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

Title page: replace AASHTO Highway “Subcommittee” with “Committee”

Page 5, Clause 2, replace “AASHTO M270M/M270” with “AASHTO M 270M/ M 270”

Page 5, Clause 2, AASHTO T244, replace “T44” with “T 244”

Page 17, Subclause 4.1.3.1, weld symbol: Switch S₁ and S₂

Pages 40, 41, 42, 44, 45, 46, and 47, Figure 4.4 title: Replace “Millimeters” with “Inches”

Page 27, Note d: Replace “S as specified on drawings” with “D as specified on drawings”

Page 38, Figure 4.4 title: replace “(Dimensions in Millimeters)” with “(Dimensions in Inches)”

Page 39, Figure 4.4 title: replace “(Dimensions in Millimeters)” with “(Dimensions in Inches)”

Page 40, Figure 4.4 title: replace “(Dimensions in Millimeters)” with “(Dimensions in Inches)”

Page 41, Figure 4.4 title: replace “(Dimensions in Millimeters)” with “(Dimensions in Inches)”

Page 42, Figure 4.4 title: replace “(Dimensions in Millimeters)” with “(Dimensions in Inches)”

Page 43, Figure 4.4 title: replace “(Dimensions in Millimeters)” with “(Dimensions in Inches)”

Page 44, Figure 4.4 title: replace “(Dimensions in Millimeters)” with “(Dimensions in Inches)”

Page 45, Figure 4.4 title: replace “(Dimensions in Millimeters)” with “(Dimensions in Inches)”

Page 46, Figure 4.4 title: replace “(Dimensions in Millimeters)” with “(Dimensions in Inches)”

Page 47, Figure 4.4 title: replace “(Dimensions in Millimeters)” with “(Dimensions in Inches)”

Page 49, Figure 4.5, Joint Designations C-P2, C-P2-GF, and C-P2-S, Weld Size (S) column: Replace “E” with “D”

Page 51, Figure 4.5, Weld Size (E) table heading: Replace “(E)” with “(S)”

Page 51, Figure 4.5, Joint Designations C-P6, C-P6-GF, and C-P6-S, Weld Size (E) column: Replace “S” with “D”
Page 64, subclause 5.2.5: Replace “ANSI B46.1” with “ASME B46.1”

Page 68, subclause 5.3.7.1: Capitalize “tack” and replace “Clause 5” with “Clause 7”

Page 70, subclause 5.5.3 table, first row: move the hyphen after “midspan” to in front of the “0” on the right side on the top line. The final result is: −0, +40 mm

Page 70, subclause 5.5.3 table, first row, right column, top line: replace “< 30 m [100 ft] with “≥ 30 m [100 ft].”

Page 72, subclause 5.5.7, second paragraph: replace “M160” with “M 160”

Page 79, Figure 5.3: lower dimension line of offset dimension should be same thickness as the dimension line above it

Page 79, Figure 5.3: replace “1/4 in” with “6 mm [1/4 in]”

Page 85, subclause 6.5.2.3, first sentence: delete “when welding steels with a minimum specified yield strength of 345 MPa [50 ksi] or less.”

Will now read as:

6.5.2.3 Optional Supplemental Moisture-Resistant Designators. E70XX-X, E80XX-X, E90XX-X, E100XX-X, and E110XX-X electrodes with the AWS filler metal specifications optional supplemental moisture resistance designator “R” may be exposed to the atmosphere for up to nine hours.

Page 96, Table 6.1, second row, under the SMAW column for A5.5/A5.5M: replace “E10010M” with “E10018M.”

Page 97, Table 6.3: insert designation “a” after “SAW; GMAW; FCAW; SMAW (M 270M/M 70 (A709/A709M) Gr. HPS 485W [HPS 70W] and HPS 690W [HPS 100W]). This is to identify that table footnote a applies to these welding processes.

Page 116, Table 7.1: delete all degree (°) symbols next to the HPS steels

Page 116, Table 7.1: insert values shown in the red box below:

| Table 7.1 Base Metal Options for WPS Qualification Test Plates |
| [AASHTO M 270M/M 270 (ASTM A709/A709M) Grades (see 7.4 and C-7.4)] |
| Base Metal Grade to be listed on WPS |

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>415 [60]</td>
<td>Gr. 250 [36], or 345 [50], or 345W [50W], or HPS 345W [HPS 50W]</td>
<td>Gr. 250 [36], or 345 [50], or 345W [50W], or HPS 345W [HPS 50W]</td>
<td>Gr. 250 [36], or 345 [50], or 345W [50W], or HPS 345W [HPS 50W]</td>
<td>HPS 485W [HPS 70W]</td>
</tr>
<tr>
<td>485 [70] or 550 [80]</td>
<td>Gr. 250 [36], or 345 [50], or 345W [50W], or HPS 345W [HPS 50W]</td>
<td>Gr. 345 [50], or 345W [50W], or HPS 345W [HPS 50W]</td>
<td>Gr. 345 [50], or 345W [50W], or HPS 345W [HPS 50W]</td>
<td>Gr. 345 [50], or 345W [50W], or HPS 345W [HPS 50W]</td>
</tr>
<tr>
<td>620 [90]</td>
<td>---</td>
<td>---</td>
<td>---</td>
<td>Gr. HPS 485W [HPS 70W]</td>
</tr>
<tr>
<td>690 [100] or 760 [110]</td>
<td>---</td>
<td>---</td>
<td>---</td>
<td>Gr. HPS 690W [HPS 100W]</td>
</tr>
</tbody>
</table>

| 2 of 5 |
Page 152, subclause 8.1.3.4, second sentence: move the “(1)” to right after “who”

Page 154, subclause 8.7.4: correct spelling of “satsified” with “satisfied”

Page 155:
Replace “8.7.6.4” with “8.7.8.4”
“8.7.6.5” with “8.7.8.5”
“8.7.7” with “8.7.9”
“8.7.9” with “8.7.10”

Page 156, subclause 8.9.1, fourth line: move “;” to before “and”

Page 156, subclause 8.10.1.1.(2): add period at end of sentence

Page 161, subclause 8.17.1: replace “prequalified” with “requalified”

Page 164, subclause 8.20.2, first sentence: replace “indentifying” with “identifying”

Page 164, subclause 8.21.1.1: delete first colon (:

Page 166, subclause 8.22.2(16): should not be a new line. It is a continuation of the previous line and should be (14). (17) through (19) along with their reference in (15) should be (16) through (18)

Page 168, subclause 8.24.2.2: use lowercase for “scanning” after the semicolon

Will now read as:
(1) Undercut in main members shall be no more than 0.25 mm [0.01 in] deep when the weld is transverse to tensile stress under any design loading condition.

Page 168, subclause 8.26.1.5(2): delete “for all other cases.”
Will now read as:
(2) Undercut in all other cases shall be no more than 1 mm [1/32 in] deep.

Page 171, Table 8.1, under the Frequency column: Replace the first four instances of “(See 8.7.4)” with “(See 8.7.3).” These all fall under Weld Type, CJP groove welds

Page 173, Table 8.3, use lowercase for “Table” at end of sentence

Page 175, Table 8.4, Class A: insert space between “of” and “length”

Page 175, Table 8.4, sub-table on Scanning Levels, table footnote b: replace the semicolon with a comma

Page 178, Figure 8.1C, callout note on the far left: insert space between “T2” and “AT”

Page 178, Figure 8.1D, callout note on the far left: insert space between “T2” and “AT”

Page 193, subclause 9.6.3.1: insert a nonbreaking space between “M” and “270” here and for all instances

Page 193, subclause 9.6.7: use lowercase for “qualification test data”
Page 206, subclause 12.7.3, delete “groove weld” from sentence. Will now read as:

**12.7.3 Fillet WPS Qualification.** Except as provided in 12.7.1, fillet WPSs shall be qualified by testing in conformance with Clause 7.

Page 213, Table 12.4: replace “M270” with “M 270”
Page 213, Table 12.5: replace “M270” with “M 270”
Page 213, Table 12.6: replace “M270” with “M 270”; replace “H > 2.8” with “HI > 2.8”
Page 214, Table 12.7: replace “M270” with “M 270”; replace “H > 70” with “HI > 70”

Page 222-225, Annex C, all tables: rows with single values are to be right justified to line up with the bottom of the two values in the other columns.

Page 236, Figure E.5, note 3 on top of page: delete “times” as there is a multiplication symbol

Page 251, Annex G, title: insert “ASTM” inside “(A709/A709M)”
Page 251, Annex G, subclause G1, first sentence: insert “ASTM” inside “(A709/A709M)”
Page 252, Annex G, Table G.1, title: insert “ASTM” inside “(A709/A709M)”

Page 325, fourth paragraph: delete “is” in the first sentence

Page 328, subclause C-1.2.2, second paragraph, third sentence: do not capitalize fracture-critical members”

Page 328, subclause C-1.2.2, third paragraph, first sentence: replace “supplemental” with “requirement”

Page 346, subclause C-5.1.5, second paragraph: replace “M 160M” with “M 160M/M 160” and “A6” with “A6/A6M”

Page 357, subclause C-5.4.8(2), fourth line: replace “streel” with “steel”

Page 358, subclause C-5.5.2, second paragraph: replace “M160” with “M 160”

Page 358, subclause C-5.5.6, third sentence: replace “facia” with “fascia”

Page 358, subclause C-5.4.8.4, last sentence: replace “preclude” with “to prevent or remove”

Page 359, subclause C-5.5.4, third paragraph: replace “M160” with “M 160”

Page 360, subclause C-5.5.8, fourth paragraph: replace “M160” with “M 160”

Page 360, subclause C-5.5.9, first paragraph, last sentence: capitalize “see”

Page 360, subclause C-5.5.9, third paragraph: delete “Rationale: In the case of a steel pier or bent supporting other members, the relevant flange under the supported members will be the top flange.”
Page 362, subclause C-5.6.2, second sentence: replace “weld procedure” with “welding procedure”

Page 381, subclause C-6.5.2.3, fourth sentence: insert “not”
Will now read as:
The moisture content of the exposed covering must not exceed the maximum specified moisture content for the “R” designated electrode and classification in the appropriate AWS A5.1/A5.1M or AWS A5.5/A5.5M specification.

Page 388, subclause C-6.12, last sentence: replace “self shielded” with “self-shielded”

Page 395, subclause C-7.4.1, first paragraph, third sentence: replace “M270” with “M 270”

Page 405, subclause C-7.13.2: replace “Fillet Metal Oscillation” with “filler metal oscillation”

Page 430, subclause C-8.26.1.7, first sentence: replace “equal leg” with “equal-leg”

Page 444, subclause C-12.3.2.1, first paragraph: replace “weld procedures” with “welding procedures”

Page 444, subclause C-12.4.1, first sentence: replace “Subcommittee” with “Committee”

Page 464, subclause C-J7.4: replace entire subclause with the following:

**C-J7.4 Testing of Welds.** For welds in corner or T-joints, the weld may be examined with a straight beam or low-angle longitudinal waves from an appropriate face to aid in obtaining coverage.

Obtaining near perpendicular coverage to the fusion face on the unbeveled side of single bevel groove welds is not practical. A sufficient number of offsets should be used to position angles as close to perpendicular to the weld fusion face as practical. Ideally, the weld volume coverage should include positioning the offsets to enable weld fusion face coverage within +/-10° of perpendicular (near 90° incidence to the weld fusion face) for S-scans or +/- 5° of perpendicular for supplemental E-scans.

For groove welds in corner or T-joints, the primary scanning for these types of joints is to be performed primarily from one side with the angle configuration for covering the unbeveled side at incidence angles as close to perpendicular as possible.

In areas where adequate coverage is suspect, the optional mock-up verification block should be used to validate coverage.

---

*(Errata Notice: October 25th, 2021)*