

AWS D1.1/D1.1M:2025
An American National Standard

Structural Welding Code— Steel



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AWS D1.1/D1.1M:2025
An American National Standard

Approved by the
American National Standards Institute
March 19, 2025

Structural Welding Code—Steel

25th Edition

Revises AWS D1.1/D1.1M:2020

Prepared by the
American Welding Society (AWS) D1 Committee on Structural Welding

Under the Direction of the
AWS Technical Activities Committee

Approved by the
AWS Board of Directors

Abstract

This code covers the welding requirements for any type of welded structure made from the commonly used carbon and low-alloy constructional steels. Clauses 1 through 11 constitute a body of rules for the regulation of welding in steel construction. There are eight normative and eleven informative annexes in this code. A Commentary of the code is included with the document.



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Foreword

This foreword is not part of AWS D1.1/D1.1M:2025, *Structural Welding Code—Steel*, but is included for informational purposes only.

The first edition of the *Code for Fusion Welding and Gas Cutting in Building Construction* was published by the American Welding Society in 1928 and called Code 1 Part A. It was revised in 1930 and 1937 under the same title. It was revised again in 1941 and given the designation D1.0. D1.0 was revised again in 1946, 1963, 1966, and 1969. The 1963 edition published an amended version in 1965, and the 1966 edition published an amended version in 1967. The code was combined with D2.0, *Specifications for Welding Highway and Railway Bridges*, in 1972, given the designation D1.1, and retitled AWS *Structural Welding Code*. D1.1 was revised again in 1975, 1979, 1980, 1981, 1982, 1983, 1984, 1985, 1986, 1988, 1990, 1992, 1994, 1996, 1998, 2000, 2002, 2004, 2006, 2008, 2010, 2015, and 2020. A second printing of AWS D1.1/D1.1M:2010, 2015, and 2020 were published in 2011, 2016, and 2022, respectively. From 1972 to 1988, the D1.1 code covered the welding of both buildings and bridges.

In 1988, AWS published its first edition of AASHTO/AWS D1.5M/D1.5, *Bridge Welding Code*; coincident with this, the D1.1 code changed references of buildings and bridges to statically loaded and dynamically loaded structures, respectively, in order to make the document applicable to a broader range of structural applications. After the publishing of the 2010 edition, it was decided that the AWS *Structural Welding Code—Steel* would be published on a five year revision cycle instead of a two year revision cycle. This was done in order to sync the publication cycle of AWS Structural Welding Code-Steel with the publication cycles of the ANSI/AISC 360, *Specification for Structural Steel Buildings* and the *International Building Code*. This 2025 edition is the 25th edition of D1.1.

Changes in Code Requirements, underlined text in the clauses, subclauses, tables, figures, or forms indicates a change from the 2020 edition. A vertical line in the margin of a table or figure also indicates a change from the 2015 edition.

The following is a summary of the most significant technical changes contained in AWS D1.1/D1.1M:2025:

Summary of Changes	
Clause/Table/Figure/Annex	Modification
General	AWS A5.36 filler metal classifications and properties have been removed throughout the standard.
Clause 2—Normative References	The normative references were amended.
Clause 3—Terms and Definitions	New terms and definitions were added.
Clause 4—Design of Welded Connections	Clarified base metal and filler metal strength requirements, added provisions for matching filler metals, added provisions for toughness, added a new subclause 4.7 on Load and Resistance Factor Design (LRFD), added a new Table 4.3 for available strength of welded joints, and added a new Figure 4.7, clarifying the maximum specified fillet weld size along edges.
Clause 5—Prequalification of WPSs	Revised subclause 5.6.1 on matching and undermatching filler metal strength, converted Table 5.1 on prequalified WPS requirements from the previous edition into 4 separate tables, added Group V metals to Table 5.7 on filler metals for matching strengths, and replaced the joint details in Figures 5.1 and 5.2 with new drawings.
Clause 6—Qualification	Qualification for preheat and interpass temperatures were revised, acceptance criteria for macroetch testing was updated, and the WPS qualification tables were changed.
Clause 7—Fabrication	Text was introduced, clarifying production welding requirements and preheat and interpass temperatures, and new weld tab exemptions were listed.

(Continued)

Summary of Changes (Continued)

Clause/Table/Figure/Annex	Modification
Clause 8—Inspection	Additional provisions for Magnetic Particle Testing (MT) and Penetrant Testing (PT) were added, language was included to clarify the certification of personnel performing nondestructive testing (NDT), and the acceptance criteria for visual inspection was updated.
Clause 9—Stud Welding	New provisions for type D studs were added.
Clause 10—Tubular Structures	Revised the requirements for tubular connections and clarified the requirements for T-, Y-, and K- connection procedures.
Annex M	It was presented as Annex N in the previous edition.
Annex N	It was presented as Annex O in the previous edition.
Annex O	It was presented as Annex P in the previous edition.
Annex P	It was presented as Annex Q in the previous edition.
Annex R	It was presented as Annex S in the previous edition and new reference documents were listed.
Annex Q	It was presented as Annex R in the previous edition.
Annex S	New annex that addresses the addition of base materials to AWS D1.1/D1.1M.

Commentary. The Commentary is nonmandatory and is intended only to provide insightful information into provision rationale.

Normative Annexes. These annexes address specific subjects in the code and their requirements are mandatory requirements that supplement the code provisions.

Informative Annexes. These annexes are not code requirements but are provided to clarify code provisions by showing examples, providing information, or suggesting alternative good practices.

Index. As in previous codes, the entries in the Index are referred to by subclause number rather than by page number. This should enable the user of the Index to locate a particular item of interest in minimum time.

Errata. It is the Structural Welding Committee's Policy that all errata should be made available to users of the code. Therefore, any significant errata will be published in the Society News Section of the *Welding Journal* and posted on the AWS web site at: <http://www.aws.org/standards/page/errata>.

Suggestions. Your comments for improving AWS D1.1/D1.1M:2025, *Structural Welding Code—Steel* are welcome. Submit comments to the Secretary of the D1Q Subcommittee, American Welding Society, 8669 NW 36 St, # 130, Miami, FL 33166.

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Dedication

The D1 Committee on Structural Welding dedicates this 25th edition of AWS D1.1/D1.1M, Structural Welding Code—Steel, in honor of Philip “Phil” Torchio, III. The D1Q Subcommittee is eternally grateful for Phil’s leadership, mentorship, and more importantly his friendship as a member and Chairman of the D1Q Subcommittee. The members of D1 and D1Q are forever thankful for his devotion to improving the AWS D1 Codes.

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Structural Welding Code—Steel

1. General Requirements

1.1 Scope

This code contains the requirements for fabricating and erecting welded steel structures. When this code is stipulated in contract documents, conformance with all provisions of the code shall be required, except for those provisions that the Engineer (see 1.5.1) or contract documents specifically modifies or exempts.

The following is a summary of the code clauses:

- 1. General Requirements.** This clause contains basic information on the scope and limitations of the code, key definitions, and the major responsibilities of the parties involved with steel fabrication.
- 2. Normative References.** This clause contains a list of reference documents that assist the user in implementation of this code or are required for implementation.
- 3. Terms and Definitions.** This clause contains terms and definitions as they relate to this code.
- 4. Design of Welded Connections.** This clause contains requirements for the design of welded connections composed of tubular, or nontubular, product form members.
- 5. Prequalification of WPSs.** This clause contains the requirements for exempting a Welding Procedure Specification (WPS) from the WPS qualification requirements of this code.
- 6. Qualification.** This clause contains the requirements for WPS qualification and the performance qualification tests required to be passed by all welding personnel (welders, welding operators, and tack welders).
- 7. Fabrication.** This clause contains general fabrication and erection requirements applicable to welded steel structures governed by this code, including the requirements for base metals, welding consumables, welding technique, welded details, material preparation and assembly, workmanship, weld repair, and other requirements.
- 8. Inspection.** This clause contains criteria for the qualifications and responsibilities of inspectors, acceptance criteria for production welds, and standard procedures for performing visual inspection and nondestructive testing (NDT).
- 9. Stud Welding.** This clause contains the requirements for the welding of studs to structural steel.
- 10. Tubular Structures.** This clause contains exclusive tubular requirements. Additionally, the requirements of all other clauses apply to tubulars, unless specifically noted otherwise.
- 11. Strengthening and Repair of Existing Structures.** This clause contains basic information pertinent to the welded modification or repair of existing steel structures.

1.2 Standard Units of Measurement

This standard makes use of both U.S. Customary Units and the International System of Units (SI). The latter are shown within brackets ([]) or in appropriate columns in tables and figures. The measurements may not be exact equivalents; therefore, each system must be used independently.

1.3 Safety Precautions

Safety and health issues and concerns are beyond the scope of this standard and therefore are not fully addressed herein. It is the responsibility of the user to establish appropriate safety and health practices. Safety and health information is available from the following sources:

American Welding Society:

- (1) ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*
- (2) AWS Safety and Health Fact Sheets
- (3) Other safety and health information on the AWS website

Material or Equipment Manufacturers:

- (1) Safety Data Sheets supplied by materials manufacturers
- (2) Operating Manuals supplied by equipment manufacturers

Applicable Regulatory Agencies

Work performed in accordance with this standard may involve the use of materials that have been deemed hazardous, and may involve operations or equipment that may cause injury or death. This standard does not purport to address all safety and health risks that may be encountered. The user of this standard should establish an appropriate safety program to address such risks as well as to meet applicable regulatory requirements. ANSI Z49.1 should be considered when developing the safety program.

1.4 Limitations

The code was specifically developed for welded steel structures that utilize carbon or low-alloy steels that are 1/8 in [3 mm] or thicker with a minimum specified yield strength of 100 ksi [690 MPa] or less. The code may be suitable to govern structural fabrications outside the scope of the intended purpose. However, the Engineer should evaluate such suitability, and based upon such evaluations, incorporate into contract documents any necessary changes to code requirements to address the specific requirements of the application that is outside the scope of the code. The Structural Welding Committee encourages the Engineer to consider the applicability of other AWS D1 codes for applications involving aluminum (AWS D1.2/D1.2M), sheet steel equal to or less than 3/16 in [5 mm] thick (AWS D1.3/D1.3M), reinforcing steel (AWS D1.4/D1.4M), stainless steel (AWS D1.6/D1.6M), strengthening and repair of existing structures (AWS D1.7/D1.7M), seismic supplement (AWS D1.8/D1.8M), and titanium (AWS D1.9/D1.9M). The AASHTO/AWS D1.5M/D1.5 *Bridge Welding Code* was specifically developed for welding highway bridge components and is recommended for those applications.

1.5 Responsibilities

1.5.1 Engineer's Responsibilities. The Engineer shall be responsible for the development of the contract documents that govern products or structural assemblies produced under this code. The Engineer may add to, delete from, or otherwise modify, the requirements of this code to meet the particular requirements of a specific structure. All requirements that modify this code shall be incorporated into contract documents. The Engineer shall determine the suitability of all joint details to be used in a welded assembly.

The Engineer shall specify in contract documents, as necessary, and as applicable, the following:

- (1) Code requirements that are applicable only when specified by the Engineer.
- (2) All additional NDT that is not specifically addressed in the code.
- (3) Extent of verification inspection, when required.
- (4) Weld acceptance criteria other than that specified in Clause 8.
- (5) CVN toughness criteria for weld metal, base metal, and/or HAZ when required.

- (6) For tubular and nontubular applications, whether the structure is statically or cyclically loaded.
- (7) Which welded joints are loaded in tension.
- (8) All additional requirements that are not specifically addressed in the code.
- (9) For OEM applications, the responsibilities of the parties involved.

1.5.2 Contractor's Responsibilities. The Contractor shall be responsible for WPSs, qualification of welding personnel, the Contractor's inspection, and performing work in conformance with the requirements of this code and contract documents.

1.5.3 Inspector's Responsibilities

1.5.3.1 Contractor Inspection. Contractor inspection shall be supplied by the Contractor and shall be performed as necessary to ensure that materials and workmanship meet the requirements of the contract documents.

1.5.3.2 Verification Inspection. The Engineer shall determine if verification inspection shall be performed. Responsibilities for verification inspection shall be established between the Engineer and the Verification Inspector.

1.6 Approval

All references to the need for approval shall be interpreted to mean approval by the Authority Having Jurisdiction or the Engineer.

1.7 Mandatory and Nonmandatory Provisions

1.7.1 Code Terms "Shall," "Should," and "May." "Shall," "should," and "may" have the following significance:

1.7.1.1 Shall. Code provisions that use "shall" are mandatory unless specifically modified in contract documents by the Engineer.

1.7.1.2 Should. The word "should" is used to recommend practices that are considered beneficial, but are not requirements.

1.7.1.3 May. The word "may" in a provision allows the use of optional procedures or practices that can be used as an alternative or supplement to code requirements. Those optional procedures that require the Engineer's approval shall either be specified in the contract documents, or require the Engineer's approval. The Contractor may use any option without the Engineer's approval when the code does not specify that the Engineer's approval shall be required.

1.8 Welding Symbols

Welding symbols shall be those shown in AWS A2.4, *Standard Symbols for Welding, Brazing, and Nondestructive Examination*. Special conditions shall be fully explained by added notes or details.

2. Normative References

The documents listed below are referenced within this publication and are mandatory to the extent specified herein. For undated references, the latest edition of the referenced standard shall apply. For dated references, subsequent amendments or revisions of the publications may not apply since the relevant requirements may have changed.

American Welding Society (AWS) Standards:

AWS A2.4, *Standard Symbols for Welding, Brazing, and Nondestructive Examination*

AWS A3.0M/A3.0, *Standard Welding Terms and Definitions, Including Terms for Adhesive Bonding, Brazing, Soldering, Thermal Cutting, and Thermal Spraying*

AWS A4.3, *Standard Methods for Determination of the Diffusible Hydrogen Content of Martensitic, Bainitic, and Ferritic Steel Weld Metal Produced by Arc Welding*

AWS A5.01M/A5.01 (ISO 14344:2010 MOD), *Welding and Brazing Consumables—Procurement of Filler Materials and Fluxes*

AWS A5.1/A5.1M, *Specification for Carbon Steel Electrodes for Shielded Metal Arc Welding*

AWS A5.5/A5.5M, *Specification for Low-Alloy Steel Electrodes for Shielded Metal Arc Welding*

AWS A5.12M/A5.12 (ISO 6848 MOD), *Specification for Tungsten and Oxide Dispersed Tungsten Electrodes for Arc Welding and Cutting*

AWS A5.17/A5.17M, *Specification for Carbon Steel Electrodes and Fluxes for Submerged Arc Welding*

AWS A5.18/A5.18M, *Specification for Carbon Steel Electrodes and Rods for Gas Shielded Arc Welding*

AWS A5.20/A5.20M, *Specification for Carbon Steel Electrodes for Flux Cored Arc Welding*

AWS A5.23/A5.23M, *Specification for Low-Alloy and High Manganese Steel Electrodes and Fluxes for Submerged Arc Welding*

AWS A5.25/A5.25M, *Specification for Carbon and Low-Alloy Steel Electrodes and Fluxes for Electroslag Welding*

AWS A5.26/A5.26M, *Specification for Carbon and Low-Alloy Steel Electrodes for Electrode Gas Welding*

AWS A5.28/A5.28M, *Specification for Low-Alloy Steel Electrodes and Rods For Gas Shielded Arc Welding*

AWS A5.29/A5.29M, *Specification for Low-Alloy Steel Electrodes for Flux Cored Arc Welding*

AWS A5.30/A5.30M, *Specification for Consumable Inserts*

AWS A5.32M/A5.32 (ISO 14175:2008 MOD), *Welding Consumables—Gases and Gas Mixtures for Fusion Welding and Allied Processes*

AWS B5.1, *Specification for the Qualification of Welding Inspectors*

AWS B4.0, *Standard Methods for Mechanical Testing of Welds*

AWS C4.1-77, *Set, Criteria for Describing Oxygen-Cut Surfaces, and Oxygen Cutting Surface Roughness Gauge*

AWS D1.0, *Code for Welding in Building Construction*

AWS D1.8/D1.8M, *Structural Welding Code—Seismic Supplement*

AWS D2.0, *Specifications for Welded Highway and Railway Bridges*

AWS QC1, *Standard for AWS Certification of Welding Inspectors*

ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*

American Institute of Steel Construction (AISC) Standards:

ANSI/AISC 360, *Specification for Structural Steel Buildings*

American Petroleum Institute (API) Standards:

API Spec 2W, *Specification for Steel Plates for Offshore Structures, Produced by Thermo-Mechanical Control Processing (TMCP)*

API Spec 2Y, *Specification for Steel Plates, Quenched and- Tempered, for Offshore Structures*

American Society of Mechanical Engineers (ASME) Standards:

ASME Boiler and Pressure Vessel Code, Section V, Article 2

ASME B46.1, *Surface Texture (Surface Roughness, Waviness, and Lay)*

American Society for Nondestructive Testing (ASNT) Standards:

ASNT CP-189, *ASNT Standard for Qualification and Certification of Nondestructive Testing Personnel*

ASNT Recommended Practice No. SNT-TC-1A, *Personnel Qualification and Certification in Nondestructive Testing*

American Society for Testing and Materials (ASTM) Standards:

All ASTM base metals listed in Table 5.6 and Table 6.10 are found in ASTM Volume 01.01, *Steel-Piping, Tubing, Fittings, ASTM Volume 01.02, Ferrous Castings; Ferroalloys*, ASTM Volume 01.03, *Steel-Plate, Sheet, Strip, Wire; Stainless Steel Bar*, or ASTM Volume 01.04, *Steel—Structural, Reinforcing, Pressure Vessel, Railway*

ASTM A6/A6M, *Standard Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling*

ASTM A109/A109M, *Standard Specification for Steel, Strip, Carbon, (0.25 Maximum Percent), Cold-Rolled*

ASTM A370, *Standard Test Methods and Definitions for Mechanical Testing of Steel Products*

ASTM A435/A435M, *Standard Specification for Straight Beam Ultrasonic Examination of Steel Plates*

ASTM A673/A673M, *Standard Specification for Sampling Procedure for Impact Testing of Structural Steel*

ASTM E23, *Standard Test Methods for Notched Bar Impact Testing of Metallic Materials*

ASTM E92, *Standard Test Methods for Vickers Hardness and Knoop Hardness of Metallic Materials*

ASTM E94/E94M, *Standard Guide for Radiographic Examination Using Industrial Radiographic Film*

ASTM E140, *Standard Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, Scleroscope Hardness, and Leeb Hardness*

ASTM E165/E165M, *Standard Practice for Liquid Penetrant Testing for General Industry*

ASTM E747, *Standard Practice for Design, Manufacture and Material Grouping Classification of Wire Image Quality Indicators (IQI) Used for Radiography*

ASTM E1032, *Standard Practice for Radiographic Examination of Weldments Using Industrial X-Ray Film*

ASTM E1254, *Standard Guide for Storage of Radiographs and Unexposed Industrial Radiographic Films*

ASTM E2033/E2033M, *Standard Practice for Radiographic Examination Using Computed Radiology (Photostimulable Luminescence Method)*

ASTM 2339, *Standard Practice for Digital Imaging and Communication in Nondestructive Evaluation (DICONDE)*

ASTM E2445/E2445M, *Standard Practice for Performance Evaluation and Long-Term Stability of Computed Radiography Systems*

ASTM E2698, *Standard Practice for Radiological Examination Using Digital Detector Arrays*

ASTM E2699, *Standard Practice for Digital Imaging and Communication in Nondestructive Evaluation (DICONDE) for Digital X-ray (DR) Test Methods.*

ASTM E2737, *Standard Practice for Digital Detector Array Performance Evaluation and Long-Term Stability*

ASTM E3024/E3024M, *Standard Practice for Magnetic Particle Testing for General Industry*

The Association for Materials Protection and Performance (AMPP) Standards:

SSPC-SP2, *Surface Preparation Standard No. 2—Hand Tool Cleaning*

Canadian Standards Association (CSA) Standards:

CSA W178.2, *Certification of Welding Inspectors*

International Institute of Welding (IIW) Ultrasonic Reference Block

3. Terms and Definitions

AWS A3.0M/A3.0, *Standard Welding Terms and Definitions, Including Terms for Adhesive Bonding, Brazing, Soldering, Thermal Cutting, and Thermal Spraying*, provides the basis for terms and definitions used herein. However, the following terms and definitions are included below to accommodate usage specific to this document.

The terms and definitions in this glossary are divided into three categories: (1) general welding terms compiled by the AWS Committee on Definitions and Symbols; (2) terms, defined by the AWS Structural Welding Committee, which apply only to UT, designated by (UT) following the term; and (3) other terms, preceded by asterisks, which are defined as they relate to this code.

For the purposes of this document, the following terms and definitions apply:

A

***allowable strength.** The strength of an element when compared to Allowable Strength Design (ASD) loads calculated as nominal strength divided by the safety factor, R_n .

***alloy flux.** A flux upon which the alloy content of the weld metal is largely dependent.

***all-weld-metal test specimen.** A test specimen with the reduced section composed wholly of weld metal.

***amplitude length rejection level (UT).** The maximum length of discontinuity allowed by various indication ratings associated with weld size, as indicated in Tables 8.2 and 8.3.

***angle of bevel.** See **bevel angle**.

arc gouging. Thermal gouging that uses an arc cutting process variation to form a bevel or groove.

as-welded. The condition of weld metal, welded joints, and weldments after welding, but prior to any subsequent thermal, mechanical, or chemical treatments.

***attenuation (UT).** The loss in acoustic energy which occurs between any two points of travel. This loss may be due to absorption, reflection, etc. (In this code, using the shear wave pulse-echo method of testing, the attenuation factor is 2 dB per inch of sound path distance after the first inch.)

automatic welding. Welding with equipment that requires only occasional or no observation of the welding, and no manual adjustment of the equipment controls. Variations of this term are **automatic brazing**, **automatic soldering**, **automatic thermal cutting**, and **automatic thermal spraying**.

***auxiliary attachments.** Members or appurtenances attached to main stress-carrying members by welding. Such members may or may not carry loads.

***available strength.** The design strength (LRFD) or allowable strength (ASD), as applicable.

average instantaneous power (AIP), waveform-controlled welding. The average of products of amperages and voltages determined at sampling frequencies sufficient to quantify waveform changes during a welding interval.

axis of a weld. See **weld axis**.

B

backgouging. The removal of weld metal and base metal from the weld root side of a welded joint to facilitate complete fusion and CJP upon subsequent welding from that side.

backing. A material or device placed against the back side of the joint, or at both sides of a weld in ESW and EGW, to support and retain molten weld metal. The material may be partially fused or remain unfused during welding and may be either metal or nonmetal.

backing pass. A weld pass made for a backing weld.

backing ring. Backing in the form of a ring, generally used in the welding of pipe.

backing weld. Backing in the form of a weld.

***backup weld (tubular structures).** The initial closing pass in a CJP groove weld, made from one side only, which serves as a backing for subsequent welding, but is not considered as a part of the theoretical weld (Figures 10.9 through 10.11, Details C and D).

back weld. A weld made at the back of a single groove weld.

base metal. The metal or alloy that is welded, brazed, soldered, or cut.

bevel angle. The angle between the bevel of a joint member and a plane perpendicular to the surface of the member.

box tubing. Tubular product of square or rectangular cross section. See **tubular**.

***brace intersection angle, θ (tubular structures).** The acute angle formed between brace centerlines.

***Building Code.** The building law or specification or other construction regulations in conjunction with which this code is applied.

NOTE: In the absence of any locally applicable building law or specifications or other construction regulations, it is recommended that the construction be required to comply with the ANSI/AISC 360, Specification for Structural Steel Buildings.

butt joint. A joint between two members aligned approximately in the same plane.

butt weld. A nonstandard term for a weld in a butt joint. See **butt joint**.

C

***cap pass.** One or more weld passes that form the weld face (exposed surface of completed weld). Adjacent cap passes may partially cover, but not completely cover, a cap pass.

***caulking.** Plastic deformation of weld and base metal surfaces by mechanical means to seal or obscure discontinuities.

complete fusion. Fusion over the entire fusion faces and between all adjoining weld beads.

complete joint penetration (CJP). A joint root condition in a groove weld in which weld metal extends through the joint thickness.

***computed radiography (CR).**

***CJP groove weld (statically and cyclically loaded structures).** A groove weld which has been made from both sides or from one side on a backing having CJP and fusion of weld and base metal throughout the depth of the joint.

***CJP groove weld (tubular structures).** A groove weld having CJP and fusion of weld and base metal throughout the depth of the joint or as detailed in Figures 10.4, 10.7 through 10.11, and 10.18. A CJP tubular groove weld made from one side only, without backing, is allowed where the size or configuration, or both, prevent access to the root side of the weld.

complete penetration. A nonstandard term for **CJP**. See **complete joint penetration**.

construction aid weld. A weld made to attach a piece or pieces to a weldment for temporary use in handling, shipping, or working on the structure.

consumable guide ESW. See **ESW, consumable guide.**

continuous weld. A weld that extends continuously from one end of a joint to the other. Where the joint is essentially circular, it extends completely around the joint.

contouring fillet welds. Fillet welds applied over CJP and PJP groove welds in butt joints joining parts of unequal width or thickness, corner joints, and T-joints for the purpose of reducing the severity of abrupt changes in the surface.

***contract documents.** Any codes, specifications, drawings, or additional requirements that are contractually specified by the Owner.

***Contractor.** Any company, or that individual representing a company, responsible for the fabrication, erection, manufacturing, or welding, in conformance with the provisions of this code.

***Contractor's Inspector.** The duly designated person who acts for, and in behalf of, the Contractor on all inspection and quality matters within the scope of the code and the contract documents.

corner joint. A joint between two members located approximately at right angles to each other in the form of an L.

***cover pass.** See **cap pass.**

CO₂ welding. A nonstandard term for **GMAW** with carbon dioxide shielding gas.

crater. A depression in the weld face at the termination of a weld bead.

***Charpy V-Notch (CVN).**

D

***digital detector array (DDA).**

***decibel (dB) (UT).** The logarithmic expression of a ratio of two amplitudes or intensities of acoustic energy.

***decibel rating (UT).** See preferred term **indication rating.**

defect. A discontinuity or discontinuities that by nature or accumulated effect (for example, total crack length) render a part or product unable to meet minimum applicable acceptance standards or specifications. This term designates rejectability.

defective weld. A weld containing one or more defects.

***defect level (UT).** See **indication level.**

***defect rating (UT).** See **indication rating.**

depth of fusion. The distance that fusion extends into the base metal or previous bead from the surface melted during welding.

***design strength.** The strength of an element when compared to Load and Resistance Factor Design (LRFD) loads calculated as resistance factor multiplied by the nominal strength, ϕR_n .

***dihedral angle.** See **local dihedral angle.**

discontinuity. An interruption of the typical structure of a material, such as a lack of homogeneity in its mechanical, metallurgical, or physical characteristics. A discontinuity is not necessarily a defect.

downhand. A nonstandard term for **flat welding position.**

***direct radiography (DR).**

***drawings.** Refers to plans, design and detail drawings, and erection plans.

E

***edge angle (tubular structures).** The acute angle between a bevel edge made in preparation for welding and a tangent to the member surface, measured locally in a plane perpendicular to the intersection line. All bevels open to outside of brace.

***effective length of weld.** The length throughout which the correctly proportioned cross section of the weld exists. In a curved weld, it shall be measured along the weld axis.

electrogas welding (EGW). An arc welding process that uses an arc between a continuous filler metal electrode and the weld pool, employing approximately vertical welding progression with backing to confine the molten weld metal. The process is used with or without an externally supplied shielding gas and without the application of pressure.

electroslag welding (ESW). A welding process that produces coalescence of metals with molten slag that melts the filler metal and the surfaces of the workpieces. The weld pool is shielded by this slag, which moves along the full cross section of the joint as welding progresses. The process is initiated by an arc that heats the slag. The arc is then extinguished by the conductive slag, which is kept molten by its resistance to electric current passing between the electrode and the workpieces.

ESW, consumable guide. An electroslag welding process variation in which filler metal is supplied by an electrode and its guiding member.

***end return.** The continuation of a fillet weld around a corner of a member as an extension of the principal weld.

***Engineer.** A duly designated individual who acts for and in behalf of the Owner on all matters within the scope of the code.

F

***false indication.** An NDT indication that is interpreted to be caused by a condition other than a discontinuity or imperfection.

***fatigue.** Fatigue, as used herein, is defined as the damage that may result in fracture after a sufficient number of stress fluctuations. Stress range is defined as the peak-to-trough magnitude of these fluctuations. In the case of stress reversal, stress range shall be computed as the numerical sum (algebraic difference) of maximum repeated tensile and compressive stresses, or the sum of shearing stresses of opposite direction at a given point, resulting from changing conditions of load.

faying surface. The mating surface of a member that is in contact with or in close proximity to another member to which it is to be joined.

filler metal. The metal or alloy to be added in making a welded, brazed, or soldered joint.

fillet weld leg. The distance from the joint root to the toe of the fillet weld.

fin. A defect in a bar or other rolled section caused by the steel spreading into the clearance between the rolls. This produces a thick overfill which, if rolled again, usually becomes a lap.

flare-bevel-groove weld. A weld in the groove formed between a joint member with a curved surface and another with a planar surface.

***flash, arc stud welding.** Solidified metal formed by the expulsion of molten metal displaced from a stud weld joint beyond the original stud base diameter.

flat welding position. The welding position used to weld from the upper side of the joint at a point where the weld axis is approximately horizontal, and the weld face lies in an approximately horizontal plane.

flux cored arc welding (FCAW). An arc welding process that uses an arc between a continuous filler metal electrode and the weld pool. The process is used with shielding gas from a flux contained within the tubular electrode, with or without additional shielding from an externally supplied gas, and without the application of pressure.

***flux cored arc welding—gas shielded (FCAW-G).** A flux cored arc welding process variation in which additional shielding is obtained from an externally supplied gas or gas mixture.

***flux cored arc welding—self shielded (FCAW-S).** A flux cored arc welding process where shielding is exclusively provided by a flux contained within the tubular electrode.

fusion. The melting together of filler metal and base metal (substrate), or of base metal only, to produce a weld.

fusion line. The boundary between weld metal and base metal in a fusion weld.

***fusion-type discontinuity.** Signifies slag inclusion, incomplete fusion, incomplete joint penetration, and similar discontinuities associated with fusion.

fusion zone. The area of base metal melted as determined on the cross section of a weld.

G

gas metal arc welding (GMAW). An arc welding process that uses an arc between a continuous filler metal electrode and the weld pool. The process is used with shielding from an externally supplied gas and without the application of pressure.

gas metal arc welding—short circuit arc (GMAW-S). A gas metal arc welding process variation in which the consumable electrode is deposited during repeated short circuits.

gas pocket. A nonstandard term for **porosity**.

geometric unsharpness (U_g). The fuzziness or lack of definition in a radiographic image resulting from the combination of source size, object-to-film distance, and source-to-object distance.

gouging. See **thermal gouging**.

groove angle. The total included angle of the groove between workpieces.

***groove angle, ϕ (tubular structures).** The angle between opposing faces of the groove to be filled with weld metals, determined after the joint is fit-up.

groove face. The surface of a joint member included in the groove.

groove weld. A weld made in the groove between the workpieces.

H

heat-affected zone (HAZ). The portion of the base metal whose mechanical properties or microstructure have been altered by the heat of welding, brazing, soldering, or thermal cutting.

***hold-back.** The unwelded portion of a joint where a fillet weld is intentionally started or stopped away from the end of the joint.

horizontal fixed position (pipe welding). The position of a pipe joint in which the axis of the pipe is approximately horizontal, and the pipe is not rotated during welding (see Figures 6.1, 6.2, 10.12, and 10.13).

horizontal welding position, fillet weld. The welding position in which the weld is on the upper side of an approximately horizontal surface and against an approximately vertical surface (see Figures 6.2 and 6.4).

***horizontal reference line (UT).** A horizontal line near the center of the UT instrument scope to which all echoes are adjusted for dB reading.

horizontal rotated position (pipe welding). The position of a pipe joint in which the axis of the pipe is approximately horizontal, and welding is performed in the flat position by rotating the pipe (see Figures 6.1, 6.2, 10.12, and 10.13).

***hot-spot strain (tubular structures).** The cyclic total range of strain which would be measured at the point of highest stress concentration in a welded connection.

NOTE: When measuring hot-spot strain, the strain gauge should be sufficiently small to avoid averaging high and low strains in the regions of steep gradients.

I

***image quality indicator (IQI).** A device whose image in a radiograph is used to determine RT quality level. It is not intended for use in judging the size nor for establishing acceptance limits of discontinuities.

***indication (MT or PT).** The visual representation of a discontinuity enhanced by the application of NDT surface materials.

***indication (UT).** The signal displayed on the oscilloscope signifying the presence of a sound wave reflector in the part being tested.

***indication level (UT).** The calibrated gain or attenuation control reading obtained for a reference line height indication from a discontinuity.

***indication rating (UT).** The decibel reading in relation to the zero reference level after having been corrected for sound attenuation.

intermittent weld. A weld in which the continuity is broken by recurring unwelded spaces.

***interpass temperature.** In a multipass weld, the temperature of the weld area between weld passes (see preheat temperature, welding).

J

joint. The junction of members or the edges of members that are to be joined or have been joined.

joint penetration. The distance the weld metal extends from the weld face into a joint, exclusive of weld reinforcement.

joint root. That portion of a joint to be welded where the members approach closest to each other. In cross section, the joint root may be either a point, a line, or an area.

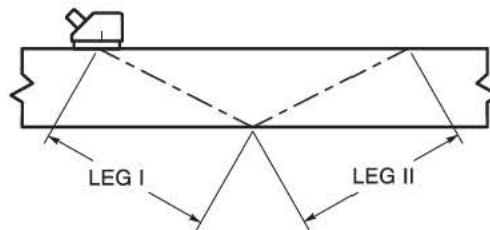
L

lap joint. A joint between two overlapping members in parallel planes.

***layer.** A stratum of weld metal or surfacing material. The layer may consist of one or more weld beads laid side by side.

***leg (UT).** The path the shear wave travels in a straight line before being reflected by the surface of material being tested.

See sketch for leg identification. Note: Leg I plus leg II equals one V-path.



leg of a fillet weld. See fillet weld leg.

***local dihedral angle, Ψ (tubular structures).** The angle, measured in a plane perpendicular to the line of the weld, between tangents to the outside surfaces of the tubes being joined at the weld. The exterior dihedral angle, where one looks at a localized section of the connection, such that the intersecting surfaces may be treated as planes.

M

manual welding. Welding with the torch, gun or electrode holder held and manipulated by hand. Accessory equipment, such as part motion devices and manually controlled filler material feeders may be used. See **automatic welding**, **mechanized welding**, and **semiautomatic welding**.

matching strength filler metal. For materials listed in Table 5.6, matching filler metals are those in the corresponding groups in Table 5.7. For materials listed in Table 6.10 matching filler metals are those in corresponding groups in Table 6.10. For unlisted materials, matching strength filler metal is a filler metal that when classified in accordance with a recognized standard, has a specified minimum tensile strength in the joint in accordance with 4.4.1.1.

mechanized process (XXXX-ME). An operation with equipment requiring manual adjustment by an operator in response to visual observation, with the torch, gun, wire guide assembly, or electrode holder held by a mechanical device.

mechanized welding (W-ME). See **mechanized process**.

***magnetic particle testing (MT).**

N

***nondestructive testing (NDT).** The process of determining acceptability of a material or a component in accordance with established criteria without impairing its future usefulness.

***node (UT).** See **leg**.

***nominal tensile strength of the weld metal.** The tensile strength of the weld metal indicated by the classification number of the filler metal (e.g., nominal tensile strength of E60XX is 60 ksi [420 MPa]).

O

***Original Equipment Manufacturer (OEM).** A single Contractor that assumes some or all of the responsibilities assigned by this code to the Engineer.

overhead welding position. The welding position in which welding is performed from the underside of the joint (see Figures 6.1, 6.2, 6.3, and 6.4).

overlap, fusion welding. The protrusion of weld metal beyond the weld toe or weld root.

overmatching strength filler metal. Overmatching strength filler metal is filler metal that, when classified in accordance with the applicable AWS A5 specification, has a specified minimum tensile strength that is greater than the strength level of matching filler metals.

***Owner.** The individual or company that exercises legal ownership of the product or structural assembly produced to this code.

oxygen cutting (OC). A group of thermal cutting processes that severs or removes metal by means of the chemical reaction between oxygen and the base metal at elevated temperature. The necessary temperature is maintained by the heat from an arc, an oxyfuel gas flame, or other source.

oxygen gouging. Thermal gouging that uses an oxygen cutting process variation to form a bevel or groove.

P

***parallel electrode.** See **SAW**.

partial joint penetration (PJP). Joint penetration that is intentionally less than complete.

pass. See **weld pass**.

peening. The mechanical working of metals using impact blows.

***pipe.** Hollow circular cross section produced or manufactured in accordance with a pipe product specification. See **tubular**.

***piping porosity (ESW and EGW).** Elongated porosity whose major dimension lies in a direction approximately parallel to the weld axis.

***piping porosity (general).** Elongated porosity whose major dimension lies in a direction approximately normal to the weld surface. Frequently referred to as *pin holes* when the porosity extends to the weld surface.

plug weld. A weld made in a circular hole in one member of a joint fusing that member to another member. A fillet-welded hole shall not be construed as conforming to this definition.

porosity. Cavity-type discontinuities formed by gas entrapment during solidification or in a thermal spray deposit.

positioned weld. A weld made in a joint that has been placed to facilitate making the weld.

***postweld heat treatment.** Any heat treatment after welding.

preheating. The application of heat to the base metal immediately before welding, brazing, soldering, thermal spraying, or cutting.

***preheat temperature, *welding*.** The temperature of the base metal in the volume surrounding the point of welding immediately before welding is started. In a multiple-pass weld, it is also the temperature immediately before the second and subsequent passes are started.

***liquid penetrant testing (PT).**

***postweld heat treatment (PWHT).**

Q

qualification. See **welder performance qualification** and **WPS qualification**.

R

random sequence. A longitudinal sequence in which the weld bead increments are made at random.

***reference level (UT).** The decibel reading obtained for a horizontal reference-line height indication from a reference reflector.

***reference reflector (UT).** The reflector of known geometry contained in the IIW reference block or other approved blocks.

reinforcement of weld. See **weld reinforcement**.

***resolution (UT).** The ability of UT equipment to give separate indications from closely spaced reflectors.

root face. That portion of the groove face within the joint root.

root gap. A nonstandard term for **root opening**.

root of joint. See **joint root**.

root of weld. See **weld root**.

root opening. A separation at the joint root between the workpieces.

***radiographic testing (RT).**

S

***scanning level (UT).** The dB setting used during scanning, as described in Tables 8.2 and 8.3.

semiautomatic welding. Manual welding with equipment that automatically controls one or more of the welding conditions.

***shelf bar.** Steel plates, bars, or similar elements used to support the overflow of excess weld metal deposited in a horizontal groove weld joint.

shielded metal arc welding (SMAW). An arc welding process with an arc between a covered electrode and the weld pool. The process is used with shielding from the decomposition of the electrode covering, without the application of pressure, and with filler metal from the electrode.

shielding gas. Protective gas used to prevent or reduce atmospheric contamination.

single-welded joint. A joint that is welded from one side only.

size of weld. See **weld size**.

slot weld. A weld made in an elongated hole in one member of a joint fusing that member to another member. The hole may be open at one end. A fillet welded slot shall not be construed as conforming to this definition.

***sound beam distance (UT).** See **sound path distance**.

***sound path distance (UT).** The distance between the search unit test material interface and the reflector as measured along the centerline of the sound beam.

***storage phosphor imaging plate (SPIP).**

spatter. The metal particles expelled during fusion welding that do not form a part of the weld.

stringer bead. A type of weld bead made without appreciable weaving motion.

***stud base.** The stud tip at the welding end, including flux and container, and 1/8 in [3 mm] of the body of the stud adjacent to the tip.

***stud welding (SW).** An arc welding process that produces coalescence of metals by heating them with an arc between a metal stud, or similar part, and the other workpiece. When the surfaces to be joined are properly heated, they are brought together under pressure. Partial shielding may be obtained by the use of a ceramic ferrule surrounding the stud. Shielding gas or flux may or may not be used.

submerged arc welding (SAW). An arc welding process that uses an arc or arcs between a bare metal electrode or electrodes and the weld pool. The arc and molten metal are shielded by a blanket of granular flux on the workpieces. The process is used without pressure and with filler metal from the electrode and sometimes from a supplemental source (welding rod, flux, or metal granules).

***single electrode.** One electrode connected exclusively to one power source which may consist of one or more power units.

***multiple electrodes.** The combination of two or more single or parallel electrode systems. Each of the component systems has its own independent power source and its own electrode feeder.

***parallel electrode.** Two electrodes connected electrically in parallel and exclusively to the same power source. Both electrodes are usually fed by means of a single electrode feeder. Welding current, when specified, is the total for the two.

supplemental filler metal, submerged arc welding. Metal introduced into the weld other than the consumable electrode(s).

T

tack weld. A weld made to hold parts of a weldment in proper alignment until the final welds are made.

***tack welder.** A fitter, or someone under the direction of a fitter, who tack welds parts of a weldment to hold them in proper alignment until the final welds are made.

***tandem.** Refers to a geometrical arrangement of electrodes in which a line through the arcs is parallel to the direction of welding.

thermal gouging. A thermal cutting process variation that removes metal by melting or burning the entire removed portion, to form a bevel or groove.

throat of a fillet weld.

actual throat. The shortest distance between the weld root and the face of a fillet weld.

theoretical throat. The distance from the beginning of the joint root perpendicular to the hypotenuse of the largest right triangle that can be inscribed within the cross section of a fillet weld. This dimension is based on the assumption that the root opening is equal to zero.

throat of a groove weld. A nonstandard term for **groove weld size**.

T-joint. A joint between two members located approximately at right angles to each other in the form of a T.

toe of weld. See **weld toe**.

***transverse discontinuity.** A weld discontinuity whose major dimension is in a direction perpendicular to the weld axis “X,” see Annex O, Form O-11.

total instantaneous energy (TIE), waveform-controlled welding. The sum of products of amperages, voltages and time intervals determined at sampling frequencies sufficient to quantify waveform changes during a welding interval.

***tubular.** A generic term that refers to sections including pipe products (see **pipe**) and the family of square, rectangular, and round hollow-section products produced or manufactured in accordance with a tubular product specification. Also referred to as hollow structural section (HSS).

***tubular connection.** A connection in the portion of a structure that contains two or more intersecting members, at least one of which is a tubular member.

***tubular joint.** A joint in the interface created by a tubular member intersecting another member (which may or may not be tubular).

U

***ultrasonic testing (UT).**

***unacceptable discontinuity.** See **defect**.

undercut. A groove melted into the base metal adjacent to the weld toe or weld root and left unfilled by weld metal.

undermatching strength filler metal. Undermatching strength filler metal is filler metal that, when classified in accordance with the applicable AWS A5 specification, has a specified minimum tensile strength that is less than the strength level of matching filler metals.

V

***Verification Inspector.** The duly designated person who acts for, and in behalf of, the Owner on all inspection and quality matters designated by the Engineer.

vertical welding position. The welding position in which the weld axis, at the point of welding, is approximately vertical, and the weld face lies in an approximately vertical plane (see Figures 6.1, 6.2, 6.3, and 6.4).

***vertical position (pipe welding).** The position of a pipe joint in which welding is performed in the horizontal position and the pipe is not rotated during welding (see Figures 6.1, 6.2, 10.12, and 10.13).

***V-path (UT).** The distance a shear wave sound beam travels from the search unit test material interface to the other face of the test material and back to the original surface.

W

weave bead. A type of weld bead made with transverse oscillation.

weld. A localized coalescence of metals or nonmetals produced by heating the materials to the welding temperature, with or without the application of pressure or by the applications of pressure alone and with or without the use of filler material.

weldability. The capacity of a material to be welded under the imposed fabrication conditions into a specific, suitably designed structure and to perform satisfactorily in the intended service.

weld axis. A line through the length of a weld, perpendicular to and at the geometric center of its cross section.

weld bead. A weld resulting from a pass. See **stringer bead** and **weave bead**.

welder. One who performs a manual or semiautomatic welding operation.

welder certification. Written certification that a welder has produced welds meeting a prescribed standard of welder performance.

welder performance qualification. The demonstration of a welder's ability to produce welds meeting prescribed standards.

weld face. The exposed surface of a weld on the side from which welding was done.

welding. A joining process that produces coalescence of materials by heating them to the welding temperature, with or without the application of pressure or by the application of pressure alone, and with or without the use of filler metal. See also the Master Chart of Welding and Joining Processes in the latest edition of AWS A3.0.

welding machine. Equipment used to perform the welding operation. For example, spot welding machine, arc welding machine, and seam welding machine.

welding operator. One who operates adaptive control, automatic, mechanized, or robotic welding equipment.

welding sequence. The order of making the welds in a weldment.

weld pass. A single progression of welding along a joint. The result of a pass is a weld bead or layer.

weld reinforcement. Weld metal in excess of the quantity required to fill a joint.

weld root. The points, as shown in cross section, at which the root surface intersects the base metal surfaces.

weld size.

fillet weld size. For equal leg fillet welds, the leg lengths of the largest isosceles right triangle that can be inscribed within the fillet weld cross section. For unequal leg fillet welds, the leg lengths of the largest right triangle that can be inscribed within the fillet weld cross section.

NOTE: When one member makes an angle with the other member greater than 105°, the leg length (size) is of less significance than the effective throat, which is the controlling factor for the strength of the weld.

groove weld size. The joint penetration of a groove weld.

weld tab. Additional material that extends beyond either end of the joint, on which the weld is started or terminated.

weld toe. The junction of the weld face and the base metal.

weldment. An assembly whose component parts are joined by welding.

WPS qualification. The demonstration that welds made by a specific procedure can meet prescribed standards.

***welding procedure specification (WPS).** A document providing the detailed methods and practices involved in the production of a weldment.

4. Design of Welded Connections

4.1 Scope

This clause contains requirements for design of welded connections. It is divided into three parts as follows:

Part A—Common Requirements for Design of Welded Connections (Nontubular and Tubular Members)

Part B—Specific Requirements for Design of Nontubular Connections (Statically or Cyclically Loaded). The requirements shall apply in addition to the requirements of Part A.

Part C—Specific Requirements for Design of Nontubular Connections (Cyclically Loaded). When applicable, the requirements shall apply in addition to the requirements of Parts A and B.

Part A *Common Requirements for Design of Welded Connections* *(Nontubular and Tubular Members)*

4.2 General

This part contains requirements applicable to the design of all welded connections of nontubular and tubular structures, independent of loading.

4.3 Contract Plans and Specifications

4.3.1 Plan and Drawing Information. Complete information regarding base metal specification designation (see 5.3 and 6.8.3) and location, type, size, and extent of all welds shall be clearly shown on the contract plans and specifications, hereinafter referred to as the contract documents. If the Engineer requires specific welds to be performed in the field, they shall be designated in the contract documents. The fabrication and erection drawings, hereinafter referred to as the shop drawings, shall clearly distinguish between shop and field welds.

4.3.2 CVN Toughness Requirements. If CVN toughness of welds is required, the Engineer shall specify one of the following:

4.3.2.1 When a filler metal meeting the minimum notch toughness requirements by classification is specified, the contract documents shall list the following for filler metal classification or classifications to be used:

- (1) The minimum absorbed energy per the appropriate AWS A5 filler metal specification, and
- (2) The corresponding test temperature for the filler metal classification.

4.3.2.2 When WPS qualification by testing with CVN tests are required, the Engineer shall specify that the WPSs be qualified by tests performed in accordance with Clause 6, Part D; and shall also specify:

- (1) the test temperature,
- (2) whether the required CVN test location is to be in the weld metal, the HAZ, or in both locations (see 6.2.1.3 and Clause 6, Part D), and

(3) an alternate location of the notch in the HAZ specimen if testing is required in HAZ at a location other than that required by Clause 6, Part D.

4.3.3 Specific Welding Requirements. The Engineer, in the contract documents, and the Contractor, in the shop drawings, shall indicate those joints or groups of joints in which the Engineer or Contractor require a specific assembly order, welding sequence, welding technique or other special precautions. See 7.4.1 and C-7.4.1 for limitations on the application of ESW and EGW welding.

4.3.4 Weld Size and Length. Contract design drawings shall specify the effective weld length and, for PJP groove welds, the required weld size “(S).” For fillet welds and skewed T-joints, the following shall be provided on the contract documents.

(1) For fillet welds between parts with surfaces meeting at an angle between 80° and 100° , contract documents shall specify the fillet weld leg size.

(2) For welds between parts with the surfaces meeting at an angle less than 80° or greater than 100° , the contract documents shall specify the effective throat.

End returns and hold-backs for fillet welds, if required by design, shall be indicated on the contract documents.

4.3.5 Shop Drawing Requirements. Shop drawings shall clearly indicate by welding symbols or sketches the details of groove welded joints and the preparation of base metal required to make them. Both width and thickness of steel backing shall be detailed.

4.3.5.1 PJP Groove Welds. Shop drawings shall indicate the weld groove depths “D” needed to attain weld size “(S)” required for the welding process and position of welding to be used.

4.3.5.2 Fillet Welds and Welds in Skewed T-Joints.

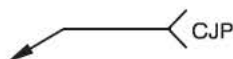
The following shall be provided on the shop drawings:

(1) For fillet welds between parts with surfaces meeting at an angle between 80° and 100° , shop drawings shall show the fillet weld leg size,

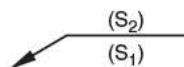
(2) For welds between parts with surfaces meeting at an angle less than 80° or greater than 100° , the shop drawings shall show the detailed arrangement of welds and required leg size to account for effects of joint geometry and, where appropriate, the Z-loss reduction for the process to be used and the angle,

(3) End returns and hold-backs.

4.3.5.3 Welding Symbols. The contract documents shall show CJP or PJP groove weld requirements. Contract documents do not need to show groove type or groove dimensions. The welding symbol without dimensions and with “CJP” in the tail designates a CJP weld as follows:



The welding symbol without dimension and without CJP in the tail designates a weld that will develop the adjacent base metal strength in tension and shear. A welding symbol for a PJP groove weld shall show dimensions enclosed in parentheses below “(S₁)” and/or above “(S₂)” the reference line to indicate the groove weld sizes on the arrow and other sides of the weld joint, respectively, as shown below:



4.3.5.4 Prequalified Detail Dimensions. The joint details described in 5.4.2 and 10.9 (PJP) and 5.4.1 and 10.10 (CJP) have repeatedly demonstrated their adequacy in providing the conditions and clearances necessary for depositing and fusing sound weld metal to base metal. However, the use of these details shall not be interpreted as implying consideration of the effects of welding process on base metal beyond the fusion boundary nor suitability of the joint detail for a given application.

4.3.5.5 Special Details. When special groove details are required, they shall be detailed in the contract documents.

4.3.5.6 Specific Inspection Requirements. Any specific inspection requirements shall be noted on the contract documents.

4.4 Base Metal/Filler Metal Strength Requirements

4.4.1 Matching, Undermatching and Overmatching Conditions

4.4.1.1 Matching Strength Filler Metal:

(1) For base metals not listed in Table 5.6 or Table 6.10 with a specified minimum yield strength equal to or greater than 60 ksi [415 MPa], the specified minimum tensile strength of the filler metal shall meet or exceed the specified minimum tensile strength of the lowest strength base metal in the joint but not by more than 10 ksi [70 MPa].

(2) For base metals not listed in Table 5.6 or Table 6.10 with a specified minimum yield strength less than 60 ksi [415 MPa], the specified minimum tensile strength of the filler metal shall not exceed the specified minimum tensile strength of the lowest strength base metal in the joint by more than 20 ksi [140 MPa].

(3) The filler metal/base metal combinations listed in Table 5.7 are matching strength filler metals for the base metal groupings listed.

When required by Table 4.3, matching strength filler metal shall be used.

4.4.1.2 Undermatching Strength Filler Metal.

(1) Filler metal that has a specified minimum tensile strength less than matching strength filler metal shall be considered undermatching strength filler metal.

(2) Undermatching filler metal may be used when permitted by Table 4.3. When undermatching strength filler metal is used, the tensile strength of the undermatching strength filler metal shall be used for design strength calculations.

4.4.1.3 Overmatching Strength Filler Metal. Filler metal that has a specified minimum tensile strength greater than matching strength filler metal shall be considered overmatching strength filler metal. Overmatching strength filler metal is not required by Table 4.3. See 4.4.2.2.

4.4.2 Required Strength Level

4.4.2.1 General. The required filler metal strength level shall be in accordance with Table 4.3.

4.4.2.2 Overmatching Filler Metal: When overmatching strength filler metal is used, the design strength of the connection shall be calculated using, matching strength filler metals.

4.5 Effective Areas

4.5.1 Groove Welds

4.5.1.1 Effective Length. The maximum effective weld length of any groove weld, regardless of orientation, shall be the width of the part joined, perpendicular to the direction of tensile or compressive stress. For groove welds transmitting shear, the effective length is the length specified.

4.5.1.2 Effective Size of CJP Groove Welds. The weld size of a CJP groove weld shall be the thickness of the thinner part joined. An increase in the effective area for design calculations for weld reinforcement shall be prohibited. Groove weld sizes for T-, Y-, and K-connections in tubular construction are shown in Table 10.7.

4.5.1.3 Minimum Size of PJP Groove Welds. PJP groove welds shall be equal to or greater than the size “(S)” specified in 5.4.2.3(1) unless the WPS is qualified in conformance with Clause 6.

4.5.1.4 Effective Size of Flare-Groove Welds. The effective size of flare-groove welds when filled flush shall be as shown in Table 4.1, except as allowed by 6.12.4. For flare-groove welds not filled flush, the underfill U shall be deducted. For flare-V-groove welds to surfaces with different radii R, the smaller R shall be used. For flare-groove welds to rectangular tubular sections, R shall be taken as two times the wall thickness.

4.5.1.5 Effective Area of Groove Welds. The effective area of groove welds shall be the effective length multiplied by the effective weld size.

4.5.2 Fillet Welds

4.5.2.1 Effective Length (Straight). The effective length of a straight fillet weld shall be the overall length of the full size fillet, including end returns. No reduction in effective length shall be assumed in design calculations to allow for the start or stop crater of the weld.

4.5.2.2 Effective Length (Curved). The effective length of a curved fillet weld shall be measured along the centerline of the effective throat.

4.5.2.3 Minimum Length. The minimum length of a fillet weld shall be at least four times the nominal size, or the effective size of the weld shall be considered not to exceed 25% of its effective length.

4.5.2.4 Intermittent Fillet Welds (Minimum Length). The minimum length of segments of an intermittent fillet weld shall be 1-1/2 in [38 mm].

4.5.2.5 Maximum Effective Length. For end-loaded fillet welds with a length up to 100 times the weld size (leg dimension), the effective length is equal to the actual length. When the length of end-loaded fillet welds exceeds 100 but not more than 300 times the weld size, the effective length shall be determined by multiplying the actual length by the reduction coefficient β .

$$\beta = 1.2 - 0.2 \left(\frac{L}{100w} \right) \leq 1.0 \quad (4-1)$$

where

β = reduction coefficient

L = actual length of end-loaded weld, in [mm]

w = weld size, in [mm]

When the length exceeds 300 times the leg size, the effective length shall be taken as 180 times the leg size.

4.5.2.6 Calculation of Effective Throat. For fillet welds between parts meeting at angles between 80° and 100° the effective throat shall be taken as the shortest distance from the joint root to the weld face of a 90° diagrammatic weld (see Figure 4.1). For welds in acute angles between 60° and 80° and for welds in obtuse angles greater than 100°, the weld leg size required to provide the specified effective throat shall be calculated to account for geometry (see Annex A). For welds in acute angles between 60° and 30°, leg size shall be increased by the Z loss dimension to account for the uncertainty of sound weld metal in the root pass of the narrow angle for the welding process to be used (see 4.5.3).

4.5.2.7 Reinforcing Fillet Welds.

(1) The effective throat of a combination of PJP flare bevel groove weld and a fillet weld shall be the shortest distance from the weld root to the weld face of the diagrammatic weld minus the deduction for incomplete joint penetration (see Table 4.1 and Figures 4.6 and 5.2).

(2) The effective throat of a combination of any other PJP groove weld and a fillet weld shall be the shortest distance from the weld root to the weld face of the diagrammatic weld minus 1/8 in [3 mm] for any groove detail requiring such deduction (see Figures 4.2, 4.3, 4.4 and 5.2).

4.5.2.8 Minimum Size. The minimum size fillet weld shall not be smaller than the size required to transmit the applied load nor that provided in 7.13.

4.5.2.9 Maximum Specified Fillet Weld Size on Edges. The maximum size of a fillet weld detailed along the edge of base metal shall be the following:

(1) the thickness of the base metal, for metal less than 1/4 in [6 mm] thick (see Figure 4.7).

(2) 1/16 in [2 mm] less than the thickness of the base metal, for metal 1/4 in [6 mm] or more in thickness (see Figure 4.7), unless the weld is designated on the shop drawing to be built out to obtain full throat thickness for a leg size equal to the base metal thickness. In the as-welded condition, the distance between the edge of the base metal and the toe of the weld may be less than 1/16 in [2 mm] provided the weld size is clearly verifiable.

4.5.2.10 Effective Area. The effective area shall be the effective weld length multiplied by the effective throat.

4.5.3 Skewed T-Joints

4.5.3.1 General. T-joints in which the angle between joined parts is greater than 100° or less than 80° shall be defined as skewed T-joints. Prequalified skewed T-joint details are shown in Figure 5.4. The details of joints for the

obtuse and acute sides may be used together or independently depending upon service conditions and design with proper consideration for effects of eccentricity.

4.5.3.2 Welds in Acute Angles Between 80° and 60° and in Obtuse Angles Greater than 100°. When welds are deposited in angles between 80° and 60° or in angles greater than 100° the contract documents shall specify the required effective throat. The shop drawings shall clearly show the placement of welds and the required leg dimensions to satisfy the required effective throat (see Annex A).

4.5.3.3 Welds in Angles Between 60° and 30°. When welding is required in an acute angle that is less than 60° but equal to or greater than 30° [Figure 5.4(D)], the effective throat shall be increased by the Z-loss allowance (Table 4.2). The contract documents shall specify the required effective throat. The shop drawings shall show the required leg dimensions to satisfy the required effective throat, increased by the Z-loss allowance (Table 4.2) (see Annex A for calculation of effective throat).

4.5.3.4 Welds in Angles Less than 30°. Welds deposited in acute angles less than 30° shall not be considered as effective in transmitting applied forces except as modified for tubular structures in 10.14.4.2.

4.5.3.5 Effective Length. The effective length of skewed T-joints shall be the overall length of the full size weld. No reduction shall be assumed in design calculations to allow for the start or stop of the weld.

4.5.3.6 Minimum Weld Size. The requirements of 4.5.2.8 shall apply.

4.5.3.7 Effective Throat. The effective throat of a skewed T-joint in angles between 60° and 30° shall be the minimum distance from the joint root to the diagrammatic face, less the Z loss reduction dimension. The effective throat of a skewed T-joint in angles between 80° and 60° and in angles greater than 100° shall be taken as the shortest distance from the joint root to the weld face.

4.5.3.8 Effective Area. The effective area of skewed T-joints shall be the specified effective throat multiplied by the effective length.

4.5.4 Fillet Welds in Holes and Slots

4.5.4.1 Diameter and Width Limitations. The minimum diameter of the hole or the width of slot in which a fillet weld is to be deposited shall be no less than the thickness of the part in which it is made plus 5/16 in [8 mm].

4.5.4.2 Slot Ends. Except for those ends which extend to the edge of the part, the ends of the slot in which a fillet weld is to be deposited shall be semicircular or shall have the corners rounded to a radius not less than the thickness of the part in which it is made.

4.5.4.3 Effective Length. For fillet welds in holes or slots, the effective length shall be the length of the weld along the centerline of the throat.

4.5.4.4 Effective Area. The effective area shall be the effective length multiplied by the effective throat. In the case of fillet welds of such size that they overlap at the centerline when deposited in holes or slots, the effective area shall not be taken as greater than the cross-sectional area of the hole or slot in the plane of the faying surface.

4.5.5 Plug and Slot Welds

4.5.5.1 Diameter and Width Limitations. The minimum diameter of the hole or the width of slot in which a plug or slot weld is to be deposited shall be no less than the thickness of the part in which it is made plus 5/16 in [8 mm.]. The maximum diameter of the hole or width of slot shall not exceed the minimum diameter plus 1/8 in [3 mm] or 2-1/4 times the thickness of the part, whichever is greater.

4.5.5.2 Slot Length and Shape. The length of the slot in which slot welds are to be deposited shall not exceed ten times the thickness of the part in which it is made. The ends of the slot shall be semicircular or shall have the corners rounded to a radius not less than the thickness of the part in which it is made.

4.5.5.3 Effective Area. The effective area of plug and slot welds shall be the nominal area of the hole or slot in the plane of the faying surface.

4.5.5.4 Minimum Depth of Filling. The minimum depth of filling of plug and slot welds shall meet the following requirements:

- (1) for slot or plug welds in material 5/8 in [16 mm] thick or less, the thickness of the material.
- (2) for slot or plug welds in materials over 5/8 in [16 mm] thick, one-half the thickness of the material or 5/8 in [16 mm], whichever is greater.

In no case is the minimum depth of filling required to be greater than the thickness of the thinner part being joined.

Part B

Specific Requirements for Design of Nontubular Connections (Statically or Cyclically Loaded)

4.6 General

The specific requirements of Part B together with the requirements of Part A shall apply to all connections of nontubular members subject to static loading. The requirements of Parts A and B, except as modified by Part C, shall also apply to cyclic loading.

4.7 Strength

4.7.1 Introduction. Design shall be performed according to the AISC provisions for Load and Resistance Factor Design (LRFD) or the provisions for Allowable Strength Design (ASD). Design according to LRFD requires that the design strength, ϕR_n , equal or exceed the required strength, R_u , which is determined on the basis of the LRFD load combinations.

$$R_u \leq \phi R_n \quad (4-2)$$

Design according to ASD requires that the allowable strength, R_n/Ω , equal or exceed the required strength, R_a , which is determined on the basis of the ASD load combinations.

$$R_a \leq R_n/\Omega \quad (4-3)$$

where

R_u = required strength using LRFD load combinations

R_n = nominal strength

ϕ = resistance factor

ϕR_n = design strength

R_a = required strength using ASD load combinations

Ω = safety factor

R_n/Ω = allowable strength

Load combinations and resistance factors for LRFD and load combinations and safety factors for ASD can vary. For this code, resistance factors and safety factors shall be the same as those in ANSI/AISC 360, *Specification for Structural Steel Buildings* which have been calibrated with load combinations from ASCE 7.

4.7.2 Consideration of Eccentricity. In the design of welded joints, eccentricities associated with alignment of connected parts and the position, size and type of welds, shall be considered except as provided in the following:

For statically loaded structures, the location of fillet welds to balance the forces about the neutral axis or axes for end connections of single-angle, double-angle, and similar members is not required. In such members, weld arrangements at the heel and toe of angle members may be distributed to conform to the length of the various available edges.

4.7.3 Welded Joint Strength. The strength (allowable strength for ASD, design strength for LRFD) of the welded joint shall be the lower value of the weld or base metal strengths as determined in accordance with the following equations. These strengths shall not exceed those given in Table 4.3 except as allowed by 4.7.3.2, 4.7.3.3, and 4.7.3.4.

$$\text{Base metal: } R_u = F_{tBM} A_{tBM} \quad (4-4)$$

$$\text{Weld metal: } R_u = F_{tW} A_{tW} \quad (4-5)$$

where

R_n = nominal strength, kips [kN]

F_{nBM} = nominal strength of base metal per unit area, ksi [MPa]

F_{nw} = nominal strength of weld metal per unit area, ksi [MPa]

A_{BM} = cross sectional area of base metal at weld joint, in² [mm²]

A_{we} = effective area of the weld, in² [mm²]

Values for and limitations on ϕ , Ω , F_{nBM} , and F_{nw} are provided in Table 4.3.

4.7.3.1 Required Strength of Fillet Welds. The required strength of fillet welds shall be determined by considering shear on the weld effective area for any direction of applied load.

4.7.3.2 Alternative Fillet Weld Available Strength. For a single linear fillet weld or fillet weld groups consisting of parallel linear fillet welds all loaded at the same angle and loaded in plane through the centroid of the weld group, the available strength is ϕR_n (design strength) or R_n/Ω (allowable strength), which may be calculated using the following formulas with $\phi = 0.75$ and $\Omega = 2.0$.

$$R_n = F_{nw} A_{we} \quad (4-6)$$

$$F_{nw} = 0.6 F_{EXX} (1.0 + 0.5 \sin^{1.5} \Theta) \quad (4-7)$$

where

F_{EXX} = filler metal classification strength, ksi [MPa]

Θ = angle of loading measured from longitudinal axis, degrees

A_{we} = effective area of the weld, in² [mm²]

4.7.3.3 Instantaneous Center of Rotation. For fillet weld elements within a fillet weld group that are analyzed using this method, the available strength is ϕR_n (design strength) or R_n/Ω (allowable strength) calculated using the following formulas with $\phi = 0.75$ and $\Omega = 2.0$.

$$R_{nx} = \sum F_{nwx} A_{wei} \quad (4-8)$$

$$R_{ny} = \sum F_{nwy} A_{wei} \quad (4-9)$$

$$M_n = \sum [F_{nwy} A_{wei} (x_i) - F_{nwx} A_{wei} (y_i)] \quad (4-10)$$

where

A_{wei} = effective area of weld of the i th weld element, in² [mm²]

$F_{nwi} = 0.60 F_{EXX} (1.0 + 0.50 \sin^{1.5} \Theta_i) f(\rho_i)$ = nominal stress in the i th weld element, ksi [MPa]

$f(\rho_i) = [\rho_i (1.9 - 0.9\rho_i)]^{0.3}$

F_{nwx} = x-component of nominal stress

F_{nwy} = y-component of nominal stress

$\rho_i = \Delta_i/\Delta_{mi}$ = ratio of element i deformation to deformation in element at maximum stress

r_{cr} = distance from instantaneous center of rotation to weld element with minimum Δ_{wi}/r_i ratio, in [mm]

r_i = distance from instantaneous center of rotation to i th weld element, in [mm]

x_i = x component of r_i

y_i = y component of r_i

w = weld size (leg dimension), in [mm]

$\Delta_i = r_i \Delta_{ucr}/r_{cr}$ = deformation of the i th weld element at an intermediate stress level, linearly proportioned to the critical deformation based on distance from instantaneous center of rotation, in [mm]

$\Delta_{mi} = 0.209 (\Theta_i + 2)^{-0.32} w$ = deformation of weld element at maximum stress, in [mm]

Δ_{ucr} = deformation of weld element with minimum Δ_{wi}/r_i ratio at ultimate stress, usually in the element furthest from instantaneous center of rotation, in [mm]

$\Delta_{wi} = 1.087 (\Theta_i + 6)^{-0.65} w, < 0.17 w$, deformation of i th weld element at ultimate stress, in [mm]

Θ_i = angle between the longitudinal axis of the i th weld element and the direction of the resultant force acting on the element, degrees.

4.7.3.4 Concentrically Loaded Weld Groups. Alternatively, for the special case of a concentrically loaded weld group, the available strength is ϕR_n (design strength) or R_n/Ω (allowable strength) calculated using the following formulas with $\phi = 0.75$ and $\Omega = 2.0$.