AWS Amendment Notice

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

Amendment #1
Subject: Annex A-Prequalified Weld-Joints, B-U2a

Amendment #1
Subject: Annex A-Prequalified Weld-Joints, TC-U4b

The purpose of this amendment notice is to inform the public that a published standard has been technically corrected. An amendment is the correction of an error in substantive content in a published standard that had been inadvertently approved by the required approval procedures.
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Amendment #1
Subject: Annex A-Prequalified Weld-Joints, TC-U5c

<table>
<thead>
<tr>
<th>Double-Bevel-Groove Weld (5)</th>
</tr>
</thead>
<tbody>
<tr>
<td>T-Joint (T)—Skew</td>
</tr>
<tr>
<td>Corner Joint (C)—Skew</td>
</tr>
<tr>
<td>Unlimited Thickness (U)</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Limitations for Joints</th>
<th>TC-U5c</th>
</tr>
</thead>
<tbody>
<tr>
<td>α in [mm]</td>
<td>Permitted Positions</td>
</tr>
<tr>
<td>45°</td>
<td>1/4 [6] All Positions</td>
</tr>
<tr>
<td>30°</td>
<td>3/8 [10] Flat and Overhead</td>
</tr>
</tbody>
</table>

Amendment #1
Subject: Annex A-Prequalified Weld-Joints, TC-U8a

<table>
<thead>
<tr>
<th>Single-J-Groove Weld (8)</th>
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<tbody>
<tr>
<td>T-Joint (T)</td>
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<tr>
<td>Corner Joint (C)</td>
</tr>
<tr>
<td>Unlimited Thickness (U)</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Limitations for Joints</th>
<th>TC-U8a</th>
</tr>
</thead>
<tbody>
<tr>
<td>α Permitted Positions</td>
<td>TC-U8a</td>
</tr>
<tr>
<td>45°</td>
<td>All Positions</td>
</tr>
<tr>
<td>30°</td>
<td>Flat and Overhead</td>
</tr>
</tbody>
</table>

Notes:
1. Gouge the roots of joints without backing before welding the other side.
2. See Table 9 for workmanship tolerances.
3. If fillet welds are used to reinforce groove welds in T-joints and corner joints, they shall be equal to 1/4 but need not exceed 3/8 in [10 mm].
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Amendment #1
Subject: Annex A-Prequalified Weld-Joints, C-L2c-S and C-U2a-S

![Diagram of C-L2c-S and C-U2a-S weld joints with tables listing limitations for joints, showing R, T, and α measurements.]

Amendment #1
Subject: Annex A-Prequalified Weld-Joints, B-U7-S

![Diagram of B-U7-S weld joint with annotations R and angle measurements.]

Notes:
1. If fillet welds are used to reinforce groove welds in T-joints and corner joints, they shall be equal to T/4 but need not exceed 3/8 in (10 mm).
2. See Table 9 for workmanship tolerances.
3. Gauge the roots of joints without backing before welding the other side.

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7.2.2 Position of Test Welds. All welds that will be encountered in actual construction shall be classified as being (1) flat, (2) horizontal, (3) vertical, or (4) overhead, in accordance with the definitions of welding positions given in Figures 6 and 7. Procedures qualified to Method I, Method II, and AWS B2.1/B2.1M, Specification for Welding Performance and Procedure Qualification shall be qualified in each position to be used.

7.4.2 Macroetch Test. A minimum of three specimens shall be etched with a suitable solution to give a clear definition of the weld. Guidelines for macroetch procedures may be found in the Annex of AWS B2.1/B2.1M, Specification for Welding Procedure and Performance Qualification.

7.5 Method III—Prequalified Welding Procedure. Certain fundamental groove welded joints meeting all the requirements listed in 4.2 are designated as prequalified within the limitations shown in Annex A, Figures A.1 through A.6. Fillet welds meeting all the requirements listed for a specified joint in 4.3 and shown in Figure A.7 are also designated as prequalified. Prequalified groove welds and fillet welds may be used without performing welding procedure qualification tests, provided the conditions documented on the written WPS are capable of satisfying the requirements of 9.5.1, 9.5.5, and 9.5.6. WPS’s that meet the aforementioned requirements of this clause shall be identified on the WPS as prequalified and are exempt from the qualification testing required by Methods I, II and AWS B2.1/B2.1M, Specification for Welding Procedure and Performance Qualification. All prequalified WPSs shall be written. For a WPS to be prequalified, conformance with all the applicable requirements of Method III shall be required. WPSs that do not conform to the requirements of Method III may be qualified by test in conformance with Methods I, II or AWS B2.1/B2.1M, Specification for Welding Procedure and Performance Qualification. The use of a prequalified welding procedure shall not exempt the Manufacturer from using sound judgment in determining the suitability of application of these welding procedures.

7.5.2 Base metal, filler metal, preheat, and interpass temperature requirements shall meet the following:

Amendment #: 1
Subject: Clause 7.2.2, 7.4.2, 7.5(2 places), 7.5.2 (2), 7.5.3, 8.2.2, 8.6.1.1

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(2) Steels listed in AWS B2.1/B2.1M, *Specification for Welding Procedure and Performance Qualification* that have the same M number and group number as those steels identified in Table 4 or defined in Table 5 are also considered prequalified, provided the preheat and interpass temperatures used are no lower than those listed in Table 6.

7.5.3 The WPS for the prequalified welding procedure shall meet the applicable requirements given in 7.5.5, 7.5.6, 7.5.7, and 7.5.8. Any changes to a prequalified welding procedure specification outside the applicable limits of 7.5 shall require qualification by Methods I, II, or AWS B2.1/B2.1M. *Specification for Welding Procedure and Performance Qualification*.

8.2.2 Limitation of Variables. The limitations of variables shall be in accordance with AWS B2.1/B2.1M, *Specification for Procedure and Performance Qualification* with the following exceptions:

8.6.1.1 A tack welder qualified for shielded metal arc welding with an electrode listed in AWS B2.1/B2.1M/B2.1 M Table, *Specification for Welding Procedure and Performance Qualification* (Grouping of Welding Electrodes and Rods for Qualification) shall be considered qualified to tack weld with any other electrode in the same group designation.

Amendment #: 1
Subject: Clause 7.5.5

7.5.5 Prequalified Procedures for Manual Shielded Metal Arc Welding (SMAW)

Amendment #: 1
Subject: Clause 7.5.2 (6)

(6) The WPS for a prequalified welding procedure shall include the specification of minimum preheat and interpass temperature for the welding process, class of steel, and thickness to be welded in accordance with the requirements of Table 6.