Standard Welding Procedure Specification (SWPS) for

Gas Tungsten Arc Welding with Consumable Insert Root of Carbon Steel (M-1/P-1, Groups 1 or 2) to Austenitic Stainless Steel (M-8/P-8, Group 1), 1/16 through 1-1/2 inch Thick, IN309 and ER309(L), As-Welded Condition, Primarily Pipe Applications
Standard Welding Procedure Specification (SWPS) for Gas Tungsten Arc Welding with Consumable Insert Root of Carbon Steel (M-1/P-1, Groups 1 or 2) to Austenitic Stainless Steel (M-8/P-8, Group 1), 1/16 through 1-1/2 inch Thick, IN309 and ER309(L), As-Welded Condition, Primarily Pipe Applications

1st Edition

Prepared by the American Welding Society (AWS) B2 Committee on Procedure and Performance Qualification

Under the Direction of the AWS Technical Activities Committee

Approved by the AWS Board of Directors

Abstract

This standard contains the essential welding variables for welding carbon steel to austenitic stainless steel in the thickness range of 1/16 through 1-1/2 inch, using manual gas tungsten arc welding with consumable insert root. It cites the base metals and operating conditions necessary to make the weldment, the filler metal specifications, and the allowable joint designs for groove welds. This SWPS was developed primarily for pipe applications.
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AWS does not monitor, police, or enforce compliance with this standard, nor does it have the power to do so.

Official interpretations of any of the technical requirements of this standard may only be obtained by sending a request, in writing, to the appropriate technical committee. Such requests should be addressed to the American Welding Society, Attention: Managing Director, Technical Services Division, 8669 Doral Blvd., Suite 130, Doral, FL 33166 (see Annex A). With regard to technical inquiries made concerning AWS standards, oral opinions on AWS standards may be rendered. These opinions are offered solely as a convenience to users of this standard, and they do not constitute professional advice. Such opinions represent only the personal opinions of the particular individuals giving them. These individuals do not speak on behalf of AWS, nor do these oral opinions constitute official or unofficial opinions or interpretations of AWS. In addition, oral opinions are informal and should not be used as a substitute for an official interpretation.

This standard is subject to revision at any time by the AWS B2 Committee on Procedure and Performance Qualification. It must be reviewed every five years, and if not revised, it must be either reaffirmed or withdrawn. Comments (recommendations, additions, or deletions) and any pertinent data that may be of use in improving this standard are required and should be addressed to AWS Headquarters. Such comments will receive careful consideration by the AWS B2 Committee on Procedure and Performance Qualification and the author of the comments will be informed of the Committee’s response to the comments. Guests are invited to attend all meetings of the AWS B2 Committee on Procedure and Performance Qualification to express their comments verbally. Procedures for appeal of an adverse decision concerning all such comments are provided in the Rules of Operation of the Technical Activities Committee. A copy of these Rules can be obtained from the American Welding Society, 8669 Doral Blvd., Suite 130, Doral, FL 33166.
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Foreword

This foreword is not part of AWS B2.1-1/8-230:2002-AMD1, Standard Welding Procedure Specification (SWPS) for Gas Tungsten Arc Welding with Consumable Insert Root of Carbon Steel (M-1/P-1, Groups 1 or 2) to Austenitic Stainless Steel (M-8/P-8, Group 1), 1/16 through 1-1/2 inch Thick, IN309 and ER309(L), As-Welded Condition, Primarily Pipe Applications, but is included for informational purposes only.

The American Welding Society and the Welding Research Council have joined in a cooperative effort to generate standard welding procedures for industry. The need for pretested welding procedures that are supported by adequate test data and that satisfy the technical requirements for the commonly used construction codes and specifications has been expressed by many individuals and organizations. The purpose of a welding procedure qualification is to provide test data for assessing the properties of a weld joint.

This Standard Welding Procedure Specification is an outgrowth of the coordinated work of the Welding Procedures Committee of the Welding Research Council and the AWS B2 Committee on Welding Procedure and Performance Qualification. The Welding Procedures Committee has provided the test data documented by a Summary of Procedure Qualification Records.

The welding terms used in this specification shall be interpreted in accordance with the definitions given in the latest edition of AWS A3.0M/A3.0, Standard Welding Terms and Definitions. Welding symbols shall be those shown in the latest edition of AWS A2.4, Standard Symbols for Welding, Brazing, and Nondestructive Examination. The A5.32 designation for welding gases should be those shown in the latest edition of AWS A5.32/A5.32M, Specification for Welding Shielding Gases.

The AWS B2 Committee on Welding Procedure and Performance Qualification was formed in 1979 to provide welding standards concerning the subject of qualification. The primary document developed by this committee is AWS B2.1, Specification for Welding Procedure and Performance Qualification. This document established the foundation and framework for Standard Welding Procedure Specifications.

The first two Standard Welding Procedure Specifications were published in 1990. Since then SWPSs are continuing to be developed and published by the American Welding Society.

This SWPS has been amended to correct the list of Supporting PQR Numbers. Also, all references to ASME “S” material numbers have been deleted.

Comments and suggestions for the improvement of this standard are welcome. They should be sent to the Secretary, AWS B2 Committee on Procedure and Performance Qualification, American Welding Society, 8669 Doral Blvd., Suite 130, Doral, FL 33166.

Amendment

The following amendment was made to AWS B2.1-1/8-230:2002 and is incorporated in this reprint.

Page 1—Correct list of Supporting PQR Numbers by replacing “500506, 500510” with “500505, 500519.” Also delete Footnote 1 and renumber subsequent footnotes accordingly.

Supporting PQR Numbers: 200726, 200748, 500500, 500504, 500506, 500510, 500505, 500519, 500520, 500529, and 500550.
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Gas Tungsten Arc Welding, with Consumable Insert Root of Carbon Steel (M-1/P-1, Groups 1 or 2) to Austenitic Stainless Steel (M-8/P-8, Group 1), 1/16 through 1-1/2 inch Thick, IN309 and ER309(L), As-Welded Condition, Primarily Pipe Applications

Welding Research Council—Supporting PQR Numbers: 200726, 200748, 500500, 500504, 500505, 500519, 500520, 500529, and 500550

Requirements for Application of SWPS

Scope. The data to support this Standard Welding Procedure Specification (SWPS) have been derived from the above listed Procedure Qualification Records (PQRs) which were reviewed and validated under the auspices of the Welding Research Council. This SWPS is not valid using conditions and variables outside the ranges listed. The American Welding Society considers that this SWPS presents information for producing an acceptable weld using the conditions and variables listed. The user needs a significant knowledge of welding and accepts full responsibility for the performance of the weld and for providing the engineering capability, qualified personnel, and proper equipment to implement this SWPS.

Application. This SWPS is to be used only as permitted by the applicable fabrication document(s) [such as code, specification, or contract document(s)]. The fabrication document(s) should specify the engineering requirements such as design, need for heat treatment, fabricating tolerances, quality control, and examination and tests applicable to the end product.

User’s Responsibility. An SWPS does not replace or substitute for fabrication codes, specifications, contract requirements, or capability and judgment on the part of the user. An SWPS is to be used only as permitted by the applicable fabrication code, specification, or contract document.

The ability to produce production welds having properties suitable for the application depends upon supplementing the SWPS with appropriate performance qualification tests and sound engineering judgment. The user is responsible for the quality and performance of the final product in accordance with the provisions of the fabrication document(s).

Supplementary Instructions. To adapt this SWPS to a specific application, a user may issue supplementary instructions. Such instructions may consist of tighter fit-up tolerances, higher minimum preheat temperature, or any other instructions necessary to produce a weldment that meets the requirements of the fabrication document(s). These instructions shall not be less restrictive than provided in the SWPS.


This specification may involve hazardous materials, operations, and equipment. The specification does not purport to address all of the safety problems associated with its use. It is the responsibility of the user to establish appropriate safety and health practices. The user should determine the applicability of any regulatory limitations prior to use.