

ERRATA SHEET

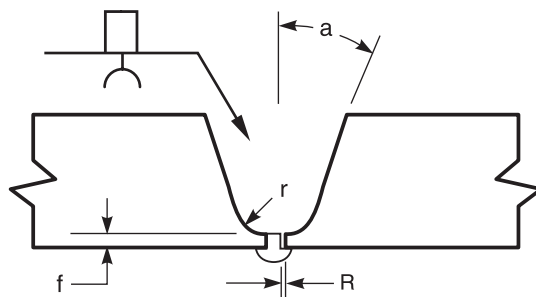
AWS B2.1-4-220:1999, Standard Welding Procedure Specification (WPS) for Gas Tungsten Arc Welding (Consumable Insert Root) of Chromium-Molybdenum Steel (M-4/P-4, Group 1 or 2), 1/8 through 1/2 in. Thick, As-Welded Condition, 1/8 through 3/4 in. Thick, PWHT Condition, IN515 and ER80S-B2, Primarily Pipe Applications

The following Errata have been identified and incorporated into the current reprint of this document.

Pages 5-6 – Figure 1, Joints 1 thru 4 – Incorrect illustrations. Replace joint figures with correct joints illustrations below:

Standard Welding Procedure Specification (SWPS)

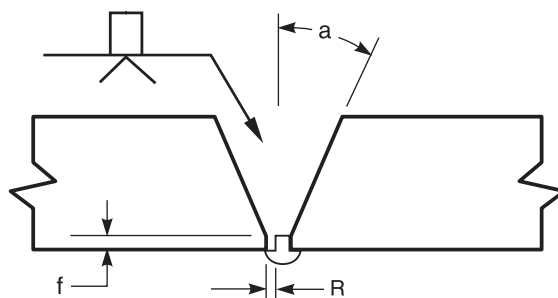
GROOVE WELDS: For pipe and tubular products, see Joints 1 through 13. In addition, joints having groove designs resulting from end preparations conforming with ASME B16.25, *Buttwelding Ends*, are also allowable for application with this SWPS.



CLASS 1 INSERT

$a = 22\text{-}1/2^\circ \pm 2\text{-}1/2^\circ$
 $f = 1/16 \text{ in.} \pm 1/32 \text{ in.}$
 $r = 1/8 \text{ in. TO } 3/16 \text{ in. RADIUS}$
 $R = 1/32 \text{ in. max}$
 I.D. MISMATCH = 1/32 in. max

JOINT 1



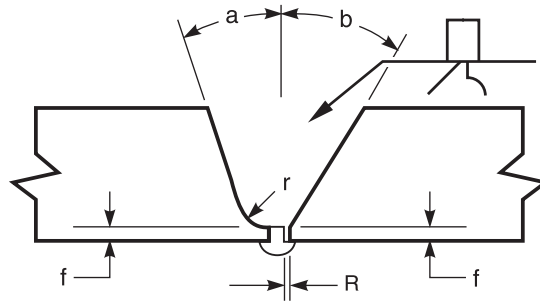
CLASS 1 INSERT

$a = 37\text{-}1/2^\circ \pm 2\text{-}1/2^\circ$
 $f = 1/32 \text{ in.} \pm 1/32 \text{ in.}$
 $R = 1/32 \text{ in. max}$
 I.D. MISMATCH = 1/32 in. max

JOINT 2

Figure 1—Allowable Joint Designs

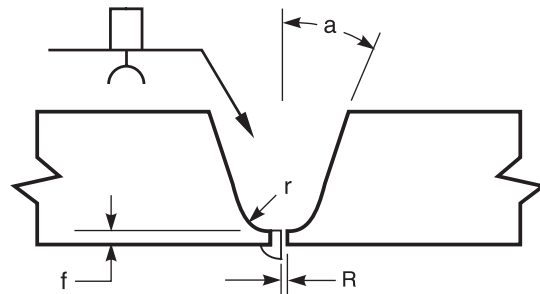
Standard Welding Procedure Specification (SWPS)



CLASS 1 INSERT

$a = 22-1/2^\circ \pm 2-1/2^\circ$
 $b = 37-1/2^\circ \pm 2-1/2^\circ$
 $f = 1/16 \text{ in.} \pm 1/32 \text{ in.}$
 $r = 1/8 \text{ in. TO } 3/16 \text{ in. RADIUS}$
 $R = 1/32 \text{ in. max}$
 I.D. MISMATCH = $1/32 \text{ in. max}$

JOINT 3



CLASS 2 INSERT

$a = 22-1/2^\circ \pm 2-1/2^\circ$
 $f = 1/16 \text{ in.} \pm 1/32 \text{ in.}$
 $r = 1/8 \text{ in. TO } 3/16 \text{ in. RADIUS}$
 $R = 1/32 \text{ in. max}$
 I.D. MISMATCH = $1/16 \text{ in. max}$

JOINT 4

Figure 1 (Continued)—Allowable Joint Designs

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