



AWS Errata Sheet

The following Errata have been identified and will be incorporated into the next reprinting of this document.

AWS Standard: AWS D14.3/D14.3M:2010, *Specification for Welding Earthmoving, Construction, and Agricultural Equipment*

Page 2 – 3. – Format Change – Indent “**groove welds,**” “**fillet welds,**” and “**plug and slot welds.**”

Page 7 – 7.1.1 – Incorrect Reference – Change reference from “7.2.1” to “7.1.3.”

Page 8 – 7.1.3 – Incorrect Reference – Change reference from “7.1.3” to “7.1.2.”

Page 13 – 7.5.2(1) – Incorrect Reference – “Steels listed in Table 2 or defined in Table 3...” should be “Steels listed in Table 4 or defined in Table 5...”

Page 15 – Table 5 – Incorrect Yield Strength Range – Change Yield Strength range For Class III from “40-45” to “40-55.”

Page 19 – 7.5.8 – Add 7.5.8.2 and 7.5.8.3 after 7.5.8.1 as follows:

“**7.5.8.2** The following requirements are essential when using the gas metal arc process for solid and metal cored wires for prequalified procedures that are exempt from qualification testing:

- (1) The maximum electrode diameter shall be 1/16 in. [1.6 mm].
- (2) The maximum size fillet weld made in one pass shall be 3/8 in. [10 mm] for the flat position and 5/16 in. [8 mm] for the horizontal position.
- (3) The thickness of weld layers, except the root, shall not exceed 1/4 in. [6 mm]. A multiple-pass split-layer technique shall be used when the root opening of a groove weld is greater than 3/8 in. [10 mm]. The split-layer technique shall also be used in making all multiple-pass welds (fillet or groove) when the width of the preceding layer exceeds 1/2 in. [13 mm].

7.5.8.3 The following requirements are essential when using the flux cored arc process for prequalified procedures that are exempt from qualification testing:

- (1) The maximum electrode diameter shall be 7/64 in. [2.8 mm].
- (2) The maximum size of a fillet weld made in one pass shall be 1/2 in. [13 mm] for the flat position and 5/16 in. [8 mm] for the horizontal position.
- (3) The thickness of weld layers, except the root, shall not exceed 1/4 in. [6 mm]. A multiple-pass split-layer technique shall be used when the root opening of a groove weld is greater than 3/8 in. [10 mm]. The split-layer technique shall also be used in making all multiple-pass welds when the width of the preceding layer exceeds 5/8 in. [16 mm].”