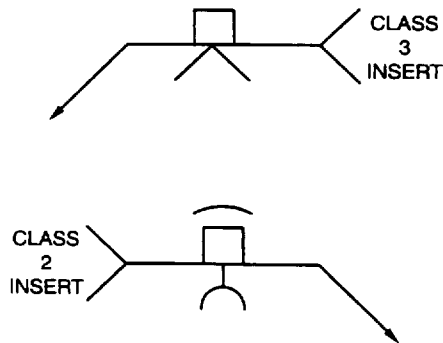


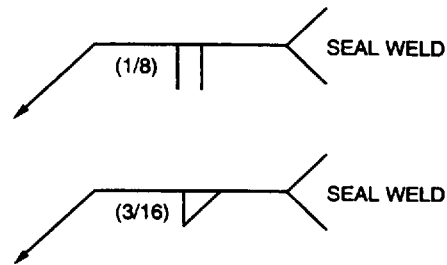
**4.10 Consumable Inserts.** Consumable inserts shall be specified by placing the consumable insert symbol on the side of the reference line opposite the groove weld symbol (see Figure 29). The AWS consumable insert class shall be placed in the tail of the welding symbol (for insert class see latest edition of ANSI/AWS A5.30, *Specification for Consumable Inserts*.)



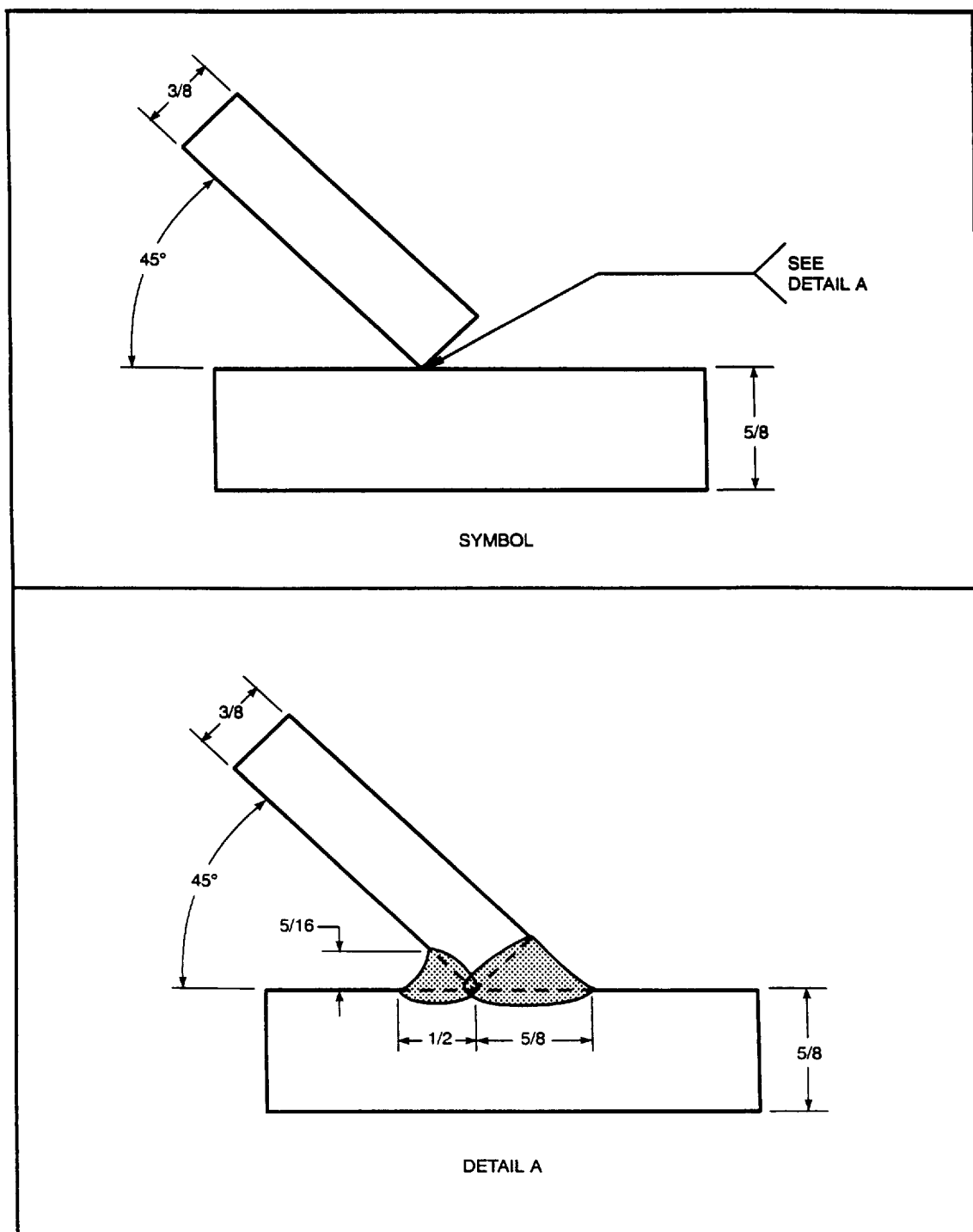
**4.11 Groove Welds with Backgouging.** A joint requiring complete joint penetration involving backgouging may be specified using either a single or multiple reference line welding symbol (see Figure 30). The welding symbol shall include a reference to backgouging in the tail and (1) in the case of asymmetrical double-groove welds must show the depth of bevel from each side [see

Figure 28(A)], together with groove angles and root opening, or (2) in the case of single-groove welds or symmetrical double-groove welds, need not include any other information except the weld symbols [see 4.2.2 and Figure 30(B) and (C)], with groove angles and root opening.

**4.12 Seal Welds.** When the intent of the weld is to fulfill a sealing function only, the weld shall be specified in the tail of the welding symbol as a seal weld (see Annex B4.10).



**4.13 Skewed Joints.** When the angle between the fusion faces is such that the identification of the weld type and, hence, proper weld symbol is in question, the detail of the desired joint and weld configuration shall be shown on the drawing with all necessary dimensions (see Figure 31).

**Figure 31—Skewed Joint**