AWS D1.1 Interpretation

Subject: Prequalified Flare Bevel Groove Weld Radius
Code Edition: D1.1-90
Code Provision: Figure 2.5 and Table 2.1
AWS Log: IR1-90-009-01/02

Inquiry: Should not the dimension “C” in Figure 2.5(10) of D1.1-90, flare-bevel-groove weld, to stated as a radius to be consistent with Table 2.1?

Response: NO. Figure 2.5(10) is a special case applicable to cold formed tubes. Practical experience has shown that corners of cold formed tubes are not standardized, for all manufacturers do not have symmetrical corners or quadrant corners. The designer cannot reliably know the radius of cold formed tubes; however, he may specify thickness. A reliable average ratio of radius-to-wall thickness is 2, therefore, Table 2.1 and Figure 2.5(10) are essentially equivalent.