



AWS D1.1 Interpretation

Subject: Welder Qualification (Allowable Undercut)

Code Edition: D1.1-86

Code Provision: Subsection 5.28.6

AWS Log: D1-88-001

Inquiry: In 5.28.6, directions are provided for visually evaluating a welder qualification test plate in accordance with 9.25.1. There are two maximum limits of allowable undercut in 9.25.1; which of these values should be used for evaluation of the welder qualification test plate?

Response: Undercut shall be no more than 1/32 in. (0.8 mm) deep. Note that the maximum allowable undercut for qualifying procedures, welders, welding operators, and tack welders was revised to 1/32 in. maximum in AWS D1.1-88.

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.