AWS D1.1 Interpretation

Subject: Bend Specimen Requirements for Pipe Welder Qualification
Code Edition: D1.1-90
Code Provision: Table 5.6
AWS Log: ID1-90-036-03

Inquiry: Table 5.6 of D1.1-90, under the heading “Job Size Pipe or Tubing” requires four side bends for material >4 in. in diameter, with a wall thickness >3/8 in. Figure 5.30 requires two side bends and two face bends for pipe with a wall thickness <3/8 in. When qualifying a welder for a groove weld in the 6G position using 5-in. pipe, 3/8 in. wall thickness, which is required-four side bends, or two face and two not bends?

Response: According to AWS D1.1-90, the material size and thickness would require four side bends (per Table 5.6). Figure 5.30 is to be used for location of the bend samples only.