AWS D1.1 Interpretation

**Subject:** Pipe Diameters Qualified for Fillet Welds

**Code Edition:** D1.1/D1.1M:2004

**Code Provision:** Tables 4.9 and 4.10

**AWS Log:** D1.1-04-I06

**Inquiry:** Table 4.9 indicates that a welder who successfully completes a qualification test on fillet weld test plate as shown in Figure 4.36 in the 2F position is also qualified to weld pipe fillets in the flat and horizontal positions. Table 4.10 shows the qualified (thickness) dimension would be 1/8 in. to unlimited.

Given there are no diameters stated, does one interpret that the welder’s qualifications must include fillet welding of pipe of all diameters and thickness?

**Response:** For performance qualification, tests on plate in compliance with AWS D1.1/D1.1M:2004 Table 4.10, the qualified production material thickness is 1/8 in [3 mm] to unlimited and the diameter is unlimited for fillet welds on tubular connections (Clause 4.28).