

Figure 2a Welding End Detail for Joint Without Backing Ring.

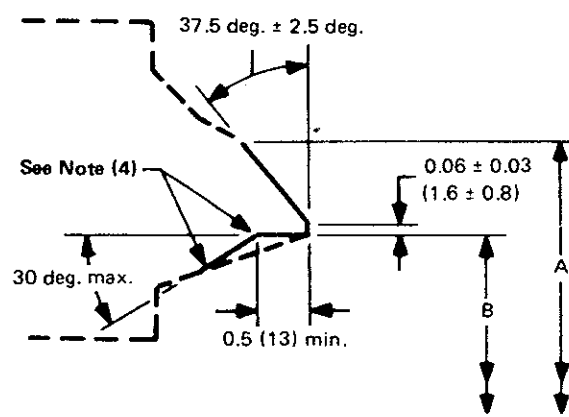


Figure 2b(5) Welding End Detail for Joint Using Split Rectangular Backing Ring.

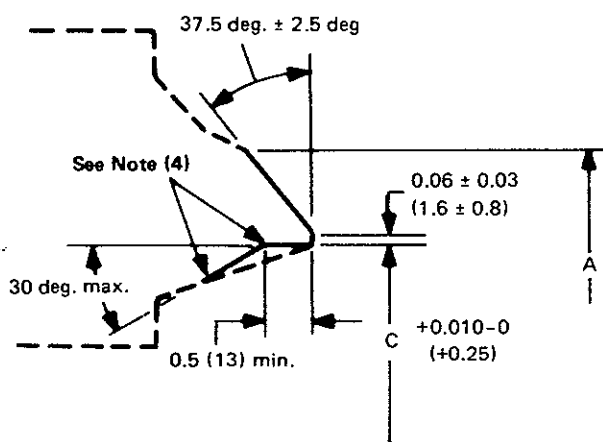


Figure 2c Welding End Detail for Joint Using Continuous Rectangular Backing Ring.

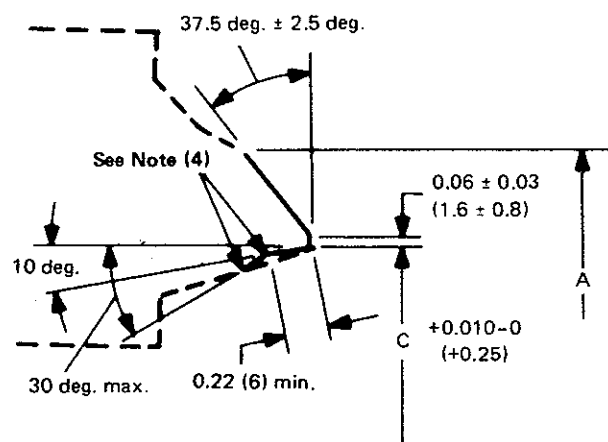


Figure 2d Welding End Detail for Joint Using Continuous Tapered Backing Ring.

NOTES:

- (1) Dotted lines denote maximum envelope for transitions from welding bevel and root face into body of component. See Figure 1 for details.
- (2) Internal surface may be as-formed or machined for dimension B at root face. Contour within the envelope is manufacturer's option unless otherwise specifically ordered.
- (3) See Section 5 for tolerances other than those given in these figures.
- (4) Intersections should be slightly rounded.
- (5) Purchase order must specify contour of ring intended to be used.

Linear dimensions are in inches with metric values shown in millimeters in parenthesis.

FIGURE 2 WELDING END DETAILS INTENDED FOR USE ON 0.88 in. (22 mm) AND THINNER NOMINAL WALL THICKNESSES

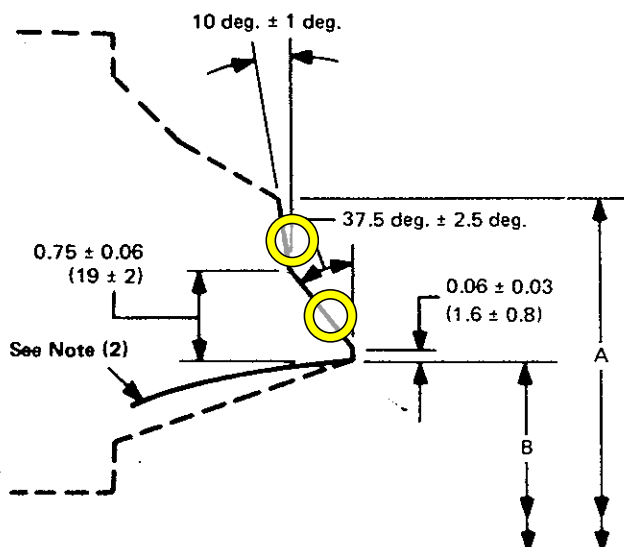


Figure 3a Welding End Detail for Joint Without Backing Ring

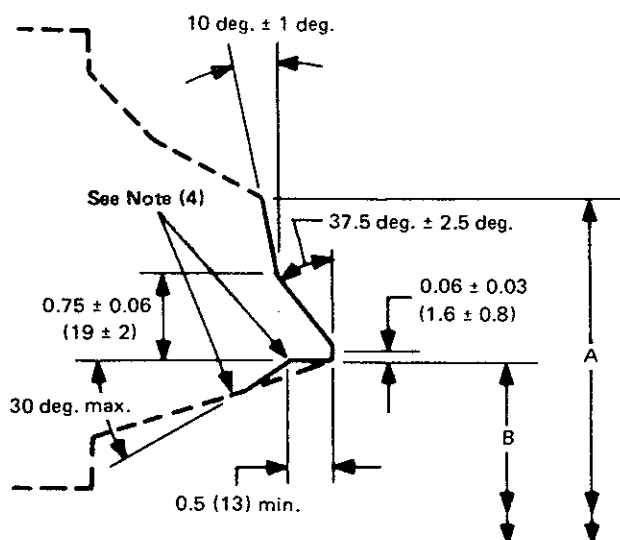


Figure 3b(5) Welding End Detail for Joint Using Split Rectangular Backing Ring.

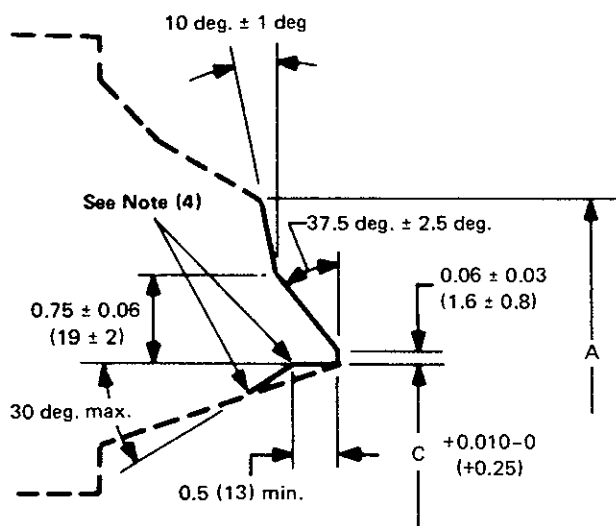


Figure 3c Welding End Detail for Joint Using Continuous Rectangular Backing Ring.

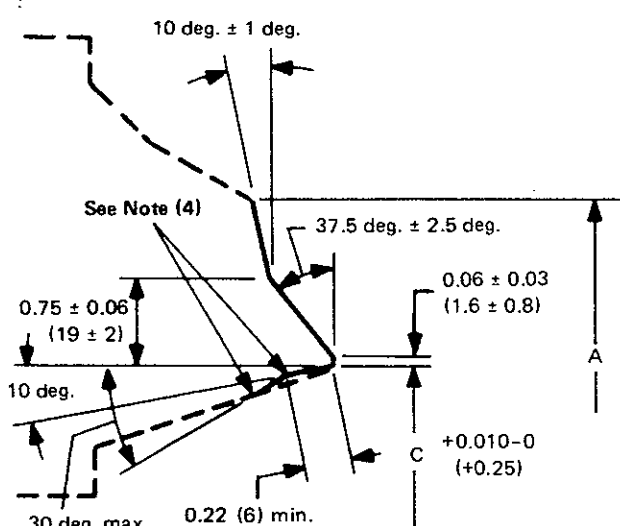


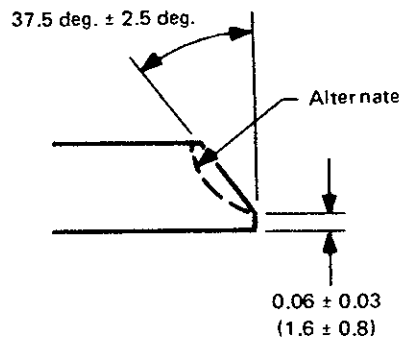
Figure 3d Welding End Detail for Joint Using Continuous Tapered Backing Ring.

NOTES:

- (1) Dotted lines denote maximum envelope for transitions from welding groove and root face into body of components. See Figure 1 for details.
- (2) Internal surface may be as-formed or machined for dimension B at roof face. Contour within the envelope is manufacturer's option otherwise specifically ordered.
- (3) See Section 5 for tolerances other than those given in these figures.
- (4) Intersections should be slightly rounded.
- (5) Purchase order must specify contour of ring intended to be used.

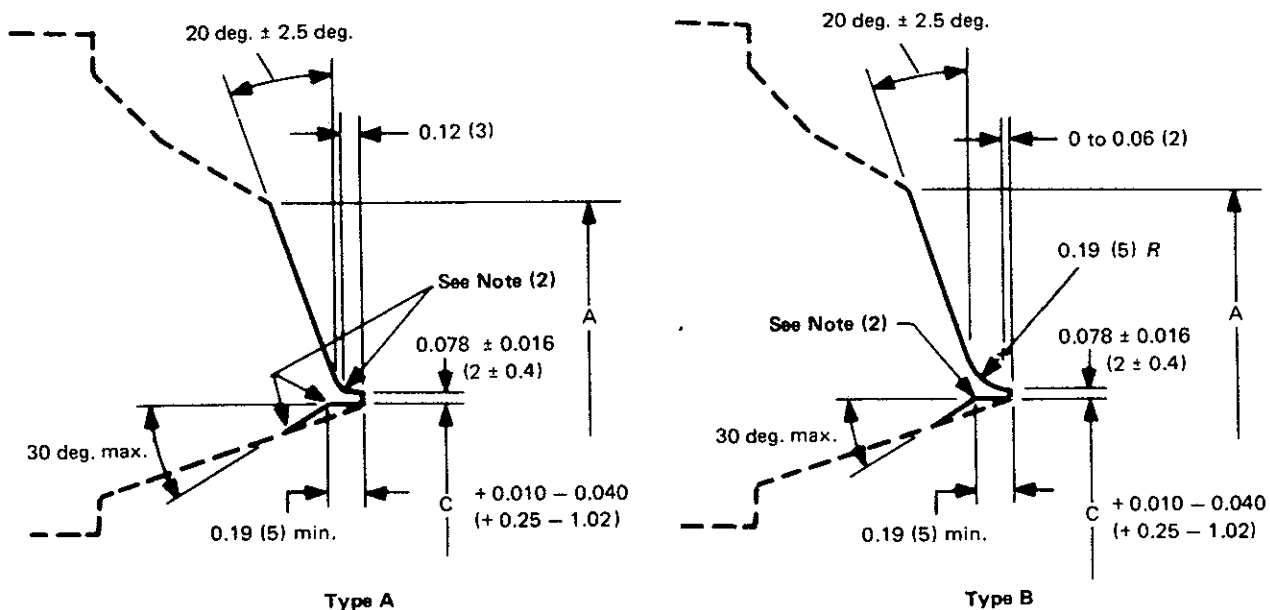
Linear dimensions are in inches with metric values (mm) shown in parenthesis.

FIGURE 3 WELDING END DETAILS INTENDED FOR USE ON NOMINAL WALL THICKNESSES GREATER THAN 0.88 in. (22 mm)



Linear dimensions are in inches with metric values shown in millimeters in parenthesis.

FIGURE 4 WELD BEVEL DETAILS INTENDED FOR USE OF GAS TUNGSTEN ARC ROOT PASS WELDING OF NOMINAL WALL THICKNESSES OVER 0.12 in. (3 mm) TO 0.38 in. (10 mm) INCLUSIVE



NOTES:

- (1) Dotted lines denote maximum envelope for transitions from welding groove and land into body of component. See Figure 1 for details.
 - (2) Inside corners should be slightly rounded.
 - (3) See Section 5 for tolerances other than those given in these sketches.
- Linear dimensions are in inches with metric values shown in millimeters in parenthesis.

FIGURE 5 WELDING END DETAILS INTENDED FOR USE OF GAS TUNGSTEN ARC ROOT PASS WELDING OF NOMINAL WALL THICKNESS OVER 0.38 in. (10 mm) TO 1 in. (25 mm) INCLUSIVE