



AWS Amendment Notice

The following amendments have been made and incorporated into the current edition of this document.

2nd Printing:

AWS Standard: D1.4/D1.4M:2018-AMD1
Amendment Number: 1
Subject: Table 8.2

Table 8.2					
PQR Essential Variable Changes Requiring WPS Requalification for SMAW, GMAW, GTAW, and FCAW (see 8.2.1.1 and 8.2.1.4)					
Essential Variable Changes to PQR Requiring Requalification		Process ^a			
		SMAW	GMAW	GTAW	FCAW
General					
(10)	A change in the position not qualified per 8.2.3	X	X	X	X
(11)	A change in joint type not qualified by Table 8.3	X	X	X	X
(12)	The omission, but not inclusion, of backing material	X	X	X	X
A change in bar diameter group:					
(13)	Group A: Bar numbers 6 and smaller Group B: Bar numbers 7 through 11 Group C: Bar numbers 14 and 18	X	X	X	X

^a An "X" indicates applicability for the process; a line (—) indicates nonapplicability.

AWS Standard: D1.4/D1.4M:2018-AMD1
Amendment Number: 1
Subject: Table 8.3

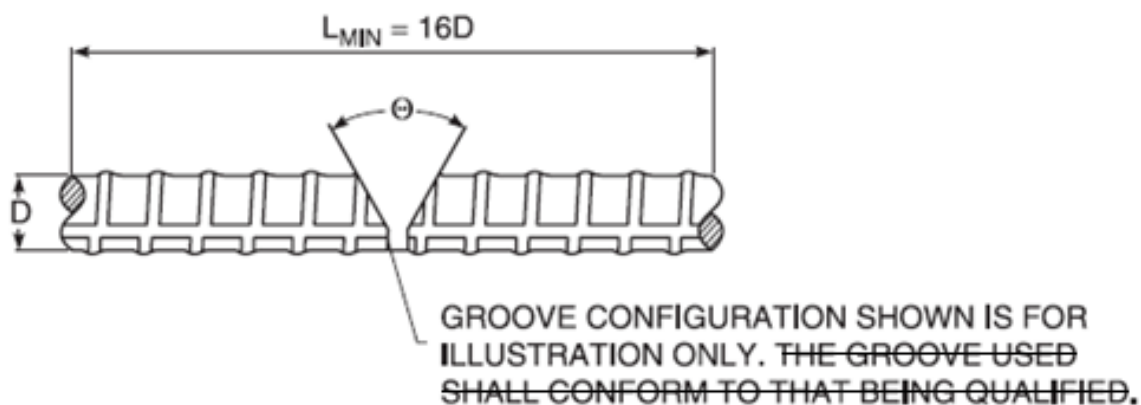
Table 8.3					
Number and Type of Tests for WPS Qualification (see 8.2.4.2)					
Test Weld (or Test Coupon)	Figure	Minimum Number of Test Assemblies	Tension Tests (8.2.4.4)	Macroetch Tests (8.2.4.5)	Joint Types Qualified per Figures
Direct butt	8.5(A)	2	2	2	5.1, 5.2, 5.5(D)
T-Joint	8.5(B)	2	2	2	5.1, 5.5(D)
Indirect butt	8.5(C)	2	2	2	5.3(A), 5.3(B), 5.4(B), 5.5(E)
Indirect butt	8.5(D)	2	2	2	5.3(C), 5.4(A)

(Amendment Notice: September 7th, 2020)



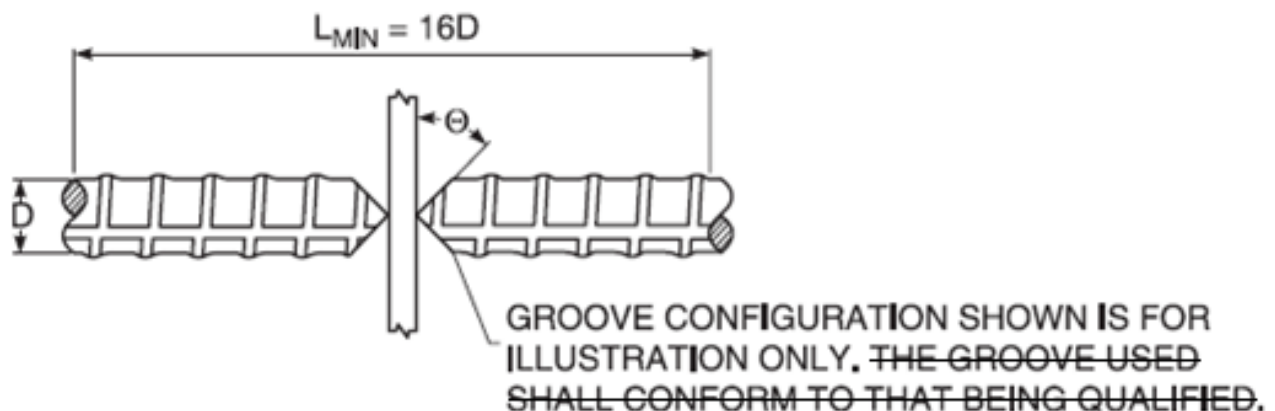
AWS Standard: D1.4/D1.4M:2018-AMD1
Amendment Number: 1
Subject: Figure 8.5(A)—COMPLETE JOINT PENETRATION GROOVE WELD—DIRECT BUTT JOINT

Delete “THE GROOVE USED SHALL CONFORM TO THAT BEING QUALIFIED” language from the groove configuration illustration:



AWS Standard: D1.4/D1.4M:2018-AMD1
Amendment Number: 1
Subject: Figure 8.5(B)—ALTERNATIVE COMPLETE JOINT PENETRATION GROOVE WELD—T-JOINT

Delete “THE GROOVE USED SHALL CONFORM TO THAT BEING QUALIFIED” language from the groove configuration illustration:



(Amendment Notice: September 7th, 2020)