

PJP

Joints **groove Welds**



Table 8-2 (continued)
Prequalified Welded Joints
Partial-Joint-Penetration Groove Welds

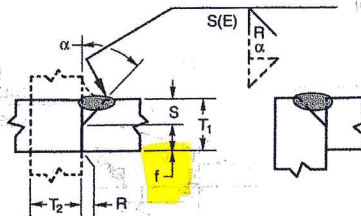
PJP

Single-bevel-groove weld (4)

Butt joint (B)

T-joint (T)

Corner joint (C)



Welding Process	Joint Designation	Base Metal Thickness (U = unlimited)	Root Opening Root Face Groove Angle	Tolerances	Allowed Welding Positions	Total Weld Size (E)	Notes
		T ₁	T ₂	As Detailed (see 3.12.3)	As Fit-Up (see 3.12.3)		
1/16	All	S ₁ + S ₂	5, 6, 9, 10				
1/16	All	S ₁ + S ₂	1, 6, 9, 10				
1/16	All	S ₁ + S ₂	6, 9, 10				

Welding Process	Joint Designation	Base Metal Thickness (U = unlimited)		Groove Preparation		Allowed Welding Positions	Total Weld Size (E)	Notes
		T ₁	T ₂	Root Opening Root Face Groove Angle	Tolerances			
SMAW	BTC-P4	U	U	R = 0 f = 1/8 min α = 45°	+1/16, -0 +U, -0 +10°, -0°	+1/8, -1/16 ±1/16 +10°, -5°	All S-1/8	2, 5, 6, 7, 10, 11
GMAW FCAW	BTC-P4-GF	1/4 min	U	R = 0 f = 1/8 min α = 45°	+1/16, -0 +U, -0 +10°, -0°	+1/8, -1/16 ±1/16 +10°, -5°	F, H V, OH S-1/8	1, 2, 6, 7, 10, 11
SAW	TC-P4-S	7/16 min	U	R = 0 f = 1/4 min α = 60°	±0 +U, -0 +10°, -0°	+1/16, -0 ±1/16 +10°, -5°	F S	2, 6, 7, 10, 11

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