



AWS D1.1 Interpretation

Subject: Visual Inspection of Test Plate
Code Edition: D1.1-94
Code Provision: Figure 4.21 and Subsection 4.8.1
AWS Log: D1-2.58

Inquiry: For a welder qualification test plate, such as depicted in Figure 4.21, visual inspection of the weld is required by Table 4.9, Note 1. Visual inspection is to be performed to the acceptance criteria of 4.8.1.

- (1) The question is whether the entire 5-in. length of the Figure 4.21 test requires the visual inspection acceptance criteria to be applied, or whether it is the intent to exclude the 1-1/4 in. at each end of the weld from evaluation, as is done for radiographic evaluation by subsection 4.30.3.
- (2) As a follow-on question, if the entire 5-in. length is to be evaluated, can the backing strip shown in the figure be extended to allow a run-on/run-off area?

Response:

- (1) Yes. The entire length of the test plate must be subjected to visual inspection.
- (2) Yes. Weld tabs may be used but are outside the area of visual inspection.

AWS D1.1, Structural Welding Code—Steel, is prepared by the AWS Structural Welding Committee. Because the Code is written in the form of a specification, it cannot present background material or discuss the committee's intent.

Since the publication of the first edition of the Code, the nature of inquiries directed to the American Welding Society and the Structural Welding Committee has indicated that there are some requirements in the Code that are either difficult to understand or not sufficiently specific, and other that appear to be overly conservative.

It should be recognized that the fundamental premise of the Code is to provide general stipulations applicable to any situation and to leave sufficient latitude for the exercise of engineering judgment. Another point to be recognized is that the Code represents the collective experience of the committee; and, while some provisions may seem overly conservative, they have been based on sound engineering practice.