AWS D15.1/D15.1M:2012-AMD1 Interpretation

Subject: PQR Essential Variable Changes Requiring WPS Requalification for SMAW, SAW, GMAW, FCAW, and GTAW – Process Parameters

Code Edition: D15.1:2012-AMD1 (Ed. 5)

Code Provision: Subclause 10.1 and Table 10.1 (17)

AWS Log: D15.1-12-I02

Inquiry: Table 10.1 Item 17 specifies “A change in amperage or voltage that is not within a range recommended by the electrode supplier” then WPSs must be requalified.

1. If a WPS is outside of these settings is the range that may be produced from a PQR similar to item 18?

2. Is the term supplier intended to be the manufacturer of the wire?

Response: 1. No. The only ranges qualified are those recoded on the PQR(s).

2. Yes.