Railroad Welding Specification—Cars and Locomotives
Abstract

This specification establishes minimum standards for the manufacture and maintenance of railroad equipment. Part I covers the general requirements for welding in the railroad industry. Part II covers specific requirements for the welding of base metals thinner than 1/8 in. (3.2 mm).
Table of Contents

Personnel .................................................................................................................................................................. iii
Foreword .................................................................................................................................................................. vii
List of Tables ........................................................................................................................................................ xiv
List of Metric Tables .......................................................................................................................................... xv
List of Figures .......................................................................................................................................................... xvi
List of Metric Figures .......................................................................................................................................... xviii

Part I. Requirements for All Welding ....................................................................................................................... 1

Section A—General Requirements ........................................................................................................................... 1
1. Scope ..................................................................................................................................................................... 1
2. Applicable Documents ....................................................................................................................................... 2
3. Base Metals .......................................................................................................................................................... 3
4. Definitions ............................................................................................................................................................ 3
5. Welding Symbols ............................................................................................................................................... 3
6. Safety Precautions .......................................................................................................................................... 3
7. Standard Units of Measurement .......................................................................................................................... 3

Section B—Requirements for All Welding .............................................................................................................. 3
8. Processes ............................................................................................................................................................. 3
9. Welding Procedure Qualification ........................................................................................................................ 3
10. Qualification of Welders and Welding Operators ............................................................................................ 4
11. Design of Welded Joints .................................................................................................................................... 4
   11.1 Drawings and Welding Procedure Specifications .......................................................................................... 4
   11.2 Effective Weld Areas, Lengths, and Sizes .................................................................................................. 4
   11.3 Fillers ........................................................................................................................................................... 5
   11.4 Details of Fillet Welds ................................................................................................................................... 6
   11.5 Intermittent Fillet Welds .............................................................................................................................. 6
   11.6 Lap Joints ..................................................................................................................................................... 6
   11.7 Mechanical Fasteners .................................................................................................................................. 6
   11.8 Design Considerations ................................................................................................................................ 6
12. Consumables ........................................................................................................................................................ 11
   12.1 Condition ..................................................................................................................................................... 11
   12.2 Certification .................................................................................................................................................. 11
   12.3 Flux for Submerged Arc Welding ................................................................................................................. 11
   12.4 Conformance ............................................................................................................................................... 13
   12.5 Shielding Gas .............................................................................................................................................. 13
   12.6 Covered Electrodes (Low Hydrogen) ........................................................................................................... 13
13. Technique and Workmanship .............................................................................................................................. 14
   13.1 General......................................................................................................................................................... 14
   13.2 Preparation of Base Metal .......................................................................................................................... 14
13.3 Steel and Aluminum Assembly Criteria ................................. 16
13.4 Weld Profiles ........................................................................ 17
13.5 Repairs ............................................................................. 17
13.6 Arc Strikes ........................................................................ 20
13.7 Cleaning and Protective Coatings ........................................ 20
13.8 Weld Termination ................................................................. 20
13.9 Groove Weld Backing .......................................................... 21
13.10 Heat Input Control for Quenched and Tempered Steel .......... 21
13.11 Stress Relief Heat Treatment .............................................. 21
13.12 Peening .......................................................................... 21
13.13 Workmanship for Stud Arc Welding (SW) ......................... 21
13.14 Grounding ....................................................................... 22
13.15 Welding Air Brake Pipe ..................................................... 22

Section C—Prequalification of Welding Procedures .......................... 22
14. Joint Design Details .............................................................. 22
14.1 Groove Weld Size (Effective Weld Size) .............................. 22
14.2 Joint Designs ..................................................................... 22
14.3 Fillet Welds ........................................................................ 22
14.4 Details of Plug and Slot Welds ............................................ 23
14.5 Complete Joint Penetration Groove Welds ......................... 23
14.6 Partial Joint Penetration Groove Welds ................................. 23

15. Technique ........................................................................... 47
15.1 Base Metal, Filler Metal, and Related Metal Requirements .... 47
15.2 Preheat, Interpass, and Postweld Heat Treatment (PWHT) Requirements ........................................ 47
15.3 Shielded Metal Arc Welding (SMAW) ................................. 47
15.4 Submerged Arc Welding (SAW) ......................................... 54
15.5 Gas Metal Arc and Flux Cored Arc Welding (GMAW and FCAW) .................................................... 56
15.6 Plug and Slot Welds ........................................................... 57

Section D—Qualification ............................................................ 57
16. General Requirements .......................................................... 57
16.1 Prequalified Procedures ....................................................... 57
16.2 Qualified Procedures .......................................................... 57
16.3 Welders, Welding Operators, and Tack Welders ................ 58
16.4 Qualification Responsibility ................................................ 58

17. Procedure Qualification ......................................................... 58
17.1 Limitation of Essential Variables ........................................ 62
17.2 Types of Tests and Purposes .............................................. 62
17.3 Base Metal and Its Preparation ......................................... 63
17.4 Position of Test Welds ........................................................ 63
17.5 Joint Welding Procedure .................................................. 66
17.6 Test Specimens: Number, Type, and Preparation ............... 66
17.7 Special Test Conditions .................................................... 78
17.8 Method of Testing Specimens .......................................... 78
17.9 Test Results Required ..................................................... 80
17.10 Records ......................................................................... 83
17.11 Retests .......................................................................... 83

18. Welder Qualification ............................................................ 83
18.1 General .......................................................................... 83
18.2 Limitation of Variables .................................................... 83
18.3 Qualification Tests Required ............................................ 85
18.4 Groove Weld Plate Qualification Test for Plate ................ 86
23. Ultrasonic Testing of Groove Welds (Steel Welds Only) ................................................................. 107
   23.1 General ........................................................................................................................................ 108
   23.2 Extent of Testing ......................................................................................................................... 108
   23.3 Ultrasonic Equipment .............................................................................................................. 108
   23.4 Reference Standards ............................................................................................................... 109
   23.5 Equipment Qualification ........................................................................................................ 114
   23.6 Calibration for Testing ............................................................................................................ 114
   23.7 Testing Procedures .................................................................................................................. 114
   23.8 Preparation and Disposition of Reports .................................................................................. 118
   23.9 Calibration of the Ultrasonic Unit with the IIW or Other Approved Reference Blocks ......... 118
   23.10 Equipment Qualification Procedures .................................................................................. 119
   23.11 Flaw Size Evaluation Procedures ...................................................................................... 120
   23.12 Scanning Patterns ................................................................................................................ 121
   23.13 Flaw Size Evaluation ........................................................................................................... 121

24. Acceptance Criteria ........................................................................................................................ 121
   24.1 Temporary Welds .................................................................................................................... 121
   24.2 Visual Inspection Acceptance Criteria .................................................................................. 121
   24.3 Radiographic Inspection Acceptance Criteria ..................................................................... 121
   24.4 Ultrasonic Inspection Acceptance Criteria (Steel Welds Only) ......................................... 122
   24.5 Liquid Penetrant Inspection Acceptance Criteria ................................................................. 122
   24.6 Magnetic Particle Inspection Acceptance Criteria ............................................................... 122

Part II. Requirements for Welding Sheet Metal ................................................................................. 125

25. Design of Welded Joints ............................................................................................................... 125
   25.1 General ....................................................................................................................................... 125
   25.2 Square Grooves ....................................................................................................................... 125
   25.3 Arc Spot Welds ......................................................................................................................... 125
   25.4 Single-Flare-Bevel-Groove Welds ......................................................................................... 125
   25.5 Plug and Slot Welds .............................................................................................................. 125
   25.6 Fillers ........................................................................................................................................ 125

26. Joint and Procedure Qualification .............................................................................................. 127
   26.1 Carbon, Low Alloy, or Stainless Steel Base Metal .............................................................. 127
   26.2 Aluminum and Aluminum Alloys ......................................................................................... 134

27. Welder, Welding Operator, and Tack Welder Qualification—Carbon, Low Alloy, and Stainless Steel
   Base Metals ...................................................................................................................................... 136
   27.1 General ...................................................................................................................................... 136
   27.2 Limitation of Variables ........................................................................................................ 136
   27.3 Retests ...................................................................................................................................... 138
   27.4 Period of Effectiveness ......................................................................................................... 138

28. Welder Qualification—Aluminum and Aluminum Alloy Base Metals ........................................... 138
   28.1 Record of Tests ..................................................................................................................... 138
   28.2 Limits of Qualified Positions—Performance Qualification ................................................ 138
   28.3 Preparation of Test Weldments—Performance Qualification ............................................. 138
   28.4 Limitation of Variables—Welder Performance Qualification ............................................. 138
   28.5 Limitation of Variables—Welding Operator Performance Qualification ......................... 139
   28.6 Limitation of Variables—Tack Welder Performance Qualification ..................................... 139
   28.7 Acceptance Criteria—Welder, Welding Operator, and Tack Welder Qualification .......... 139
   28.8 Retests .................................................................................................................................... 139
   28.9 Period of Effectiveness ......................................................................................................... 139
Section G—Workmanship Technique ........................................................................................................................139
29. Technique and Workmanship ............................................................................................................................139

Section H—Verification Inspection ............................................................................................................................140
30. Inspection of Welding Procedure Qualification and Equipment ........................................................................140

Section I—Weld Details/Weld Quality ......................................................................................................................140
31. Weld Details ......................................................................................................................................................140
     31.1 Groove Welds (Butt Joints) ..........................................................................................140
     31.2 Fillet Welds .........................................................................................................................140
32. Weld Quality—Visual Inspection Acceptance Criteria .........................................................................................140

Annexes—Nonmandatory Information
Annex A—Base Metal Groupings ......................................................................................................................141
Annex B—Filler Metal Classifications ..................................................................................................................219
Annex C—Effective Weld Size—Special Cases .................................................................................................223
Annex D—Sample Report Forms .......................................................................................................................225
Annex E—Glossary .............................................................................................................................................251
Annex F—Safety Considerations ........................................................................................................................253
Annex G—Gage Thickness of Sheet Metal and Aluminum Filler Alloy Selection Guide ....................................255
Annex H—Metric Tables and Figures ..................................................................................................................259
Annex I—Macroetch Procedures ..........................................................................................................................355
Annex J—Guidelines for Preparation of Technical Inquires for AWS Technical Committees ................................357
Index ........................................................................................................................................................................359
List of Tables

<table>
<thead>
<tr>
<th>Table</th>
<th>Description</th>
<th>Page No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>B1</td>
<td>Minimum Weld Size for Partial Joint Penetration Groove Welds</td>
<td>4</td>
</tr>
<tr>
<td>B2</td>
<td>Allowable Weld Stresses (Steel)</td>
<td>9</td>
</tr>
<tr>
<td>B3</td>
<td>Allowable Weld Stresses (Aluminum)</td>
<td>10</td>
</tr>
<tr>
<td>B4</td>
<td>Minimum Mechanical Properties for Welded Aluminum Alloys (GTAW or GMAW)</td>
<td>11</td>
</tr>
<tr>
<td>B5</td>
<td>Minimum Mechanical Properties for Non-Welded Aluminum Alloys</td>
<td>12</td>
</tr>
<tr>
<td>B6</td>
<td>Permissible Atmospheric Exposure of Low Hydrogen Electrodes</td>
<td>13</td>
</tr>
<tr>
<td>B7</td>
<td>Limits on Acceptability and Repair of Cut Edge Discontinuities</td>
<td>15</td>
</tr>
<tr>
<td>B8</td>
<td>Joint Dimension Tolerances</td>
<td>16</td>
</tr>
<tr>
<td>B9</td>
<td>Maximum Heat Exposure Time at Temperature Preparatory to Forming or Welding</td>
<td>19</td>
</tr>
<tr>
<td>C1</td>
<td>Weld Size of Flare Groove Welds</td>
<td>22</td>
</tr>
<tr>
<td>C2</td>
<td>Minimum Fillet Weld Size</td>
<td>23</td>
</tr>
<tr>
<td>C3</td>
<td>Legend for Figures C1A–C1L and C2A–C2J</td>
<td>24</td>
</tr>
<tr>
<td>C4</td>
<td>Prequalified Base Metal–Filler Metal Combinations for Matching Strength</td>
<td>48</td>
</tr>
<tr>
<td>C5</td>
<td>Prequalified Minimum Preheat and Interpass Temperature (Steel)</td>
<td>52</td>
</tr>
<tr>
<td>D1</td>
<td>Procedure Qualification—Number and Type of Specimens and Range of Thickness Qua</td>
<td>68</td>
</tr>
<tr>
<td>D2</td>
<td>Procedure Qualification—Number and Type of Specimens and Range of Thickness Qua</td>
<td>75</td>
</tr>
<tr>
<td>D3</td>
<td>Procedure Qualification—Number and Type of Specimens and Range of Thickness Qua</td>
<td>75</td>
</tr>
<tr>
<td>D4</td>
<td>Procedure Qualification Type and Position Limitations</td>
<td>79</td>
</tr>
<tr>
<td>D5</td>
<td>As-Welded Strength of Aluminum Alloys (GTAW or GMAW)</td>
<td>81</td>
</tr>
<tr>
<td>D6</td>
<td>Electrode Classification Groups for Welder and Tack Welder Qualification</td>
<td>83</td>
</tr>
<tr>
<td>D7</td>
<td>Number and Type of Specimens and Range of Thickness Welder and Welding Operator Qualification</td>
<td>84</td>
</tr>
<tr>
<td>D8</td>
<td>Welder and Welding Operator Qualification—Type and Position Limitations</td>
<td>85</td>
</tr>
<tr>
<td>D9</td>
<td>Maximum Reinforcement—Pipe Welds</td>
<td>85</td>
</tr>
<tr>
<td>E1</td>
<td>Penetrator Requirements</td>
<td>102</td>
</tr>
<tr>
<td>E2</td>
<td>Ultrasonic Testing Angle</td>
<td>115</td>
</tr>
<tr>
<td>E3</td>
<td>Undercut and Porosity Tolerances</td>
<td>122</td>
</tr>
<tr>
<td>E4</td>
<td>Ultrasonic Testing Acceptance-Rejection Criteria</td>
<td>123</td>
</tr>
<tr>
<td>F1</td>
<td>Procedure Qualification Tests</td>
<td>128</td>
</tr>
<tr>
<td>F2</td>
<td>Welder Qualification Tests</td>
<td>137</td>
</tr>
<tr>
<td>AA1</td>
<td>Numerical Indexing of Base Metal Specifications (Steels)</td>
<td>142</td>
</tr>
<tr>
<td>AA2</td>
<td>Numerical Indexing of Base Metal Specifications (Aluminum)</td>
<td>169</td>
</tr>
<tr>
<td>AA3</td>
<td>Grouping of Steels and Other Iron Base Alloys for Qualification</td>
<td>173</td>
</tr>
<tr>
<td>AA4</td>
<td>Aluminum and Aluminum Alloys</td>
<td>213</td>
</tr>
<tr>
<td>AB1</td>
<td>Grouping of Welding Electrodes and Rods for Qualification</td>
<td>220</td>
</tr>
<tr>
<td>AC1</td>
<td>Equivalent Fillet Weld Leg Size Factors for Skewed T-Joints</td>
<td>224</td>
</tr>
<tr>
<td>AG1</td>
<td>Hot-Rolled and Cold-Rolled Sheet Metal</td>
<td>256</td>
</tr>
<tr>
<td>AG2</td>
<td>Galvanized Sheet Metal</td>
<td>256</td>
</tr>
<tr>
<td>AG3</td>
<td>Guide to the Choice of Filler Metal for General Purpose Welding of Aluminum</td>
<td>257</td>
</tr>
</tbody>
</table>
# List of Metric Tables

<table>
<thead>
<tr>
<th>Table</th>
<th>Description</th>
<th>Page No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>B1M</td>
<td>Minimum Weld Size for Partial Joint Penetration Groove Welds</td>
<td>260</td>
</tr>
<tr>
<td>B2M</td>
<td>Allowable Weld Stresses (Steel)</td>
<td>260</td>
</tr>
<tr>
<td>B3M</td>
<td>Weld Stresses (Aluminum)</td>
<td>261</td>
</tr>
<tr>
<td>B4M</td>
<td>Minimum Mechanical Properties for Welded Aluminum Alloys (Gas Tungsten Arc or Gas Metal Arc Welding with No Postweld Heat Treatment)</td>
<td>262</td>
</tr>
<tr>
<td>B5M</td>
<td>Minimum Mechanical Properties for Non-Welded Aluminum Alloys</td>
<td>263</td>
</tr>
<tr>
<td>B7M</td>
<td>Limits on Acceptability and Repair of Cut Edge Discontinuities</td>
<td>264</td>
</tr>
<tr>
<td>B8M</td>
<td>Joint Dimension Tolerances</td>
<td>264</td>
</tr>
<tr>
<td>B9M</td>
<td>Maximum Heat Exposure Time at Temperature Preparatory to Forming or Welding Aluminum</td>
<td>265</td>
</tr>
<tr>
<td>C2M</td>
<td>Minimum Fillet Weld Size for Prequalified Joints</td>
<td>265</td>
</tr>
<tr>
<td>C4M</td>
<td>Prequalified Base Metal–Filter Metal Combinations for Matching Strength</td>
<td>266</td>
</tr>
<tr>
<td>C5M</td>
<td>Prequalified Minimum Preheat and Interpass Temperature (Steel)</td>
<td>270</td>
</tr>
<tr>
<td>D1M</td>
<td>Procedure Qualification—Number and Type of Specimens and Range of Thickness Qualified—Complete Joint Penetration Groove Weld</td>
<td>272</td>
</tr>
<tr>
<td>D2M</td>
<td>Procedure Qualification—Number and Type of Specimens and Range of Thickness Qualified—Partial Joint Penetration Groove Weld</td>
<td>273</td>
</tr>
<tr>
<td>D5M</td>
<td>As-Welded Strength of Aluminum Alloys (GTAW or GMAW)</td>
<td>274</td>
</tr>
<tr>
<td>D7M</td>
<td>Number and Type of Specimens and Range of Thickness Qualified-Welder and Welding Operator Qualification</td>
<td>276</td>
</tr>
<tr>
<td>E1M</td>
<td>Penetrameter Requirements</td>
<td>277</td>
</tr>
<tr>
<td>E2M</td>
<td>Ultrasonic Testing Angle</td>
<td>278</td>
</tr>
<tr>
<td>E3M</td>
<td>Undercut and Porosity Tolerances</td>
<td>279</td>
</tr>
<tr>
<td>E4M</td>
<td>Ultrasonic Testing Acceptance-Rejection Criteria</td>
<td>280</td>
</tr>
<tr>
<td>AA3M</td>
<td>Grouping of Steels and Other Iron Base Alloys for Qualification</td>
<td>281</td>
</tr>
</tbody>
</table>
List of Figures

<table>
<thead>
<tr>
<th>Figure</th>
<th>Description</th>
<th>Page No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>B1</td>
<td>Fillers Less than 1/4 in. Thick</td>
<td>6</td>
</tr>
<tr>
<td>B2</td>
<td>Fillers 1/4 in. or Thicker</td>
<td>7</td>
</tr>
<tr>
<td>B3</td>
<td>Details for Fillet Welds</td>
<td>8</td>
</tr>
<tr>
<td>B4</td>
<td>Distribution of Mechanical Properties in the Vicinity of an Aluminum Weld</td>
<td>10</td>
</tr>
<tr>
<td>B5</td>
<td>Cut Edge Discontinuity</td>
<td>15</td>
</tr>
<tr>
<td>B6</td>
<td>Acceptable and Unacceptable Weld Profiles</td>
<td>18</td>
</tr>
<tr>
<td>C1A</td>
<td>Prequalified Complete Joint Penetration Groove (CJP) Groove Welded Joint Details</td>
<td>25</td>
</tr>
<tr>
<td>C1B</td>
<td>Prequalified Complete Joint Penetration Groove (CJP) Groove Welded Joint Details</td>
<td>26</td>
</tr>
<tr>
<td>C1C</td>
<td>Prequalified Complete Joint Penetration Groove (CJP) Groove Welded Joint Details</td>
<td>27</td>
</tr>
<tr>
<td>C1D</td>
<td>Prequalified Complete Joint Penetration Groove (CJP) Groove Welded Joint Details</td>
<td>28</td>
</tr>
<tr>
<td>C1E</td>
<td>Prequalified Complete Joint Penetration Groove (CJP) Groove Welded Joint Details</td>
<td>29</td>
</tr>
<tr>
<td>C1F</td>
<td>Prequalified Complete Joint Penetration Groove (CJP) Groove Welded Joint Details</td>
<td>30</td>
</tr>
<tr>
<td>C1G</td>
<td>Prequalified Complete Joint Penetration Groove (CJP) Groove Welded Joint Details</td>
<td>31</td>
</tr>
<tr>
<td>C1H</td>
<td>Prequalified Complete Joint Penetration Groove (CJP) Groove Welded Joint Details</td>
<td>32</td>
</tr>
<tr>
<td>C1I</td>
<td>Prequalified Complete Joint Penetration Groove (CJP) Groove Welded Joint Details</td>
<td>33</td>
</tr>
<tr>
<td>C1J</td>
<td>Prequalified Complete Joint Penetration Groove (CJP) Groove Welded Joint Details</td>
<td>34</td>
</tr>
<tr>
<td>C1K</td>
<td>Prequalified Complete Joint Penetration Groove (CJP) Groove Welded Joint Details</td>
<td>35</td>
</tr>
<tr>
<td>C1L</td>
<td>Prequalified Complete Joint Penetration Groove (CJP) Groove Welded Joint Details</td>
<td>36</td>
</tr>
<tr>
<td>C2A</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Weld Joint Details</td>
<td>37</td>
</tr>
<tr>
<td>C2B</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Weld Joint Details</td>
<td>38</td>
</tr>
<tr>
<td>C2C</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Weld Joint Details</td>
<td>39</td>
</tr>
<tr>
<td>C2D</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Weld Joint Details</td>
<td>40</td>
</tr>
<tr>
<td>C2E</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Weld Joint Details</td>
<td>41</td>
</tr>
<tr>
<td>C2F</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Weld Joint Details</td>
<td>42</td>
</tr>
<tr>
<td>C2G</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Weld Joint Details</td>
<td>43</td>
</tr>
<tr>
<td>C2H</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Weld Joint Details</td>
<td>44</td>
</tr>
<tr>
<td>C2I</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Weld Joint Details</td>
<td>45</td>
</tr>
<tr>
<td>C2J</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Weld Joint Details</td>
<td>46</td>
</tr>
<tr>
<td>C3</td>
<td>Weld Pass in Which Depth and Width Exceed the Width of the Weld Face</td>
<td>54</td>
</tr>
<tr>
<td>D1</td>
<td>Positions of Groove Welds</td>
<td>60</td>
</tr>
<tr>
<td>D2</td>
<td>Positions of Fillet Welds</td>
<td>61</td>
</tr>
<tr>
<td>D3</td>
<td>Positions of Test Plates for Groove Welds</td>
<td>64</td>
</tr>
<tr>
<td>D4</td>
<td>Positions of Test Pipe or Tubing for Groove Welds</td>
<td>65</td>
</tr>
<tr>
<td>D5</td>
<td>Test Positions for Fillet Welds (for Plate)</td>
<td>66</td>
</tr>
<tr>
<td>D6</td>
<td>Test Positions for Fillet Welds (for Pipe and Tubing)</td>
<td>67</td>
</tr>
<tr>
<td>D7</td>
<td>Location of Test Specimens on Welded Test Pipe</td>
<td>69</td>
</tr>
<tr>
<td>D8</td>
<td>Location of Test Specimens for Welded Square and Rectangular Tubing</td>
<td>69</td>
</tr>
<tr>
<td>D9</td>
<td>Location of Test Specimens on Welded Test Plate for 1/8 to 3/8 in. (inclusive) Thick Procedure Qualification</td>
<td>70</td>
</tr>
<tr>
<td>D10</td>
<td>Location of Test Specimens on Welded Test Plate 3/8 in. Thick and Over Procedure Qualification</td>
<td>71</td>
</tr>
<tr>
<td>D11</td>
<td>Reduced-Section Tension Specimen</td>
<td>72</td>
</tr>
<tr>
<td>D12</td>
<td>All-Weld-Metal Tension Specimen</td>
<td>73</td>
</tr>
<tr>
<td>D13</td>
<td>Side-Bend Specimens</td>
<td>73</td>
</tr>
<tr>
<td>D14</td>
<td>Face-and Root-Bend Specimens</td>
<td>74</td>
</tr>
<tr>
<td>D15</td>
<td>Fillet Weld Soundness Test for Procedure Qualification</td>
<td>76</td>
</tr>
</tbody>
</table>
D33 Method of Rupturing Specimen

D31 Test Plate for Unlimited Thickness

D29 Guided-Bend Wraparound Jig

D28 Guided-Bend Jig

D27 Location of Test Specimens on Welded Test Pipe and Square or Rectangular Tubing

D26 Fillet Weld on Pipe

D25 Fillet Weld Root-Bend Test Plate Welder and Welding Operator Qualification

D24 Fillet-Weld-Break and Macroetch Test Plate Welder and Welding Operator Qualification

D23 Tubular Butt Joint—Welder Qualification with Backing

D22 Tubular Butt Joint—Welder Qualification Without Backing

D21 Test Plate for Limited Thickness Horizontal Position—Welder Qualification

D20 Test Plate for Limited Thickness—Welder Qualification

D19 Test Plate for Unlimited Thickness Horizontal Position—Welder Qualification

D18 Test Plate for Unlimited Thickness Welder Qualification

D17 Pipe Fillet Weld Soundness Test Procedure Qualification

D16 Location of Test Specimens on Welded Test Plate 1 in. Thick—Consumables Verification for Fillet Weld Procedure Qualification

D15 F16 Flare-Groove Weld Qualification

D14 F15 Standard Test Assembly for Flare-V-Groove Welds

D13 F14 Standard Test Assembly for Flare-Bevel-Groove Weld; Test C—Sheet-to-Sheet

D12 F13 Standard Test Assembly for Flare-Bevel-Groove Weld; Test C—Sheet-to-Supporting Plate

D11 F12 Standard Test Assembly for Flare-V-Groove Welds

D10 F11 Fillet Weld Test Assembly

D9 F10 Test for Arc Spot Weld

D8 F9 Square-Groove Butt Joints

D7 F8 Single-Flare-V-Groove Weld—Flat

D6 F7 Single-Flare-Bevel-Groove Weld—Horizontal

D5 F6 Fillet Welds in T-Joints

D4 F5 Lap-Fillet Welds

D3 F4 Edge Distances for Arc Spot Welds

D2 F3 Arc Spot Weld Using Washer

D1 F2 Arc Spot Welds

E11 F1 Square-Groove Weld in Butt Joint

E10 E10 Transducer Positions (Typical)

E9 E9 Other Reference Blocks

E8 E8 International Institute of Welding (IIW) Ultrasonic Reference Blocks

E7 E7 Qualification Procedure of Search Unit Using IIW Reference Block

E6 E6 Transducer Crystal

E5 E5 Penetrameter Design

E4 E4 Radiographic Identification and Penetrameter Locations on Transition Joints Less than 10 in. in Length

E3 E3 Radiographic Identification and Penetrameter Locations on Transition Joints 10 in. and Greater in Length

E2 E2 Radiographic Identification and Penetrameter Locations on Approximately Equal Thickness Joints

E1 E1 Plan View of Welded Plate

D18 D18 Test Plate for Unlimited Thickness Welder Qualification

D17 D17 Pipe Fillet Weld Soundness Test Procedure Qualification

D16 D16 Location of Test Specimens on Welded Test Plate 1 in. Thick—Consumables Verification for Fillet Weld Procedure Qualification

D15 D15 F16 Flare-Groove Weld Qualification

D14 D14 F15 Standard Test Assembly for Flare-V-Groove Welds

D13 D13 F14 Standard Test Assembly for Flare-Bevel-Groove Weld; Test C—Sheet-to-Sheet

D12 D12 F13 Standard Test Assembly for Flare-Bevel-Groove Weld; Test C—Sheet-to-Supporting Plate

D11 D11 F12 Standard Test Assembly for Flare-V-Groove Welds

D10 D10 F11 Fillet Weld Test Assembly

D9 D9 F10 Test for Arc Spot Weld

D8 D8 F9 Square-Groove Butt Joints

D7 D7 F8 Single-Flare-V-Groove Weld—Flat

D6 D6 F7 Single-Flare-Bevel-Groove Weld—Horizontal

D5 D5 F6 Fillet Welds in T-Joints

D4 D4 F5 Lap-Fillet Welds

D3 D3 F4 Edge Distances for Arc Spot Welds

D2 D2 F3 Arc Spot Weld Using Washer

D1 D1 F2 Arc Spot Welds

E11 E11 Plan View of Welded Plate

E10 E10 Transducer Positions (Typical)

E9 E9 Other Reference Blocks

E8 E8 International Institute of Welding (IIW) Ultrasonic Reference Blocks

E7 E7 Qualification Procedure of Search Unit Using IIW Reference Block

E6 E6 Transducer Crystal

E5 E5 Penetrameter Design

E4 E4 Radiographic Identification and Penetrameter Locations on Transition Joints Less than 10 in. in Length

E3 E3 Radiographic Identification and Penetrameter Locations on Transition Joints 10 in. and Greater in Length

E2 E2 Radiographic Identification and Penetrameter Locations on Approximately Equal Thickness Joints

E1 E1 Plan View of Welded Plate
List of Metric Figures

<table>
<thead>
<tr>
<th>Figure</th>
<th>Description</th>
<th>Page No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>B1M</td>
<td>Filler Less than 6.4 mm Thick</td>
<td>299</td>
</tr>
<tr>
<td>B2M</td>
<td>Fillers 6.4 mm or Thicker</td>
<td>300</td>
</tr>
<tr>
<td>B4M</td>
<td>Distribution of Mechanical Properties in the Vicinity of an Aluminum Weld</td>
<td>301</td>
</tr>
<tr>
<td>C1AM</td>
<td>Prequalified Complete Joint Penetration (CJP) Groove Welded Joint Details</td>
<td>302</td>
</tr>
<tr>
<td>C1BM</td>
<td>Prequalified Complete Joint Penetration (CJP) Groove Welded Joint Details</td>
<td>303</td>
</tr>
<tr>
<td>C1CM</td>
<td>Prequalified Complete Joint Penetration (CJP) Groove Welded Joint Details</td>
<td>304</td>
</tr>
<tr>
<td>C1DM</td>
<td>Prequalified Complete Joint Penetration (CJP) Groove Welded Joint Details</td>
<td>305</td>
</tr>
<tr>
<td>C1EM</td>
<td>Prequalified Complete Joint Penetration (CJP) Groove Welded Joint Details</td>
<td>306</td>
</tr>
<tr>
<td>C1FM</td>
<td>Prequalified Complete Joint Penetration (CJP) Groove Welded Joint Details</td>
<td>307</td>
</tr>
<tr>
<td>C1GM</td>
<td>Prequalified Complete Joint Penetration (CJP) Groove Welded Joint Details</td>
<td>308</td>
</tr>
<tr>
<td>C1HM</td>
<td>Prequalified Complete Joint Penetration (CJP) Groove Welded Joint Details</td>
<td>309</td>
</tr>
<tr>
<td>C1IM</td>
<td>Prequalified Complete Joint Penetration (CJP) Groove Welded Joint Details</td>
<td>310</td>
</tr>
<tr>
<td>C1JM</td>
<td>Prequalified Complete Joint Penetration (CJP) Groove Welded Joint Details</td>
<td>311</td>
</tr>
<tr>
<td>C1KM</td>
<td>Prequalified Complete Joint Penetration (CJP) Groove Welded Joint Details</td>
<td>312</td>
</tr>
<tr>
<td>C1LM</td>
<td>Prequalified Complete Joint Penetration (CJP) Groove Welded Joint Details</td>
<td>313</td>
</tr>
<tr>
<td>C2AM</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Welded Joint Details</td>
<td>314</td>
</tr>
<tr>
<td>C2BM</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Welded Joint Details</td>
<td>315</td>
</tr>
<tr>
<td>C2CM</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Welded Joint Details</td>
<td>316</td>
</tr>
<tr>
<td>C2DM</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Welded Joint Details</td>
<td>317</td>
</tr>
<tr>
<td>C2EM</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Welded Joint Details</td>
<td>318</td>
</tr>
<tr>
<td>C2FM</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Welded Joint Details</td>
<td>319</td>
</tr>
<tr>
<td>C2GM</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Welded Joint Details</td>
<td>320</td>
</tr>
<tr>
<td>C2HM</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Welded Joint Details</td>
<td>321</td>
</tr>
<tr>
<td>C2IM</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Welded Joint Details</td>
<td>322</td>
</tr>
<tr>
<td>C2JM</td>
<td>Prequalified Partial Joint Penetration (PJP) Groove Welded Joint Details</td>
<td>323</td>
</tr>
<tr>
<td>D7M</td>
<td>Location of Test Specimens on Welded Test Pipe</td>
<td>324</td>
</tr>
<tr>
<td>D9M</td>
<td>Location of Test Specimens on Welded Test Plate for 3.2 to 9.5 mm (inclusive) Thick Procedure Qualification</td>
<td>325</td>
</tr>
<tr>
<td>D10M</td>
<td>Location of Test Specimens on Welded Test Plate Over 9.5 mm Thick Procedure Qualification</td>
<td>326</td>
</tr>
<tr>
<td>D11M</td>
<td>Reduced-Section Tension Specimen</td>
<td>327</td>
</tr>
<tr>
<td>D12M</td>
<td>All-Weld-Metal Tension Specimen</td>
<td>328</td>
</tr>
<tr>
<td>D13M</td>
<td>Side-Bend Specimen</td>
<td>328</td>
</tr>
<tr>
<td>D14M</td>
<td>Face- and Root-Bend Specimens</td>
<td>329</td>
</tr>
<tr>
<td>D15M</td>
<td>Fillet Weld Soundness Test for Procedure Qualification</td>
<td>330</td>
</tr>
<tr>
<td>D16M</td>
<td>Location of Test Specimens on Welded Test Plate 25.4 mm Thick Consumables Verification for Fillet Weld Procedure Qualification</td>
<td>331</td>
</tr>
<tr>
<td>D17M</td>
<td>Pipe Fillet Weld Soundness Test Procedure Qualification</td>
<td>332</td>
</tr>
<tr>
<td>D18M</td>
<td>Test Plate for Unlimited Thickness —Welder Qualification</td>
<td>333</td>
</tr>
<tr>
<td>D19M</td>
<td>Test Plate for Unlimited Thickness—Horizontal Position—Welder Qualification</td>
<td>334</td>
</tr>
<tr>
<td>D20M</td>
<td>Test Plate for Limited Thickness—Welder Qualification</td>
<td>334</td>
</tr>
<tr>
<td>D21M</td>
<td>Test Plate for Limited Thickness—Horizontal Position—Welder Qualification</td>
<td>335</td>
</tr>
<tr>
<td>D22M</td>
<td>Tubular Butt Joint—Welder Qualification Without Backing</td>
<td>335</td>
</tr>
<tr>
<td>D23M</td>
<td>Tubular Butt Joint—Welder Qualification With Backing</td>
<td>336</td>
</tr>
<tr>
<td>D24M</td>
<td>Fillet-Weld-Break and Macroetch Test Plate Welder and Welding Operator Qualification—Option 1</td>
<td>336</td>
</tr>
<tr>
<td>D25M</td>
<td>Fillet-Weld Root-Bend Test Plate—Welder and Welding Operator Qualification—Option 2</td>
<td>337</td>
</tr>
<tr>
<td>Figure</td>
<td>Description</td>
<td>Page No.</td>
</tr>
<tr>
<td>--------</td>
<td>------------------------------------------------------------------------------</td>
<td>----------</td>
</tr>
<tr>
<td>D26M</td>
<td>Fillet Weld on Pipe—Welder and Welding Operator Qualification—Option 3</td>
<td>338</td>
</tr>
<tr>
<td>D27M</td>
<td>Location of Test Specimens on Welded Test Pipe and Square or Rectangular Tubing—Welder Qualification</td>
<td>339</td>
</tr>
<tr>
<td>D28M</td>
<td>Guided-Bend Jig</td>
<td>340</td>
</tr>
<tr>
<td>D29M</td>
<td>Guided-Bend Wraparound Jig</td>
<td>341</td>
</tr>
<tr>
<td>D30M</td>
<td>Guided-Bend Roller Jig</td>
<td>342</td>
</tr>
<tr>
<td>D31M</td>
<td>Test Plate for Unlimited Thickness—Welding Operator Qualification</td>
<td>343</td>
</tr>
<tr>
<td>E1M</td>
<td>Radiograph Identification and Penetrameter Locations on Approximately Equal Thickness Joints 250 mm and Greater in Length</td>
<td>344</td>
</tr>
<tr>
<td>E2M</td>
<td>Radiograph Identification and Penetrameter Locations on Approximately Equal Thickness Joints Less than 250 mm in Length</td>
<td>344</td>
</tr>
<tr>
<td>E3M</td>
<td>Radiographic Identification and Penetrameter Locations on Transition Joints 250 mm and Greater in Length</td>
<td>345</td>
</tr>
<tr>
<td>E4M</td>
<td>Radiographic Identification and Penetrameter Locations on Transition Joints Less than 250 mm in Length</td>
<td>345</td>
</tr>
<tr>
<td>E5M</td>
<td>Penetrameter Design</td>
<td>346</td>
</tr>
<tr>
<td>E7M</td>
<td>Qualification Procedure of Search Unit Using IIW Reference Block</td>
<td>347</td>
</tr>
<tr>
<td>E8M</td>
<td>International Institute of Welding (IIW) Ultrasonic Reference Blocks</td>
<td>348</td>
</tr>
<tr>
<td>E9M</td>
<td>Other Reference Blocks</td>
<td>349</td>
</tr>
<tr>
<td>F10M</td>
<td>Test for Arc Spot Weld</td>
<td>351</td>
</tr>
<tr>
<td>F11M</td>
<td>Fillet Weld Test Assembly</td>
<td>351</td>
</tr>
<tr>
<td>F13M</td>
<td>Standard Test Assembly for Flare-Bevel-Groove Welds; Test C—Sheet-to-Sheet</td>
<td>352</td>
</tr>
<tr>
<td>F14M</td>
<td>Standard Test Assembly for Flare-Bevel-Groove Welds; Test D—Sheet-to-Supporting Plate</td>
<td>352</td>
</tr>
<tr>
<td>F15M</td>
<td>Standard Test Assembly for Flare-V-Groove Welds</td>
<td>353</td>
</tr>
</tbody>
</table>
Railroad Welding Specification—
Cars and Locomotives

Part I
Requirements for All Welding

Section A
General Requirements

1. Scope

1.1 This specification covers the minimum welding requirements applicable to welded structures used in the railroad industry. It is not intended to apply to tank car tanks, or to the welding of rails. Recommended practices for welding railroad rails and related components are included in D15.2, *Recommended Practice for the Welding of Rails and Related Rail Components for Use by Rail Vehicles*.

1.2 Part I gives the general requirements for welded construction for metal components 1/8 in. (3.2 mm), or greater, in thickness. Unless otherwise stated these requirements apply to all freight cars, locomotives, and passenger train vehicles. Part II covers specific requirements for the welding of base metals less than 1/8 in. (3.2 mm) in thickness.

1.3 Companies shall be responsible for the quality of the welding done by their organization and shall perform whatever tests are necessary beyond the requirements of this specification to assure that the welds are satisfactory for the intended application.

The term "company" as used in this specification includes all facilities under common ownership that utilize the same program of welding standards and documentation.

1.4 Requirements contained herein constitute acceptable industrial practices. They are not intended as a substitute for engineering judgment with respect to the suitability of application of listed joints to a welded structure, nor are they intended to nullify or void any rules or require-ments contained in the U.S. Department of Transportation Locomotive Inspection Act (45 USC-22), and the Federal Railway Administration’s *Railroad Locomotive Safety Standards and Locomotive Inspection* (49 CFR Part 229).

1.5 Requirements contained herein are not intended to nullify or void the requirements of any law or governmental agency regulation nor any specification of the Association of American Railroads.

1.6 All references to the need for approval shall be interpreted to mean approval by the Engineer. The Engineer is the agency or representative designated by the owner, purchaser, or operating railroad, as applicable, acting on the owner’s behalf on all matters within the scope of this specification.

1.7 Specific areas of application to locomotives and passenger train vehicles include, but are not limited to the following:

- Structural components including primary and secondary load-bearing members of the locomotive underframe, center plate bearings, truck bolsters, draft gear pockets, equipment bases and supports, collision posts, main generators (alternator), traction motor frames, and car body structures.
- Air reservoirs not covered by the provisions of the *ASME Boiler and Pressure Vessel Code*.
- Fuel tank manufacture and repair
- Air compressor and air system piping
- Electrical components including eddy current clutches, reverser contacts, and motor commutator terminations.

1.8 Engines and engine components may require specialized processes and procedures unique to the original equipment manufacturer. Repair or rework of the engine
Index

A
Arc spot welds, 25.3, 26.1.5.2
“A” scan (UT), 23.3.1
Acceptance criteria
alternate, 27.2.12(3)
bend tests, 18.10.4
fillet weld, 17.2.2
liquid penetrant testing, 24.5
macroetch, 17.2.2
magnetic particle testing, 24.6
radiographic, 24.3
reduced section tension test, 17.9.1
tack weld, 20.7.1, 20.7.2
ultrasonic, 24.4
visual, 24.2, 32
Airbrake pipe, 13.15
Air compressors, 1.7
Air reservoirs, 1.7
Alignment
fixturing, 13.3.4.3
Allowable stresses, 11.8.2, 11.8.3
Tables B2, B3
aluminum, 11.8.3, Table B3
steel, 11.8.2, Table B2
Aluminum
allowable stresses, 11.8.3, Table B3
max time at temperature, Table B9
mechanical properties, Tables B4, B5
Angle beam (UT), 23.3.7, 23.6.5
Antispatter compound, 29.3
Approval, 1.6
Arc shield, 13.13.4
Arc strikes, 13.6
As-detailed tolerance, 14.5.2
Assembly, 13.3, Table B6, Figs. L3, L5–L7
Atmospheric exposure time period, 12.6.3, 12.6.4
Attenuation factor, 23.7.6.4
Attenuator, 23.3.4, 23.5.2

B
Backgouging, 14.6.1, 17.1.1, 17.1.9
Backing, 13.9, 15.4.1.4, 15.4.4.3, Figs. D23, D23M
contact, 13.3.4.4
full, 13.9.2
fused, 11.1.1, 13.3.4.5, 13.9.1
temporary, 13.9.3
Backing removal, 18.10.4
Baking of electrodes, 12.6.1, 12.6.2, 12.6.5

C
Calibration, ultrasonic
angle beam, 23.6.5
block (IIW), 23.3.7.7
dB accuracy, 23.10.2
equipment, 23.6
horizontal linearity, 23.3.2
longitudinal mode, 23.9.1
nomograph, 23.10.2
shear wave mode, 23.9.2
Chipping, 13.2.3.2, 13.4.3, 13.5.1
Cleaning, 13.2.3.2, 13.2.3.4
Clipping control (UT), 23.6.1
Combination of welds, 11.2.2.7
Consumables, 12
Convexity, 11.2.2, 11.2.2.8, 13.4.1, 13.4.2, 13.4.5, Figs. B6, C1
Copper-bearing steel, 11.8.4
Corner joints, 13.4.1, 15.4.4.3, 15.4.5.3
Correction of deficiencies, 13.3.4
Covered electrodes, 12.6
Cut roughness, 13.2.1.1

D
Decibel calculating equation, 23.10.3
Deficiencies in the work, 13.5.6
Definitions other than AWS 3.0, Annex E
Designated inspector, 21.2, 21.2.1, Annex E
Design considerations
aluminum alloys, Table B5
base metals 11.8.1
Dew point, 12.5.1, 12.5.2, 12.5.3
Diagrammatic weld, Annexes C1, C2
Dihedral angle, 11.2.2.6, 11.4.3, 18.6.1.1, 18.6.1.2, 18.6.2.1, 18.6.2.2, Annex C2
Dimensional tolerances, 13.3.4, 14.5.2, 14.6.2, Tables B8, D8M
Discontinuities repair, 13.2.1.1, 13.2.1.2, 17.9.2, 18.10.4
18.12.2, 21.7.5.5, 22.2.4, 22.3.2, 22.4, 23, 23.3.4, 23.11.1, 23.12.1, 23.12.2, 24.3.1, 24.3.2, Annex E
limits, Tables B7, B7M
Distortion control, 13.5.4
straightening, 13.5.4, 13.5.5, 13.5.5.1, 13.5.5.2
Drawings, 11.1, 11.1.1, 11.1.3, 11.1.4
Dye penetrant inspection, 13.5.3, see also liquid penetrant

E
Eccentricity, 13.3.3
Edge discontinuities, 13.2.1.2, Fig. B5
Effective throat, 11.2.2, 11.2.2.2, 11.2.2.4, 11.2.2.7, 17.6.2.3
Effective weld area, 11.2
Effective weld length, 11.2, 11.2.1, 11.2.1.1, 11.2.2, 17.6.1.3
        circular, 11.2.2.4
Effective weld size, 11.2.2.6, 13.3.1, Annex C
diagrammatic weld, Annexes C1, C2
Electrodes, 12.1, 12.4, 12.6.1, 12.6.2, 12.6.3, 12.6.4, 12.6.5, 12.6.6, 13.13.1, 15.3.1, 15.3.2.2, 15.3.2.3, 15.4.1.1, 15.4.1.2, 15.4.1.4, 15.4.2, 15.4.3, 15.4.3.1, 15.4.4, 15.4.4.1–15.4.4.4, 15.4.4.6, 15.4.5, 15.4.5.2, Tables B6, D6, AB1
flux cored arc, 8, 15.5.1
gas metal arc, 15.5, 15.5.1
low hydrogen, 12.6, 12.6.1, 12.6.2, Table B6
manufacturer’s certification, 12.2
shielded metal arc, 8, 14.1.1, 15.3.1, 15.6.2, 17.1.12, 27.2.4
storage, 12.6, 12.6.1–12.6.6
submerged arc, 8, 14.1.1, 15.4, 15.4.1.1, 15.4.2, 15.4.3, 15.4.4.2, 17.1.13
welder qualification groups, Table D6
Energy input, 13.10, 13.10.1, 17.1.2, 17.1.6
Engineer, 1.4, 1.6, 8, 12.2, 12.5.3, 13.2.1.1
Equipment
hazards, 6, 6.1, 6.2, 6.3
ultrasonic testing, 23.5
welding, 13.1.2, 13.13.1, 21.7.3.2, 30, 30.2
Essential variables, Annex E
procedure qualification, 26.1.4, 26.1.5, 26.2.1.4
performance qualification, 28.1
Exposure (radiographic), 22.2.8, 22.3.2.11
Extension bars, see weld tabs

F
Fabrication inspector or Designated inspector 21.2, 21.2.1, 21.2.2, Annex E
Failure, 11.2.1.4, 13.13.8, 17.9.1.3, 17.11, 20.8, 23, 26.1.5.2
Fatigue loading, 1.10
Faying surface, 11.2.3.1, 11.5.2, 13.3.1.1, 13.4.3, 25.5, 26.1.5.4
FCAW, 9.1, 14.2.1, 15.5, 15.5.2.3, 15.5.2.6
Filler metal, Annex B
base metal combinations, Table C4
electrode-flux, 12.4, 15.4.1.5
granular, 17.1.13
hydrogen control, 12.6, 12.6.1, 12.6.2, 12.6.3, 12.6.4, 12.6.6, 13.13.6, Table B6
matching requirements, Table C4
powdered, 17.1.13
Flux, 12.3, 12.4
Flux cored arc welding, 14.1.1, 15.5, 17.1.15
Fogging, 22.3.2.10
Forms, Annex D

G
Gas metal arc, 14.2.3, 15.4.4.7, 15.5, 15.5.1
Gamma ray, 22.3.2.5, 22.3.2.11
Gap, see root opening
Gas metal arc welding, 14.2.3, 15.5
backing, 15.5.2.7
electrodes, 15.5.1, 15.5.2
essential variables, 26.1.4
layer thickness, 15.5.2.1
root pass, 15.4.4.7
shielding gas, 26.1.4
short circuit transfer, 14.2.3, 16.3.2, 18.2.1, 18.10.1
Gas tungsten arc welding, 17.1.16
electrodes, 27.2.3
essential variables, 17.1.16
Glass tape, 13.9.3, 15.4.1.4, 15.5.2.7
Glossary, Annex E
Grease, 13.2.2.1, 13.2.3.3, 23.7.3
Groove welds
assembly tolerances, 13.3.4, Table B6
complete joint penetration 13.3.4.5, 14.5
effective area, 11.5, 11.5.3
layer thickness, 15.5.2.1
root pass, 15.4.4.7
throat, 14.1, see also Effective weld size
tubular, 18.5
Groove weld test plate, 17.2.3, 17.2.4
Grounding, 13.14
battery equipped vehicles, 13.14.3
connection, 13.14.2
self-propelled vehicles, 13.14.4
Guided bend test jig, Figs. D28–D30

H
H & D density, 22.5.1
Hazardous materials, 6.3, Annex F
Heat input, 13.10, 13.10.1, 17.1.2, 17.1.6
intermittent, 11.5, 11.5.3
interrupted, 11.5, 11.5.3, 13.7.2
lap joints, 11.2.2.5, 11.4.1, 11.4.2, 11.6.2
length, 11.2.2.1, 11.2.2.3, 11.2.2.4
layer thickness, 15.5.2.1
minimum size, 14.3.1, 14.3.2, Table C2
pipe positions, 17.4.4.1, 17.4.4.2, 17.4.4.3, 17.4.4.4, Table B6
profiles, 13.4.1, Fig. B6
shear stress, 11.4.2
soundness test, Figs. D15, D15M, D17, D17M
termination, 11.2.2.3, 13.8
test plates, 17.4.3
undersize, 24.2.7
Fit-up tolerance, 14.5.2, 14.6.2
Flaw size evaluation, 23.11
angle beam testing, 23.11.2
straight beam testing 23.11.3
Fluorescent screens, 22.3.2.4
Flux, 12.3, 12.4
Flux cored arc welding, 14.1.1, 15.5, 17.1.15
Fogging, 22.3.2.10
Forms, Annex D

H & D density, 22.5.1
Hazardous materials, 6.3, Annex F
Heat input, 13.10, 13.10.1, 17.1.2, 17.1.6, 29.5
Heat treatment, 13.11, 15.2, 17.1.4
Hermetic containers, 12.6.1, 12.6.2, 12.6.3
Hole-type IQI, image quality indicator
Annex E
Horizontal position, 14.1.1, 15.3.2.7
I

IWIW ultrasonic reference block, 23.3.7.7, Figs. E7, E7M, E8, E8M
Identification marks, 22.3.2.12
Image quality indicator, Annex E
Impact test, 17.1.6, 17.2.1
In-process cleaning, 13.7.2
Inadequate joint penetration, 17.9.5.4
Incomplete fusion, 17.9.5.4, 20.7.2, 24.2.2, 24.3
Indication rating, 23.7.6.3, 23.7.6.5, 23.11.2.1

II

Image quality indicator, Annex E
Impact test, 17.1.6, 17.2.1
In-process cleaning, 13.7.2
Inadequate joint penetration, 17.9.5.4
Incomplete fusion, 17.9.5.4, 20.7.2, 24.2.2, 24.3
Indication rating, 23.7.6.3, 23.7.6.5, 23.11.2.1

III

Inspection
dye penetrant, 13.5.3, 21.8.4
equipment, 13.5.3
general, 13.5.3
liquid penetrant, 13.5.3, 24.5
magnetic particle, 13.5.3, 21.8.5, 24.6
materials, 21.7.2
nondestructive testing, 13.5.3
personnel, 21.9
pipe and tubing, 17.9.5
radiographic, 13.5.3, 21.8.2, 22, 24.3
records, 21.7.5
reference standards, 23.4
studs, 13.13.8
ultrasonic, 13.5.3, 21.8.3, 23, 24.4,
Tables E2, E4, Figs. E6–E11
verification, 13.5.3, 21.7.4, 21.7.5
visual, 24.2, Table E3
welder qualification, 21.7.4.2
work, 21.7.5
WPS qualification, 21.7.3
Inspector
identification of accepted welds, 21.6
qualification, 21.2.2
verification, 13.5.3, 21.7.4, 21.7.5
Inserts, 17.1.1, 26.1.4
Intermittent, 11.5, 11.5.3
Interpass temperature, 15.2.2, 17.1.4, 29.5, Tables C5, C5M
IQI, see Hole-type IQI, image quality indicator Annex E
Iridium, 22.3.2.6
Iron powder, 15.4.1.4, 15.5.2.7
Isotope radiation, 22.3.1

J

J-grooves, Table C3, Figs. C11, C1J,
C1K, C2I, C2J
Job-size pipe, 17.6.1.1
Joint alignment 13.3.3
Joint root openings, 11.2.2.6, 13.3.1,
13.3.2, 13.3.4.1, 15.4.4.5
15.5.2.1, 15.5.2.2

L

Lamellar tearing, 23.1.5
Laminar reflector, 23.7.5
Laminations, 23.1.5
Lap joints, 11.6, 11.6.1, 11.6.2
Limitation of variables, WPS qualification, 17.1
flux cored arc welding, 17.1.15
gas metal arc welding, 17.1.14
shielded metal arc welding, 17.1.12
submerged arc welding, 17.1.13
Limitation of variables, tack welders, 20.2
base metals, 20.4
electrodes, 20.2.1, 20.2.2
position, 20.2.4
welding process, 20.2.3
Limitation of variables, welder qualification, 19.2
base metals, 19.2.2
electrodes, 19.2.3
position, 19.2.5
progression of welding, 19.2.7
welding process, 19.2.1
Limitation of variables, operator qualification, 19.2
base metals, 19.2.2
electrodes, 19.2.4
position, 19.2.5
progression of welding, 19.2.7
Linearity (UT)
horizontal, 23.3.2
Liquid penetrant testing 13.5.3, see also
Dye penetrant inspection
Local dihedral angle, see Dihedral angle
Longitudinal bend specimens, 17.2.1, 17.6.1.5
Low alloy steel, 27.2.3, 29.3.1
Low hydrogen electrodes, 12.6
atmospheric exposure, 12.6.3, 12.6.4
condition, 12.6.1
established by tests, 12.6.4
redrying, 12.6.6
restrictions, 12.6.5, Table B6
storage, Table B6

M

Machined joints, 13.2.2.2, 13.2.3.1,
17.6.2.3
Machining, 13.2.1.1, 13.2.2
Macroetch test, 17.2.1, 17.2.2, 17.6.2,
17.6.3.2, 17.7.1, Tables D2, D3,
Figs. D24, D24M
Macroetch test specimen, 17.6.2.3,
17.6.3.2, 17.9.3, 18.10.3
Magnetic particle testing
sample test report form, Annex D
Manufacturer, 21.1
electrode certification, 12.2
responsibility, 1.3
shielding gas certification, 12.5.3
Maximum single pass layer width,
13.2.1.2, 15.3.2.7, 15.4.3.3
Mislocated holes, repair of, 13.5.9
Mechanical testing, 17.6.1.4, 18.10.1
Melt-through, 15.4, 1.4, 15.4.4.3,
15.4.5.3, 15.2.2.7, 17.9.5.5
Melting-through, see melt-through
Method of testing, 17.8, 18.11, 19.7,
20.6, 27.2.10
Mill scale, 12.3, 13.2.2.1, 29.3
Minimum weld size, 11.2.1.3, 14.1.3,
Tables B1, B1M
Fillet, 14.3.2, Tables C2, C2M
groove, 11.2.1.3, 14.1.3, Tables B1, B1M
Misalignment, 13.3.4
Multiple arc, 17.1.6
Multiple electrodes, 15.4.4.3
Multiple pass, 13.7.2, 15.3.2.6, 15.4.3.3

N

NDE, see Nondestructive testing
Nomograph, ultrasonic attenuation,
23.10.2, 23.10.4, 23.10.4.2, 23.10.5
Nonconformance, 13.3.4
Nondestructive testing
liquid penetration, 13.5.3, 21.8.4
magnetic particle, 13.5.3, 21.8.5,
24.6
personnel qualification
radiographic testing, 13.5.3, 21.8.2,
22, 24.3
ultrasonic testing, 13.5.3, 21.8.3, 23,
24.4, Tables E2, E4, Figs. E6–E11
Notches, 13.2.1.1
Notch toughness, 17.1.6, 17.2.1
Owner (Engineer), 1.6, 22.5.2, 22.5.3,
23.8.3, Annex E
Oxygen cutting, 13.2.2.2  
plate preparation, 13.2.2.1, 13.2.3.1, 13.2.3.3  
roughness, 13.2.1.1  
Oxygen gouging, 13.2.2.2  
metal removal, 13.2.2.2  
on quenched and tempered steels, 13.5.1, 13.10.2  
Out-of-tolerance, 13.3.4  

P  
Paint removal, 6.2  
Parallel electrodes, 15.4.1.1, 15.4.4  
Peening, 13.12  
acceptable peening, 13.12.1.1  
aluminum, 13.12.2  
slag removal, 13.12.1.3  
use of vibrating tools, 13.12.1.3  
Penetrameters, 22.1.3, 22.3.1, 22.3.2.3, 22.3.2.7, 22.3.2.9, Annex E, see also hole-type IQI or wire IQI  
Performance qualification, 9.1, 16.4.2, 18.7.3, 27.2.13  
Personnel qualification for NDT, 21.9  
Pipe welds, 19.3.6  
job-size pipe, 17.6.1.1  
procedure qualification test specimens, Table D1, Figs. D17, D17M  
test position, 17.4.2, 17.6.6, Table D4, Figs. D4, D6, D7, D7M, D27  
test specimens, location, Figs. D26, D26M, D27, D27M  
tests required, Figs. D26, D26M  
visual inspection, 17.9.5  
welder qualification, 16.3.2, Figs. D26, D26M  
Piping porosity, Annex E  
Plate qualification test specimens, Figs. D18–D20  
Plug welds, 11.2.3.1, 11.2.3.2, 11.2.3.3, 11.2.3.4, 11.2.3.6, 11.2.3.7, 17.2.3  
ablessible stresses, 11.2.3.7  
diameter, 11.2.3.3, 14.4.2  
effective area, 11.2.3.1, 25.6  
filling, 11.2.3.6  
macroetch test, 17.9.3  
prequalified dimensions, 14.4.1  
qualification tests, 17.2.3  
size, 14.4.2  
spaceing, 11.2.3.3  
stresses, 11.2.3.7  
technique, 15.6.1  
thickness, 11.2.3.6  
uses, 11.2.3.2  
Porosity, 15.5.2.4, 18.12.3.1, 18.12.3.2, 20.7, 20.7.2, 24.2.6, 24.3.1, Annex E, Tables E3, E3M  
Position 1F rotated, 17.4.4.1, Fig. D6  
Position 2F rotated, 17.4.4.2, Fig. D6  
Position 1G rotated, 17.4.2.1, Fig. D4  
Postweld heat treatment (PWHT), 15.2  
Prequalified joint details, Figs. C1A–C1K, C2A–C2J  
Pressure vessels or pressure piping, 1.7  
Procedure qualification record (PQR), Annex D  
Processes, 8  
Profiles, weld, 13.4, 13.4.2, Fig. B6  
Progression of welding, 15.5.2.4, 28.4.5  
Prohibited welded joints, 13.5.9  
Protective coatings, 13.7  
Punched holes, repair, 13.5.9  
Qualification forms, Annex D  
general requirements, 16.1  
NDT, 16.3.2, 17.6.1.3  
prequalified, WPS, 16.1.2  
previously qualified, WPSs, 16.4.3  
records, 17.10  
responsible, 16.4  
retests, 17.11  
stud application, 17.2.4  
tack welders, 20  
welding operators, 16.3.1  
WPSs, 17  
Qualification of welders and welding operators, 10.1, 10.2, 10.3  
Quality of welds, 32.  
Quenched and tempered steel, 13.5.1, 13.5.4, 13.10, 17.1.2  
Radiation imaging  
Radiographic inspection, see Radiographic testing, 22  
Radiographic procedure, 22.3  
Radiographic testing, 23  
acceptance criteria, 24.3  
backscattered radiation, 22.3.2.8  
elongated discontinuities see piping porosity, Annex E  
extent of testing, 22.2  
Reinforcement removal of, 13.4.3  
not removed, 18.10.4, 22.3.2.3  
Reject control (UT), 23.6.1  
Report forms, Annex D  
Reports, 22.5, 23.8.3  
Residual stress, 13.5.5.1  
Restoration by welding, of holes, 13.5.9  
Retests, 17.11, 18.13, 19.9, 27.3  
Root-bend tests, 17.2.1
Root face, 14.5.2.2, 15.4.4.3, 15.5.4.3, 17.1.1
Root opening, 13.3.1, 13.3.2, 13.3.4.1, 15.4.4.5, 17.1.1, 31.1, Annex C2
Run-off plates, see Run off tabs
Run-off tabs
  aluminum 13.8.2
  steel 13.8.1
Rust-inhibitive coating, 13.2.2.1
Sample joint, 15.4.1.3, 17.6.2
Scanning, 23, 23.7.5, 23.12
Sensitivity (RT), 22.3.1
Sensitivity (UT), 23.4.1, 23.6.2, 23.6.4
Sequence, 11.1.3
Shear connectors, 11.2.3.2
Shear stress, 11.2.3.2, Tables B2, B3
Shielded metal arc welding, 15.3, 17.1.12
  atmospheric exposure, 12.6.3, 12.6.4, Table B6
  electrodes, 15.3.2.3, 17.1.12
  essential variables, 17.1
  layer thickness, 15.3.2.7
  maximum fillet weld size, 15.3.2.6
  of studs, 13.13.6
  prequalified WPSs, 16.1
  root pass, 15.3.2.4, 15.3.2.5
Shielding gas 12.5
  dew point 12.5.1, 12.5.2
  wind protection, 15.5.2.6
Short circuiting transfer, 9.1, 14.2.1, 14.2.3, 15.6.1.1, 16.3.2, 18.10.1
Shrinkage
  due to welding, 11.1.3, 13.12.1.1
Side bend
  specimens, 17.2.1, 17.6.4.2, Figs. D13, D13M
  Side-bend test, 17.2.1, 17.9.2, 18.12.2
  Skewed T-joints, 11.2.2.6, 11.4.3, Table AC1, Fig. B3
Slag, 12.3.1
Slag inclusion, 17.9.2, 18.12.2
Slag removal
  filling, 11.2.3.6
  required, 13.7.2, 13.7.3
  use of slag hammers, 13.12.1.3
  use of vibrating tools, 13.12.1.3
Slot welds
  effective area, 11.2.3.1, 25.6
  ends, 11.2.3.4
  filling, 11.2.3.6
  length, 11.2.3.5, 14.4.3, 15.6.2
  maximum, 14.4.3
  prequalified dimensions, 14.4.1, 14.4.2
  size, 14.4.1
  spacing, 11.2.3.5
  stresses, 25.3
  technique for making, 14.4.1, 15.6
  thickness, 11.2.3.6
  uses, 11.2.3.2
  welder qualification, 18.2.8
SNT-TC-1A qualification, 21.9
Spacer bar, or backing bar, Fig. F8
Special details, 13.13.1
Special inspection requirements, 11.1.4
Stainless steel, 13.2.3.3, 13.9.3, 16.1.5, 26.1, 27, 27.2.4, Annex I
Stress relief, 13.11
  quenched and tempered steels, 13.5.4
  temperature, 13.5.4
Studs
  acceptance, 13.13.8
  alternative processes, 13.13.6
  base metal temperature, 13.13.3, 13.13.5
  description, 13.13.1
  design, 13.13.1
  fillet weld size, 13.13.6
  flash, 13.13.7
  length of studs, 13.13.1
  manufacturers, 1.3
  moisture, 13.13.3
  oil, 13.13.1
  rust, 13.13.1
  scale, 13.13.1
Stud welding
  application qualification
    requirements, 13.13.1
  arc shields, 13.13.4
  ferrule, 13.13.4
  flash, 13.13.7
  flux, 15.4.2
  inspection requirements, 13.13.8
  length of studs, 13.13.1
  low hydrogen electrodes, 13.13.6
  moisture, 13.13.3
  preheat requirements, 13.1.5
  profiles, Fig. B6
  repair, 13.13.7
  rust, 13.13.1
  scale, 13.13.1
Submerged arc welding, 15.4
  electrode diameter, 15.4.1.2
  electrodes and fluxes, 15.4.2
  flux reclamation, 12.3
  interpass temperature, 15.2.2
  layer thickness, 15.4.3.3
  limitations, 15.4.1.5
  macroetch test specimens, 15.4.1.3
  maximum current, 15.4.3.4
  multiple arcs, 15.4.1.1
  multiple electrodes, 15.4.5
  definition, 15.4.5.1
  GMAW root pass, 15.4.5.7
  weld current limitations, 15.4.5.6
  weld layer thickness, 15.4.5.3
  parallel electrodes, 15.4.1.1
  definition, 15.4.1.1
  essential variables, 17.1.13
  GMAW root pass, 15.4.4.7
  reduction of preheat and single electrodes, 15.4.3
  tack weds, 15.4.1.6
  weld layer thickness, 15.4.4.3
  welding current limitations, 15.4.4.5
  15.4.4.6
Surface preparation, 13.2
Surface roughness, 13.2.1.1
Surface roughness guide, 13.2.1.1
Surface Roughness Guide for Oxygen Cutting
Tack welder qualification, 20
  essential variables, 20.2
  method of testing specimens, 20.6, Fig. D33
  period of effectiveness, 20.9
  retests, 20.8
  test report form, Annex D
  test specimens, Figs. D32, D33
  tests, 20.5
Tack weds, 13.3.5
  discontinuities, 20.7.1
  in final weld, 13.3.5
  quality, 13.3.4.3
  size, 13.3.4.3, 15.4.1.6
Temporary welds, 24.1
  Temperature, ambient, 13.5.5, 29.3.1
  Temperature limitations, 13.1.4
Terms, AWS A3.0, Standard Welding Terms and Definitions
Testing agency, 1.6
Test plates, welded
  tack welder qualification, Figs. D32, D33
welding operator qualification, Table D7, Figs. D24–D26, D31
welder qualification, Table D7, Figs. D18–D21, D24–D26
WPS qualification, 21.7.3
Test specimens, D1, D1M, D2, D2M, D3
Test weld positions, 15.4.4.2, Figs. D1–D4
Thermal cutting
acceptance criteria, 13.2.1.1
aluminum, 13.2.1.1
Thickness limitations, Tables D1, D1M, D2, D2M, D3, D7, D7M, Figs. D20, D20M
Thin metal
arc spot welds, 25.3, 26.1.5.2, Figs. F2–F4
fillers, 25.6
flare bevel welds, 26.1.5.5, Figs. F13, F14
plug welds, 25.5
procedure qualification, 26
aluminum alloys, 26.2.1.4
essential variables, 26.1.4
steels, 26.1
testing, 26.1.5
T-joints, 26.1.5.4, Table F1
slot, 25.5
square groove welds, 26.1.5.1, 26.2.1.6
workmanship techniques, 29
Tolerances
alignment, 13.3.3, 13.3.4.3
dimensional, 13.3.4, Tables D8, D8M, Figs. C1A–C1L
offset, 13.3.3
warpage, 13.5.4
Toughness, 17.1.6, 17.2.1
Transducer calibration, 23.9.1
Transducer specifications, 23.3.6, 23.3.7.1, 23.3.7.2
Transitions of thickness or widths, 13.4.2, 13.4.3
Transverse bend specimens, 17.2.1

U
Ultrasonic testing, 23
acceptance criteria, 24.4, Table E4
attenuation factor, 23.7.6.4
base metal discontinuities, 23.1.5
calibration, 23.6
calibration for angle beams, 23.6.5
distance, 23.6.5.1
horizontal sweep, 23.6.5.1
zero reference level sensitivity, 23.6.5.2
calibration for longitudinal mode, 23.9.1
calibration for shear mode or angle beam, 23.6.5
amplitude calibration, 23.9.1.2
approach distance, 23.9.2.6
distance calibration, 23.6.5.1
resolution, 23.4.3
sound entry point, 23.5.4
sound path angle, 23.5.4
transducer positions, 23.3.7.4
calibration for straight beam, 23.6.4
horizontal sweep, 23.6.4.1
sensitivity, 23.6.4.2
calibration for testing, 23.6
distance, 23.6.2
horizontal sweep, 23.6.2
zero reference level sensitivity, 23.6.5.2
crossing patterns, 23.7.6.2
discontinuities
longitudinal, 23.7.6.2, 23.12.1
transverse, 23.7.6.2, 23.12.2
equipment
gain control, 23.3.4
horizontal linearity, 23.3.1, 23.5.1, 23.10.1
search units, 23.3.7
equipment qualification
 calibration block, 23.5.4, 23.6.5.1
dB accuracy, 23.10.2
gain control, 23.5.2
horizontal linearity, 23.9.1.4, 23.10.1
internal reflections, 23.10.7
examples, 23.10.2
extent of testing, 23.2
flaw length determination, 23.13
flaw size evaluation procedures, 23.11
angle beam testing, 23.11.2
straight beam testing, 23.11.1
groove welds, 23.1.1
indication of length, 23.11.2.1
laminar reflector, 23.7.5
longitudinal mode calibration, 23.9.1
nomograph, 23.10.5
operator requirements, 23.1.3
personnel qualification, 21.9
procedures, equipment qualification, 23.10
internal reflections, 23.10.7
vertical linearity, 23.10.2
procedures, flaw size evaluation, 23.11
angle beam testing, 23.11.2
straight beam testing, 23.11.1
qualification blocks, 23.4
reference blocks, IIW, 23.4.1, Figs. E7, E8
information on, 23.4.3
other approved blocks, Fig. E9
reports, 23.8, Annex D
disposition, 23.8
reflector size, 23.7.5
repairs, 23.1.4
scanning patterns, 23.7.6.2, 23.12
search units, 23.3.7
amplitude, 23.9.1.2
angle beam, 23.3.7
application, Fig. E10
approach distance, 23.6.5.1
dimensions, 23.7.6
distance calibration, 23.6.5.1
resolution, 23.4.3, 23.9.1.3
sensitivity, 23.4.1
shear wave mode, 23.6.5
sound entry point, 23.5.4
sound path angle, 23.5.4
straight beam, 23.6.4
spot testing, 23.2.4
testing angle, 23.7.6.1, Tables E2, E2M
testing procedure
cleanliness of surface, 23.7.3
couplant materials, 23.7.3
flaw evaluation, 23.11
testing of repairs
thickness limitations, 23.6.5.1
transducer locations, Fig. E10
transducer size, 23.11.1
tubular structures, 24.2
weld identification, 23.132
Ultrasonic testing (alternative method), 23.9
acceptance criteria, 24.4, Table E4
amplitude, 23.9.1.2
calibration, 23.9
calibration test block, Fig. E10
compression wave, 23.9.2
DAC (distance amplitude correction), 23.6.5.1
discontinuities
height, 23.10.2
length, 23.11.2.1
location, 23.7.5
delaminations, 23.1.5
documentation requirements, Annex D
lamellar, 23.11.1
reports, Annex D
scanning, 23.7.5
sensitivity, 23.4.1
shear wave, 23.9.2
transducer, 23.11.1
weld marking, 23.13.2
Undercut, 15.4.3.4, Tables E3, E3M
Unlisted base metals, 15.1.2
Unit stresses
- base metal, Tables B2, B2M, B3, B3M
- plug welds, 11.2.3.7
- shear, Tables B2, B3
- slot welds, 25.3
- tension, 11.8.3
- welds, Tables B2, B2M, B3, B3M
UT report forms, Annex D

V
Verification inspection 13.5.3, 21.7.4, 21.7.5
Vertical position, 15.5.2.4, 15.6.1.2
prequalified, 15.6.1.2, All figs. C1, C2
restrictions on, 15.3.2.8, 15.5.2.4
Visual inspection, 32, 17.9.5, 17.9.6, 21.5, 21.7.5.5, 24.2

W
Warpage, 13.5.4
Weld cleaning, 13.2.3.3, 17.5.2, 18.9
completed welds, 13.7
in-process cleaning, 13.3.4.5, 13.7
use of manual hammers, 13.12.1.3
use of lightweight vibrating tools, 13.12.1.3
Weld metal removal, 13.5.1
Weld profiles, 13.4, Fig. B6
butt, 13.4.3, 13.4.4
fillet, 13.4.1, 13.4.5
groove, 13.4.2, 14.4.6
Weld spatter, removal of, 13.7.4, 24.2.8
Weld specimens, Tables D1, D1M, D2, D2M, D3, D7, Figs. D7, D7M, D8, D8M, D9, D10, D10M, D11, D11M, D12, D12M, D13, D13M, D14, D14M, D16, D16M, D27, D27M, D32, D33
Weld starts and stops, see Weld tabs
Weld tabs, 13.8.1, 13.8.2
Weld termination, 13.8
Weld thickness (UT), 23.6.5.1
Welded connections, 25.1
Welder performance qualification
acceptance criteria, 26, 28.7, Table D8
aluminum alloys, 28
fillet weld tests, 18.6
groove weld tests, 18.4
limitation of variables, 18.2, 27, 28.4
limited thickness, Fig. D20
method of testing, 18.11
number of specimen, 19.10
period of effectiveness, 18.14, 27.4
pipe welding tests, 18.3.2, 18.5
plate, 18.3.3, 18.4
positions, 27
production welding position, 27.2.13
records, 18.15
retests, 18.13
steels, 27
testing, 18.10
Welders, see AWS 3.0
Welding
at low temperatures, 13.1.3, 13.1.4
equipment, 13.1.2
progression, 15.5.2.4, 28.4.5
Welding consumables, 12
Welding operator qualification, 19, 28
- essential variables, 19.2
- fillet weld tests, 19.3.5
groove weld tests, 19.3.1
method of testing, 18.11
number of specimen, 18.10
period of effectiveness, 19.10
pipe weld tests, 19.3.6, 18
plate weld tests, 19.3.4
preparation of test specimens, 18.10
retests, 19.9
test report form, Annex D
test results required, 18.12
- bend tests, 18.12.2
- fillet weld break tests, 18.12.3
- macroetch tests, 18.12.4
- radiographic tests, 18.12.5, 19.3.1
test specimens, 18.10
Welding operators, 10, 16.3, 16.4, 19.3
Welding Performance Qualification
Record, Annex D
Welding personnel, 27
Welding Procedure Specification, 11.1,
- 13.3.4.2, 16.1.3, 17.1.6
- essential variables, 17.1.1
- qualification, Section D
- sample forms, Annex D

X
X-rays, 22.1.3, 22.3.2.6, 22.3.2.11

Y
Yield strength, 11.8.3, 25.3