American Welding Society

550 NW LeJeune Road *Miami, Florida 33126*

AWS D1.1 Interpretation

Subject: Qualification Requirements
Code Edition: D1.1-84
Code Provision: Figure 5.10.1.3 and Subsections 5.18, 5.19
AWS Log: D1-85-031

Inquiry:

(1) Does Note 4 in Figure 5.10.1.3F, Reduced Section Tension Specimens, apply to the capacity of the testing machine?
(2) In Figure 5.10.1.3D, Location of Test Specimens on a Welded Test Plate Over 3/8 in. Thick-Procedure Qualification, is the 20 in. minimum plate width required?
(3) Is the rolling direction important for test plate validity?
(4) Is a welder who qualified using groove details of 5.18 or 5.19 qualified to weld other groove details?
(5) Is it permissible for a welder to qualify using a test plate with thickness larger than 3/8 in. and smaller than 1 in.?
(6) Must only the standard joint details specified for plate in Figures 5.18 and 5.19 be used for qualifying welders?

Response:

(1) No. Note 4 applies to specific cases where small diameter tubing is tested.
(2) Yes.
(3) Yes.
(4) Yes, within the limits of Section 5, Part C.
(5) Yes. Table 5.26.1 permits groove welding qualification on plate with thickness larger than 3/8 in. and smaller than 1 in.