AWS D1.1 Interpretation

Subject: Welder Qualification (Allowable Undercut)
Code Edition: D1.1-86
Code Provision: Subsection 5.28.6
AWS Log: D1-88-001

Inquiry: In 5.28.6, directions are provided for visually evaluating a welder qualification test plate in accordance with 9.25.1. There are two maximum limits of allowable undercut in 9.25.1; which of these values should be used for evaluation of the welder qualification test plate?

Response: Undercut shall be no more than 1/32 in. (0.8 mm) deep. Note that the maximum allowable undercut for qualifying procedures, welders, welding operators, and tack welders was revised to 1/32 in. maximum in AWS D1.1-88.