CJP groove weld, made from one side only, which serves as a backing for subsequent welding, but is not considered as a part of the theoretical weld (Figures 10.9 through 10.11, Details C and D).

back weld. A weld made at the back of a single groove weld.

base metal. The metal or alloy that is welded, brazed, soldered, or cut.

bevel angle. The angle between the bevel of a joint member and a plane perpendicular to the surface of the member.

box tubing. Tubular product of square or rectangular cross section. See **tubular**.

***brace intersection angle, θ (tubular structures).** The acute angle formed between brace centerlines.

***Building Code.** The building law or specification or other construction regulations in conjunction with which this code is applied.

NOTE: In the absence of any locally applicable building law or specifications or other construction regulations, it is recommended that the construction be required to comply with the ANSI/AISC 360, Specification for Structural Steel Buildings.

butt joint. A joint between two members aligned approximately in the same plane.

butt weld. A nonstandard term for a weld in a butt joint. See **butt joint**.

C

***cap pass.** One or more weld passes that form the weld face (exposed surface of completed weld). Adjacent cap passes may partially cover, but not completely cover, a cap pass.

***caulking.** Plastic deformation of weld and base metal surfaces by mechanical means to seal or obscure discontinuities.

complete fusion. Fusion over the entire fusion faces and between all adjoining weld beads.

complete joint penetration (CJP). A joint root condition in a groove weld in which weld metal extends through the joint thickness.

***computed radiography (CR).**

***CJP groove weld (statically and cyclically loaded structures).** A groove weld which has been made from both sides or from one side on a backing having CJP and fusion of weld and base metal throughout the depth of the joint.

***CJP groove weld (tubular structures).** A groove weld having CJP and fusion of weld and base metal throughout the depth of the joint or as detailed in Figures 10.4, 10.7 through 10.11, and 10.18. A CJP tubular groove weld made from one side only, without backing, is allowed where the size or configuration, or both, prevent access to the root side of the weld.

complete penetration. A nonstandard term for **CJP**. See **complete joint penetration**.

construction aid weld. A weld made to attach a piece or pieces to a weldment for temporary use in handling, shipping, or working on the structure.

consumable guide ESW. See **ESW, consumable guide**.

continuous weld. A weld that extends continuously from one end of a joint to the other. Where the joint is essentially circular, it extends completely around the joint.

contouring fillet welds. Fillet welds applied over CJP and PJP groove welds in butt joints joining parts of unequal width or thickness, corner joints, and T-joints for the purpose of reducing the severity of abrupt changes in the surface.

***contract documents.** Any codes, specifications, drawings, or additional requirements that are contractually specified by the Owner.

***Contractor.** Any company, or that individual representing a company, responsible for the fabrication, erection, manufacturing, or welding, in conformance with the provisions of this code.

***Contractor's Inspector.** The duly designated person who acts for, and in behalf of, the Contractor on all inspection and quality matters within the scope of the code and the contract documents.

corner joint. A joint between two members located approximately at right angles to each other in the form of an L.

***cover pass.** See **cap pass**.

CO_2 welding. A nonstandard term for **GMAW** with carbon dioxide shielding gas.

crater. A depression in the weld face at the termination of a weld bead.

***Charpy V-Notch (CVN).**

D

***digital detector array (DDA).**

***decibel (dB) (UT).** The logarithmic expression of a ratio of two amplitudes or intensities of acoustic energy.

***decibel rating (UT).** See preferred term **indication rating**.

defect. A discontinuity or discontinuities that by nature or accumulated effect (for example, total crack length) render a part or product unable to meet minimum applicable acceptance standards or specifications. This term designates rejectability.

defective weld. A weld containing one or more defects.

***defect level (UT**). See **indication level**.

***defect rating (UT).** See **indication rating**.

depth of fusion. The distance that fusion extends into the base metal or previous bead from the surface melted during welding.

***design strength.** The strength of an element when compared to Load and Resistance Factor Design (LRFD) loads calculated as resistance factor multiplied by the nominal strength, φRn.

***dihedral angle.** See **local dihedral angle**.

discontinuity. An interruption of the typical structure of a material, such as a lack of homogeneity in its mechanical, metallurgical, or physical characteristics. A discontinuity is not necessarily a defect.

downhand. A nonstandard term for **flat welding position**.

***direct radiography (DR).**

***drawings.** Refers to plans, design and detail drawings, and erection plans.

E

***edge angle (tubular structures).** The acute angle between a bevel edge made in preparation for welding and a tangent to the member surface, measured locally in a plane perpendicular to the intersection line. All bevels open to outside of brace.

***effective length of weld.** The length throughout which the correctly proportioned cross section of the weld exists. In a curved weld, it shall be measured along the weld axis.

electrogas welding (EGW). An arc welding process that uses an arc between a continuous filler metal electrode and the weld pool, employing approximately vertical welding progression with backing to confine the molten weld metal. The process is used with or without an externally supplied shielding gas and without the application of pressure.

electroslag welding (ESW). A welding process that produces coalescence of metals with molten slag that melts the filler metal and the surfaces of the workpieces. The weld pool is shielded by this slag, which moves along the full cross section of the joint as welding progresses. The process is initiated by an arc that heats the slag. The arc is then extinguished by the conductive slag, which is kept molten by its resistance to electric current passing between the electrode and the workpieces.

ESW, consumable guide. An electroslag welding process variation in which filler metal is supplied by an electrode and its guiding member.

***end return.** The continuation of a fillet weld around a corner of a member as an extension of the principal weld.

***Engineer.** A duly designated individual who acts for and in behalf of the Owner on all matters within the scope of the code.

F

***false indication.** An NDT indication that is interpreted to be caused by a condition other than a discontinuity or imperfection.

***fatigue.** Fatigue, as used herein, is defined as the damage that may result in fracture after a sufficient number of stress fluctuations. Stress range is defined as the peak-to-trough magnitude of these fluctuations. In the case of stress reversal, stress range shall be computed as the numerical sum (algebraic difference) of maximum repeated tensile and compressive stresses, or the sum of shearing stresses of opposite direction at a given point, resulting from changing conditions of load.

faying surface. The mating surface of a member that is in contact with or in close proximity to another member to which it is to be joined.

filler metal. The metal or alloy to be added in making a welded, brazed, or soldered joint.

fillet weld leg. The distance from the joint root to the toe of the fillet weld.

fin. A defect in a bar or other rolled section caused by the steel spreading into the clearance between the rolls. This produces a thick overfill which, if rolled again, usually becomes a lap.

flare-bevel-groove weld. A weld in the groove formed between a joint member with a curved surface and another with a planar surface.

***flash,** *arc stud welding*. Solidified metal formed by the expulsion of molten metal displaced from a stud weld joint beyond the original stud base diameter.

flat welding position. The welding position used to weld from the upper side of the joint at a point where the weld axis is approximately horizontal, and the weld face lies in an approximately horizontal plane.

flux cored arc welding (FCAW). An arc welding process that uses an arc between a continuous filler metal electrode and the weld pool. The process is used with shielding gas from a flux contained within the tubular electrode, with or without additional shielding from an externally supplied gas, and without the application of pressure.

***flux cored arc welding—gas shielded (FCAW-G).** A flux cored arc welding process variation in which additional shielding is obtained from an externally supplied gas or gas mixture.

***flux cored arc welding—self shielded (FCAW-S).** A flux cored arc welding process where shielding is exclusively provided by a flux contained within the tubular electrode.

fusion. The melting together of filler metal and base metal (substrate), or of base metal only, to produce a weld.

fusion line. The boundary between weld metal and base metal in a fusion weld.

***fusion-type discontinuity.** Signifies slag inclusion, incomplete fusion, incomplete joint penetration, and similar discontinuities associated with fusion.

fusion zone. The area of base metal melted as determined on the cross section of a weld.

G

gas metal arc welding (GMAW). An arc welding process that uses an arc between a continuous filler metal electrode and the weld pool. The process is used with shielding from an externally supplied gas and without the application of pressure.

gas metal arc welding—short circuit arc (GMAW-S). A gas metal arc welding process variation in which the consumable electrode is deposited during repeated short circuits.

gas pocket. A nonstandard term for **porosity**.

geometric unsharpness (U_g). The fuzziness or lack of definition in a radiographic image resulting from the combination of source size, object-to-film distance, and source-to-object distance.

gouging. See **thermal gouging**.

groove angle. The total included angle of the groove between workpieces.

***groove angle, ϕ (tubular structures).** The angle between opposing faces of the groove to be filled with weld metals, determined after the joint is fit-up.

groove face. The surface of a joint member included in the groove.

groove weld. A weld made in the groove between the workpieces.

H

heat-affected zone (HAZ). The portion of the base metal whose mechanical properties or microstructure have been altered by the heat of welding, brazing, soldering, or thermal cutting.

***hold-back**. The unwelded portion of a joint where a fillet weld is intentionally started or stopped away from the end of the joint.

horizontal fixed position (pipe welding). The position of a pipe joint in which the axis of the pipe is approximately horizontal, and the pipe is not rotated during welding (see Figures 6.1, 6.2, 10.12, and 10.13).

horizontal welding position, *fillet weld*. The welding position in which the weld is on the upper side of an approximately horizontal surface and against an approximately vertical surface (see Figures 6.2 and 6.4).

***horizontal reference line (UT).** A horizontal line near the center of the UT instrument scope to which all echoes are adjusted for dB reading.

horizontal rotated position (pipe welding). The position of a pipe joint in which the axis of the pipe is approximately horizontal, and welding is performed in the flat position by rotating the pipe (see Figures 6.1, 6.2, 10.12, and 10.13).

***hot-spot strain (tubular structures).** The cyclic total range of strain which would be measured at the point of highest stress concentration in a welded connection.

NOTE: When measuring hot-spot strain, the strain gauge should be sufficiently small to avoid averaging high and low strains in the regions of steep gradients.

I

***image quality indicator (IQI).** A device whose image in a radiograph is used to determine RT quality level. It is not intended for use in judging the size nor for establishing acceptance limits of discontinuities.

***indication (MT or PT).** The visual representation of a discontinuity enhanced by the application of NDT surface materials.

***indication (UT).** The signal displayed on the oscilloscope signifying the presence of a sound wave reflector in the part being tested.

***indication level (UT).** The calibrated gain or attenuation control reading obtained for a reference line height indication from a discontinuity.

***indication rating (UT).** The decibel reading in relation to the zero reference level after having been corrected for sound attenuation.

intermittent weld. A weld in which the continuity is broken by recurring unwelded spaces.

***interpass temperature.** In a multipass weld, the temperature of the weld area between weld passes (see preheat temperature, *welding*).

J

joint. The junction of members or the edges of members that are to be joined or have been joined.

joint penetration. The distance the weld metal extends from the weld face into a joint, exclusive of weld reinforcement.

joint root. That portion of a joint to be welded where the members approach closest to each other. In cross section, the joint root may be either a point, a line, or an area.

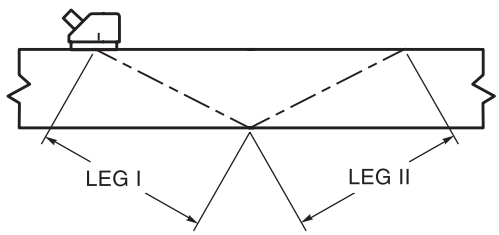
L

lap joint. A joint between two overlapping members in parallel planes.

***layer.** A stratum of weld metal or surfacing material. The layer may consist of one or more weld beads laid side by side.

***leg (UT).** The path the shear wave travels in a straight line before being reflected by the surface of material being tested.

See sketch for leg identification. Note: Leg I plus leg II equals one V-path.



leg of a fillet weld. See **fillet weld leg.**

***local dihedral angle, Ψ (tubular structures).** The angle, measured in a plane perpendicular to the line of the weld, between tangents to the outside surfaces of the tubes being joined at the weld. The exterior dihedral angle, where one looks at a localized section of the connection, such that the intersecting surfaces may be treated as planes.

M

manual welding. Welding with the torch, gun or electrode holder held and manipulated by hand. Accessory equipment, such as part motion devices and manually controlled filler material feeders may be used. See **automatic welding, mechanized welding**, and **semiautomatic welding**.

matching strength filler metal. For materials listed in Table 5.6, matching filler metals are those in the corresponding groups in Table 5.7. For materials listed in Table 6.10 matching filler metals are those in corresponding groups in Table 6.10. For unlisted materials, matching strength filler metal is a filler metal that when classified in accordance with a recognized standard, has a specified minimum tensile strength in the joint in accordance with 4.4.1.1.

mechanized process (XXXX-ME). An operation with equipment requiring manual adjustment by an operator in response to visual observation, with the torch, gun, wire guide assembly, or electrode holder held by a mechanical device.

mechanized welding (W-ME). See **mechanized process.**

***magnetic particle testing (MT).**

N

***nondestructive testing (NDT).** The process of determining acceptability of a material or a component in accordance with established criteria without impairing its future usefulness.

***node (UT).** See **leg**.

***nominal tensile strength of the weld metal.** The tensile strength of the weld metal indicated by the classification number of the filler metal (e.g., nominal tensile strength of E60XX is 60 ksi [420 MPa]).

O

***Original Equipment Manufacturer (OEM).** A single Contractor that assumes some or all of the responsibilities assigned by this code to the Engineer.

overhead welding position. The welding position in which welding is performed from the underside of the joint (see Figures 6.1, 6.2, 6.3, and 6.4).

overlap, *fusion welding.* The protrusion of weld metal beyond the weld toe or weld root.

overmatching strength filler metal. Overmatching strength filler metal is filler metal that, when classified in accordance with the applicable AWS A5 specification, has a specified minimum tensile strength that is greater than the strength level of matching filler metals.

***Owner.** The individual or company that exercises legal ownership of the product or structural assembly produced to this code.

oxygen cutting (OC). A group of thermal cutting processes that severs or removes metal by means of the chemical reaction between oxygen and the base metal at elevated temperature. The necessary temperature is maintained by the heat from an arc, an oxyfuel gas flame, or other source.

oxygen gouging. Thermal gouging that uses an oxygen cutting process variation to form a bevel or groove.

P

***parallel electrode.** See **SAW.**

partial joint penetration (PJP). Joint penetration that is intentionally less than complete.

pass. See **weld pass**.

peening. The mechanical working of metals using impact blows.

***pipe.** Hollow circular cross section produced or manufactured in accordance with a pipe product specification. See **tubular**.

***piping porosity (ESW and EGW).** Elongated porosity whose major dimension lies in a direction approximately parallel to the weld axis.

***piping porosity (general).** Elongated porosity whose major dimension lies in a direction approximately normal to the weld surface. Frequently referred to as *pin holes* when the porosity extends to the weld surface.

plug weld. A weld made in a circular hole in one member of a joint fusing that member to another member. A fillet-welded hole shall not be construed as conforming to this definition.

porosity. Cavity-type discontinuities formed by gas entrapment during solidification or in a thermal spray deposit.

positioned weld. A weld made in a joint that has been placed to facilitate making the weld.

***postweld heat treatment.** Any heat treatment after welding.

preheating. The application of heat to the base metal immediately before welding, brazing, soldering, thermal spraying, or cutting.

***preheat temperature**, *welding*. The temperature of the base metal in the volume surrounding the point of welding immediately before welding is started. In a multiple-pass weld, it is also the temperature immediately before the second and subsequent passes are started.

***liquid penetrant testing (PT).**

***postweld heat treatment (PWHT).**

Q

qualification. See **welder performance qualification** and **WPS qualification.**

R

random sequence. A longitudinal sequence in which the weld bead increments are made at random.

***reference level (UT).** The decibel reading obtained for a horizontal reference-line height indication from a reference reflector.

***reference reflector (UT).** The reflector of known geometry contained in the IIW reference block or other approved blocks.

reinforcement of weld. See **weld reinforcement.**

***resolution (UT).** The ability of UT equipment to give separate indications from closely spaced reflectors.

root face. That portion of the groove face within the joint root.

root gap. A nonstandard term for **root opening.**

root of joint. See **joint root**.

root of weld. See **weld root.**

root opening. A separation at the joint root between the workpieces.

***radiographic testing (RT).**

S

***scanning level (UT).** The dB setting used during scanning, as described in Tables 8.2 and 8.3.

semiautomatic welding. Manual welding with equipment that automatically controls one or more of the welding conditions.

***shelf bar.** Steel plates, bars, or similar elements used to support the overflow of excess weld metal deposited in a horizontal groove weld joint.

shielded metal arc welding (SMAW). An arc welding process with an arc between a covered electrode and the weld pool. The process is used with shielding from the decomposition of the electrode covering, without the application of pressure, and with filler metal from the electrode.

shielding gas. Protective gas used to prevent or reduce atmospheric contamination.

single-welded joint. A joint that is welded from one side only.

size of weld. See **weld size**.

slot weld. A weld made in an elongated hole in one member of a joint fusing that member to another member. The hole may be open at one end. A fillet welded slot shall not be construed as conforming to this definition.

***sound beam distance (UT).** See **sound path distance.**

***sound path distance (UT).** The distance between the search unit test material interface and the reflector as measured along the centerline of the sound beam.

***storage phosphor imaging plate (SPIP).**

spatter. The metal particles expelled during fusion welding that do not form a part of the weld.

stringer bead. A type of weld bead made without appreciable weaving motion.

***stud base.** The stud tip at the welding end, including flux and container, and 1/8 in [3 mm] of the body of the stud adjacent to the tip.

***stud welding (SW).** An arc welding process that produces coalescence of metals by heating them with an arc between a metal stud, or similar part, and the other workpiece. When the surfaces to be joined are properly heated, they are brought together under pressure. Partial shielding may be obtained by the use of a ceramic ferrule surrounding the stud. Shielding gas or flux may or may not be used.

submerged arc welding (SAW). An arc welding process that uses an arc or arcs between a bare metal electrode or electrodes and the weld pool. The arc and molten metal are shielded by a blanket of granular flux on the workpieces. The process is used without pressure and with filler metal from the electrode and sometimes from a supplemental source (welding rod, flux, or metal granules).

***single electrode.** One electrode connected exclusively to one power source which may consist of one or more power units.

***multiple electrodes.** The combination of two or more single or parallel electrode systems. Each of the component systems has its own independent power source and its own electrode feeder.

***parallel electrode.** Two electrodes connected electrically in parallel and exclusively to the same power source. Both electrodes are usually fed by means of a single electrode feeder. Welding current, when specified, is the total for the two.

supplemental filler metal, *submerged arc welding*. Metal introduced into the weld other than the consumable electrode(s).

T

tack weld. A weld made to hold parts of a weldment in proper alignment until the final welds are made.

***tack welder.** A fitter, or someone under the direction of a fitter, who tack welds parts of a weldment to hold them in proper alignment until the final welds are made.

***tandem.** Refers to a geometrical arrangement of electrodes in which a line through the arcs is parallel to the direction of welding.

thermal gouging. A thermal cutting process variation that removes metal by melting or burning the entire removed portion, to form a bevel or groove.

throat of a fillet weld.

actual throat. The shortest distance between the weld root and the face of a fillet weld.

theoretical throat. The distance from the beginning of the joint root perpendicular to the hypotenuse of the largest right triangle that can be inscribed within the cross section of a fillet weld. This dimension is based on the assumption that the root opening is equal to zero.

throat of a groove weld. A nonstandard term for **groove weld size**.

T-joint. A joint between two members located approximately at right angles to each other in the form of a T.

toe of weld. See **weld toe.**

***transverse discontinuity.** A weld discontinuity whose major dimension is in a direction perpendicular to the weld axis "X," see Annex O, Form O-11.

total instantaneous energy (TIE), *waveform-controlled welding*. The sum of products of amperages, voltages and time intervals determined at sampling frequencies sufficient to quantify waveform changes during a welding interval.

***tubular.** A generic term that refers to sections including pipe products (see **pipe**) and the family of square, rectangular, and round hollow-section products produced or manufactured in accordance with a tubular product specification. Also referred to as hollow structural section (HSS).

***tubular connection.** A connection in the portion of a structure that contains two or more intersecting members, at least one of which is a tubular member.

***tubular joint.** A joint in the interface created by a tubular member intersecting another member (which may or may not be tubular).

U

***ultrasonic testing (UT).**

***unacceptable discontinuity**. See **defect.**

undercut. A groove melted into the base metal adjacent to the weld toe or weld root and left unfilled by weld metal.

undermatching strength filler metal. Undermatching strength filler metal is filler metal that, when classified in accordance with the applicable AWS A5 specification, has a specified minimum tensile strength that is less than the strength level of matching filler metals.

V

***Verification Inspector.** The duly designated person who acts for, and in behalf of, the Owner on all inspection and quality matters designated by the Engineer.

vertical welding position. The welding position in which the weld axis, at the point of welding, is approximately vertical, and the weld face lies in an approximately vertical plane (see Figures 6.1, 6.2, 6.3, and 6.4).

***vertical position (pipe welding).** The position of a pipe joint in which welding is performed in the horizontal position and the pipe is not rotated during welding (see Figures 6.1, 6.2, 10.12, and 10.13).

***V-path (UT).** The distance a shear wave sound beam travels from the search unit test material interface to the other face of the test material and back to the original surface.

W

weave bead. A type of weld bead made with transverse oscillation.

weld. A localized coalescence of metals or nonmetals produced by heating the materials to the welding temperature, with or without the application of pressure or by the applications of pressure alone and with or without the use of filler material.

weldability. The capacity of a material to be welded under the imposed fabrication conditions into a specific, suitably designed structure and to perform satisfactorily in the intended service.

weld axis. A line through the length of a weld, perpendicular to and at the geometric center of its cross section.

weld bead. A weld resulting from a pass. See **stringer bead** and **weave bead**.

welder. One who performs a manual or semiautomatic welding operation.

welder certification. Written certification that a welder has produced welds meeting a prescribed standard of welder performance.

welder performance qualification. The demonstration of a welder's ability to produce welds meeting prescribed standards.

weld face. The exposed surface of a weld on the side from which welding was done.

welding. A joining process that produces coalescence of materials by heating them to the welding temperature, with or without the application of pressure or by the application of pressure alone, and with or without the use of filler metal. See also the Master Chart of Welding and Joining Processes in the latest edition of AWS A3.0.

welding machine. Equipment used to perform the welding operation. For example, spot welding machine, arc welding machine, and seam welding machine.

welding operator. One who operates adaptive control, automatic, mechanized, or robotic welding equipment.

welding sequence. The order of making the welds in a weldment.

weld pass. A single progression of welding along a joint. The result of a pass is a weld bead or layer.

weld reinforcement. Weld metal in excess of the quantity required to fill a joint.

weld root. The points, as shown in cross section, at which the root surface intersects the base metal surfaces.

weld size.

fillet weld size. For equal leg fillet welds, the leg lengths of the largest isosceles right triangle that can be inscribed within the fillet weld cross section. For unequal leg fillet welds, the leg lengths of the largest right triangle that can be inscribed within the fillet weld cross section.

NOTE: When one member makes an angle with the other member greater than 105°, the leg length (size) is of less significance than the effective throat, which is the controlling factor for the strength of the weld.

groove weld size. The joint penetration of a groove weld.

weld tab. Additional material that extends beyond either end of the joint, on which the weld is started or terminated.

weld toe. The junction of the weld face and the base metal.

weldment. An assembly whose component parts are joined by welding.

WPS qualification. The demonstration that welds made by a specific procedure can meet prescribed standards.

***welding procedure specification (WPS).** A document providing the detailed methods and practices involved in the production of a weldment.