



AWS D1.1 Interpretation

Subject: Combination of Qualified and Prequalified WPSs
Code Edition: D1.1-84
Code Provision: Subsection 5.1.3
AWS Log: D1-85-019

Inquiry: Does 5.1.3 permit a welding procedure to be used that combines a welding procedure qualified in accordance with 5.2 for the root of the weld and a prequalified procedure for the remainder of the weld?

Response: Yes. A combination of qualified or prequalified joint welding procedures may be used without qualification provided the limitation of essential variables applicable to each process is observed.

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.