

**Interpretation: IX-04-11**

Subject: QW-451.1, Procedure Qualification Thickness Limits and Test Specimens and  
QW-202.4, Dissimilar Base Metal Thicknesses

Date Issued: December 22, 2004

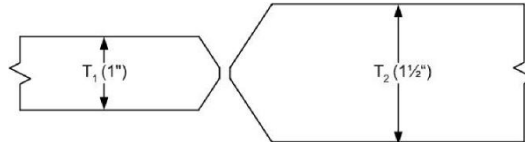
File No: 04-599

Background: A procedure qualification test coupon using the same P-Number material and consisting of two plates of different thicknesses are welded together, where the thicker of the two plates ( $T_2 = 1\text{-}1/2''$  thick) has been tapered on a 4:1 taper down to the thinner plate thickness ( $T_1 = 1''$  thick).

Question (1): Does this test coupon qualify the WPS for a base metal thickness range of  $3/16''$  to  $8''$ ?

Reply (1): See Interpretation IX-86-43, Question (2).

Background: A procedure qualification test coupon using the same or different P-Number materials and consisting of two plates of different thicknesses,  $T_2 = 1\text{-}1/2''$  thick and  $T_1 = 1''$  thick welded with a single process. The thicknesses meet on the same plane with neither plate being tapered. The joint is welded in accordance with the sketch below.



Question (2): Does this test coupon qualify the WPS for both base metals for a thickness range of  $3/16''$  to  $8''$  on both sides of the weld joint?

Reply (2): Yes.

Question (3): Does this test coupon qualify the WPS for both base metals of different P Numbers for a thickness range of  $3/16''$  to  $8''$ ?

Reply (3): No. QW-202.4 requires both base metal thicknesses be in accordance with QW-451.1. Base metal  $T_1$  is qualified  $3/16''$  to  $2''$  and base metal  $T_2$  is qualified  $3/16''$  to  $8''$ , except as permitted by QW-202.4(b)(1).