



AWS D1.1 Interpretation

Subject: Fillet weld inspection
Code Edition: D1.1:2002
Code Provision: Section 6
AWS Log: INQ-45

Inquiry:

- (1) Does D1.1-2002 require fillet welds to be subject to RT requirements?
- (2) Fillet welds subject to MT shall be evaluated based on visual inspection criteria. If these welds have successfully passed the MT test based on visual acceptance criteria Table 6.1 but do not pass the RT criteria applicable to CJP welds, will it be considered as Gross Non Conformance to D1.1-2002 Section 6.6.5?
- (3) Does D1.1-2002 require the fillet welds which are permitted to have a gap of up to 5 mm by AWS section 5.22 to comply with the same acceptance criteria as applied to the CJP welds?

Response:

- (1) No
- (2) Since the Code does not address the RT of fillet welds, the acceptability of RT-detected discontinuities is exclusively a contractual issue. The application of 6.6.5 to the detection of flaws unacceptable to such contractual criteria is an issue to be decided between the contracting parties.
- (3) No

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.