AWS D1.1 Interpretation

Subject: Ceramic Backing
Code Edition: D1.1-96
Code Provision: Subsection 2.27.2
AWS Log: D1.259

Inquiry: For one-sided groove welds, 2.27.2 of D1.1-96 prohibits the use of backing, other than steel, without qualification of the Welding Procedure Specification (WPS). The subsection specifically requires qualification in accordance with Section 4 of the Code. However, subsection 3.6, by reference of Table 4.5, indicates that addition of backing does not affect the prequalification status of a WPS. For a WPS with ceramic backing, subsection 3.6 allows prequalification while subsection 2.27.2 prohibits prequalification.

Response: Yes. Ceramic backing is not prequalified under this Code. A change from steel backing to ceramic backing will require a new WPS to be qualified in accordance with Section 4 of the Code.