



AWS Addenda Notice

The following Addenda has been made and incorporated into the current edition of this document.

AWS Standard: D1.9/D1.9M:2007
Addenda #: ADD1
Subject: Radiographic Crack Allowance in Table 5.2

Page 81 – Add a row above “Fine Scattered Porosity” to Table 5.2 for crack discontinuity types as follows:

Table 5.2
Radiographic Allowance for CJP and PJP Welds (see 3.8.2, 5.22, and A4.3.2)

Table with 4 columns: Discontinuity Types, Base Material Thickness Range, Radiograph Category, and Acceptance Level. Rows include Cracks, Fine Scattered Porosity, Coarse Scattered Porosity, Linear Porosity or Rounded Indications, Nonmetallic Inclusions, Tungsten Inclusions, and Incomplete Joint Penetration.

The purpose of this addenda notice is to inform the public that a published standard has been technically modified. An addenda is an addition or supplement to a published standard or portions thereof required before the complete revision and publication of the next edition of the standard.



# American Welding Society

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|  |                                    |                       |  |
|--|------------------------------------|-----------------------|--|
| CJP only   | >1/2 [12] and $\leq$ 1-1/2 [38]    | Up to 3/4 [19], incl. | 2  |
|  | >1-1/2 [38] and $\leq$ 3 [76]      | Up to 2 [50], incl.   | 3  |
| Incomplete Fusion CJP only   | $\geq$ 1/8 [3] and $\leq$ 1/2 [12] | Up to 3/8 [10], incl. | 2  |
|  | >1/2 [12] and $\leq$ 1-1/2 [38]    | Up to 3/4 [19], incl. | 2  |
|  | >1-1/2 [38] and $\leq$ 3 [76]      | Up to 2 [50], incl.   | 3  |
| Incomplete Joint Penetration—<br>Partial joint penetration welds<br>only | All                                | N/A                   | 1/32 [0.8] width<br>full weld length<br>1/16 [1.5] width<br>4T in 8T weld length |
| Incomplete Fusion—Partial joint<br>penetration welds only                | All                                | N/A                   | 1/32 [0.8] width<br>full weld length<br>1/16 [1.5] width<br>4T 8T weld length    |

Notes:

1. Porosity or inclusions allowed by this table shall be cause for rejection when closer than twice their maximum dimension to an edge or extremity of a weldment in a highly stressed or critical area, as determined by design engineering personnel.
2. Linear is described as having a length greater than three times the width. Rounded is defined by the converse.