AWS D1.1 Interpretation

Subject: Visual Inspection of Test Plate
Code Edition: D1.1-94
Code Provision: Figure 4.21 and Subsection 4.8.1
AWS Log: D1-2.58

Inquiry: For a welder qualification test plate, such as depicted in Figure 4.21, visual inspection of the weld is required by Table 4.9, Note 1. Visual inspection is to be performed to the acceptance criteria of 4.8.1.

(1) The question is whether the entire 5-in. length of the Figure 4.21 test requires the visual inspection acceptance criteria to be applied, or whether it is the intent to exclude the 1-1/4 in. at each end of the weld from evaluation, as is done for radiographic evaluation by subsection 4.30.3.
(2) As a follow-on question, if the entire 5-in. length is to be evaluated, can the backing strip shown in the figure be extended to allow a run-on/run-off area?

Response:
(1) Yes. The entire length of the test plate must be subjected to visual inspection.
(2) Yes. Weld tabs may be used but are outside the area of visual inspection.