



**American Water Works
Association**

The Authoritative Resource on Safe WaterSM

AWWA C206-03
(Revision of ANSI/AWWA C206-97)

AWWA Standard

Field Welding of Steel Water Pipe

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AWWA Standard

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Foreword

This foreword is for information only and is not a part of AWWA C206.

I. Introduction.

I.A. *Background.* The provisions of this standard describe the requirements for welding steel water pipe joints in water transmission and distribution lines. The purchaser for each project is responsible for determining if any unusual circumstances related to the project require additional provisions that are not included in the standard.

The design of field-welded joints is not discussed in this standard. Useful information on this subject may be found in *Steel Water Pipe—A Guide for Design and Installation*,* and in *Useful Information on the Design of Plate Structures*.†

After the welded field joint has been completed, if the pipe has been coated or lined, the joint shall be coated and lined with a coating system compatible with that on the body of the pipe, in accordance with the requirements for field repairs stated in the appropriate AWWA coating or lining standard.

For lap-welded pipe with an inside diameter exceeding 27 in. (675 mm) and where the purchaser deems single welding to be acceptable, inside welding should be considered.

Pipe should be supplied with lead holes approximately 3 in. (76 mm) in diameter at approximately 500-ft (150-m) centers to allow passage of welding leads. Lead holes in the pipe will permit shorter welding leads, and thus avoid erratic voltage drops caused by excessively long welding leads. The plug plate to repair the hole shall be the same material as the base material of the pipe, and the holes shall be closed by welding.

I.B. *History.* This standard was first approved as tentative by AWWA in January 1946 and by the American Welding Society (AWS) in October 1945. It was advanced to standard status by AWWA in 1950 and by AWS in 1951. The joint AWWA–AWS activity continued through revisions in 1957 (AWWA C206-57, AWS D7.0-57) and 1962 (AWWA C206-62, AWS D7.0-62a). The joint committee

**Steel Water Pipe—A Guide for Design and Installation*, AWWA Manual M11, AWWA, Denver, Colo. (2004).

†*Useful Information on the Design of Plate Structures*, Steel Plate Engineering Data, Vol. 2, American Iron and Steel Institute, 1101 17th St. N.W., Ste. 1300, Washington, DC 20036.