AWS D1.1 Interpretation

Subject: Fillet Weld Procedure Qualification
Code Provision: Table 4.4 and Table 4.5
AWS Log: D1.1-02-I04

Inquiry: We have had a running question regarding the application of Table 4.5, Essential Variable 16), and the application of Note 3. When the procedure qualified is only used as a single pass weld, does the code permit the qualification of the WPS described in Table 4.4 - Plate T-test, "Single pass, maximum size to be used in production" without qualification of the "Multiple pass, minimum size to be used in construction" and subsequently using Table 4.5, Essential Variable 16), Note 3 to determine the WPS travel speeds for smaller size fillets by increasing the travel speed while maintaining the PQR wire feed speed?

Response: (1) Yes, qualification of a single pass, maximum size fillet weld to be used in construction may be performed without performing the multiple pass, minimum size fillet weld to be used in construction qualification that is shown in Table 4.4.
(2) Yes, for the same PQR wire feed speed (as permitted in Note 3 of Table 4.5), smaller single pass fillet welds may be performed by increasing travel speed as restricted by Essential Variable 16.