

Joint		Joint Details -		
Backing :	1a) No & 2-N) YES	See Piping welding key form part. : 1-2 (only 111)-5-7-8-9 For fillet weld throat see details		
Backing material type:	1) No; 2-N) Weld metal			
Other:	None			
Base Metal		No welding shall be done if the ambient temperature is lower than – 5 °C.		
Gr.8.1	con/to Gr.8.1			
Type and grade :	ASTM A312 TP316L			*
Type and grade :	ASTM A312 TP316L/TP317L			*
Thickness groove (mm):	5,0 ÷ 45,0			
Thickness fillet (mm):	5,0 ÷ 45,0			
Outside diameter:	≥ 60,3			
Other	* same sub-group and any lower sub-group within same sub-group.			

Fillet weld joint details.

