

Underwater Welding Code



American Welding Society



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An American National Standard

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American National Standards Institute
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Underwater Welding Code

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Prepared by the
American Welding Society (AWS) D3 Committee on Welding in Marine Construction

Under the Direction of the
AWS Technical Activities Committee

Approved by the
AWS Board of Directors

Abstract

This Code covers the requirements for welding structures or components under the surface of water. It includes welding in both dry and wet environments. Clauses 1 through 6 constitute the general requirements for underwater welding while clauses 7 through 9 contain the special requirements applicable to three individual classes of weld:

Class A—Comparable to above-water welding

Class B—For less critical applications

Class O—To meet the requirements of another designated code or specification



American Welding Society

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Dedication

The D3 Committee on Welding in Marine Construction dedicates this edition of AWS D3.6M, Underwater Welding Code, to the memory of Conway E. 'Whitey' Grubbs.

C. E. 'WHITEY' GRUBBS
1918–2004

Whitey passed away in June 2004 at the age of 85 and is considered by many in the field as the father of underwater wet welding. During his more than 30 years of dedication to underwater welding, Whitey founded the AWS committee that established the standard for underwater welding, and served as its Chairman from 1974 to 1988. He authored more than 50 papers on underwater welding, received numerous awards for his contributions, and held three patents. He was the first to design and use the scallop sleeve splice for connecting tubular members by wet welding. Whitey retired from Global Industries as the Director of Underwater Welding Research. He was a friend and mentor to many in the industry today.

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Foreword

This foreword is not part of AWS D3.6M:2010, *Underwater Welding Code*, but is included for informational purposes only.

In 1975, the AWS Committee on Marine Construction requested the Subcommittee on Underwater Welding to establish a standard reflecting state-of-the-art technology relative to underwater welding. The first edition of the Code was published in 1983, with subsequent editions issued in 1989, 1993, and 1999.

This edition is presented with the SI units of measure being the standard. The U.S. Customary Units are approximate and for information only. Clauses 1 through 6 constitute the general requirements applicable to all classes of underwater welds. Clauses 7 through 9 contain unique requirements applicable to each class.

Initially applied as a means of temporary repair for damaged steel-hulled vessels, underwater welding has evolved into an accepted method of construction and repair of engineered structures. Recent applications include engineered repair and alteration of off-shore structures, submerged marine pipelines, underwater port facilities and nuclear power plant components.

There are five basic methods of underwater welding currently in use:

- (1) Welding in a pressure vessel in which the pressure is reduced to approximately one atmosphere, independent of depth (dry welding at one atmosphere).
- (2) Welding at ambient pressure in a large chamber from which water has been displaced in an atmosphere such that the welder/diver does not work in diving equipment (dry welding in a habitat).
- (3) Welding at ambient pressure in a simple open-bottomed dry chamber that accommodates, as a minimum, the head and shoulders of the welder/diver in full diving equipment (dry chamber welding).
- (4) Welding at ambient pressure in a small, transparent, gas-filled enclosure with the welder/diver outside in the water (dry spot welding).
- (5) Welding at ambient pressure with the welder/diver in the water without any mechanical barrier between the water and the welding arc (wet welding).

No sharp distinction exists between these methods; intermediate degrees of weldment and welder protection from the water are in use. Metal-transfer characteristics, solidification behavior, weld appearance, mechanical properties, and other characteristics can vary with pressure, and each method of welding may differ from its usual behavior with conventional surface welding. Special quality requirements and inspection procedures must be established for underwater welds because of the altered environment and accessibility. This document is intended to define the important variables associated with underwater welding and to describe welding and inspection procedures so that work of a known quality level can be conveniently specified.

Three weld classes (A, B, and O) are specified herein. They encompass the range of quality and properties currently produced by application of the various methods. Each weld class defines a set of criteria for weldment properties that must be established during qualification, and a set of weld soundness requirements that are to be verified during construction. Welds in each class must meet all the criteria specified for that class. This Code does not address the selection of the class that meets the service requirements of a particular application. The selection of the class of weld to be provided is to be prescribed by the customer.

Comments and suggestions for the improvement of this standard are welcome. They should be addressed to the Secretary, AWS D3B Subcommittee on Underwater Welding, American Welding Society, 550 N.W. LeJeune Road, Miami, FL 33126.

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Table of Contents

	Page No.
<i>Dedication</i>	v
<i>Personnel</i>	vii
<i>Foreword</i>	ix
<i>List of Tables</i>	xiv
<i>List of Figures</i>	xiv
<i>List of Forms</i>	xv
1. General Provisions	1
1.1 Scope	1
1.2 Normative References	1
1.3 Purpose	2
1.4 Application	2
1.5 Base Metals	2
1.6 Welding Process	2
1.7 Definitions	3
1.8 Welding and NDE Symbols	3
1.9 Safety and Health	3
1.10 Standard Units of Measure	3
2. Classification and Design of Welded Connections	5
2.1 Classification of Welds	5
2.2 Design	5
3. Workmanship	6
3.1 General	6
3.2 Base Metal Preparation	6
3.3 Assembly	6
3.4 Confirmation Weld	6
3.5 Dimensional Tolerances	7
3.6 Weld Profiles	8
3.7 Tack Welds and Temporary Welds	8
3.8 Repair	8
3.9 Peening	8
3.10 Arc Strikes	8
3.11 Weld Cleaning	8
4. Technique	9
4.1 Filler Metal	9
4.2 Measurement of Variable Conditions	9
4.3 Weld Temperature Control	9
5. Qualification	10
Part I—General Requirements	10
5.1 Approved Procedure	10
5.2 Previous Qualification	10
5.3 Performance Qualification	10
5.4 Qualification Responsibility	10

Part II—Procedure Qualification	10
5.5 Limitation of Variables	10
5.6 Procedure Qualification Variables	14
5.7 Types of Tests	15
5.8 Position of Test Welds	15
5.9 Joint Configuration	20
5.10 Test Specimens: Number and Type	22
5.11 Preparation and Testing of Specimens	23
5.12 Test Results Required	29
5.13 Supplemental Requirements	30
5.14 Records	30
Part III—Welder Qualification	30
5.15 General	30
5.16 Limitations of Variables	31
5.17 Qualification Tests Required	33
5.18 Method of Testing	38
5.19 Tests Results Required	38
5.20 Retests	38
5.21 Period of Effectiveness	38
5.22 Records	42
6. Inspections	47
Part I—General Requirements	47
6.1 General	47
6.2 Inspection of Materials	47
6.3 Inspection of Equipment	47
6.4 Verification of Procedure and Performance Qualification	47
6.5 Inspection of Work and Records	47
6.6 Obligations of Contractor	48
6.7 Inspection Methods	48
6.8 Inspection Personnel Qualification	48
Part II—Visual Examination	49
6.9 General	49
6.10 Procedure	49
Part III—Radiographic Examination	49
6.11 General	49
6.12 Procedure	50
Part IV—Ultrasonic Examination	50
6.13 General	50
6.14 Procedure	50
Part V—Magnetic Particle Examination	52
6.15 General	52
6.16 Procedure	54
Part VI—Eddy Current Examination	55
6.17 General	55
6.18 Procedure	55
7. Class A Welds	56
7.1 Application	56
Part I—Procedure Qualification	56
7.2 Testing Requirement	56
7.3 Groove Welds	56
7.4 Fillet Welds	60

Part II—Welder Qualification	61
7.5 Testing Requirements	61
7.6 Groove Welds	61
7.7 Fillet Welds	62
Part III—Examination	62
7.8 Examination Requirements	62
7.9 Visual Acceptance Criteria	64
7.10 Radiographic and Macroetch Test Acceptance Criteria	64
7.11 Surface Examination Acceptance Criteria	65
7.12 Ultrasonic Examination Acceptance Criteria	66
8. Class B Welds	71
8.1 Application	71
Part I—Procedure Qualification	71
8.2 Testing Requirement	71
8.3 Groove Welds	71
8.4 Fillet Welds	75
Part II—Welder Qualification	76
8.5 Testing Requirements	76
8.6 Groove Welds	76
8.7 Fillet Welds	76
Part III—Examination	76
8.8 Examination Requirements	76
8.9 Visual Acceptance Criteria	79
8.10 Radiographic and Macroetch Test Acceptance Criteria	79
8.11 Surface Examination Acceptance Criteria	81
9. Class O Welds	82
9.1 Application	82
Part I—Procedure Qualification	82
9.2 Testing Requirements	82
9.3 Groove Welds	82
9.4 Fillet Welds	84
Part II—Welder Qualification	84
9.5 Requirements	84
Part III—Examination	84
9.6 Examination Requirements	84
9.7 Acceptance Criteria	84
Annex A (Informative)—Sample Welding Forms	85
Annex B (Informative)—Terms and Definitions	99
Annex C (Informative)—Commentary on AWS D3.6M:2010, Underwater Welding Code	101
Annex D (Informative)—Recommended Guidelines for Safety in Underwater Welding	111
Annex E (Informative)—References	113
Annex F (Informative)—Guidelines for the Preparation of Technical Inquiries for Structural Welding Committee	119
Index	121
List of AWS Documents on Marine Welding	125

List of Tables

Table	Page No.
5.1	Welding Variables—Dry Welding by Shielded Metal Arc, Gas Metal Arc, Flux Cored Arc, Gas Tungsten Arc, and Plasma Arc Welding Process 11
5.2	Welding Variables—Wet Welding by Shielded Metal Arc or Flux Cored Arc Welding 13
5.3	Depth Limitation for Qualification Welding 15
5.4	Procedure Qualification—Type and Position Limitations 16
5.5	Positions for Welder Qualification 46
5.6	Pipe Diameter Groups for Welder Qualification 46
7.1	Weld Procedure Qualification—Number and Type of Test Specimens for Class A Welds 57
7.2	Weld Procedure Qualification—Mechanical Test Acceptance Criteria for Class A Welds 61
7.3	Welder Performance Qualification—Number and Type of Test Specimens for Class A Welds 62
8.1	Weld Procedure Qualification—Number and Type of Test Specimens for Class B Welds 72
8.2	Weld Procedure Qualification—Mechanical Test Acceptance Criteria for Class B Welds 75
8.3	Welder Performance Qualification—Number and Type of Test Specimens for Class B Welds 79
9.1	Weld Procedure Qualification—Number and Type of Test Specimens for Class O Welds 83

List of Figures

Figure	Page No.
3.1	Tolerances in Assembly of Groove Weld Butt Joints—Dry Welding 7
5.1	Positions of Groove Welds 17
5.2	Positions of Fillet Welds 18
5.3	Positions of Test Plates for Groove Welds 19
5.4	Positions of Test Pipe or Tubing for Groove Welds 21
5.5	Positions of Test Plates for Fillet Welds 23
5.6	Positions of Test Pipes for Fillet Welds 24
5.7	Reduced-Section Tension Specimens 25
5.7A	Reduced-Section Tension Specimens (U.S. Customary Units) 26
5.8	Fillet Weld Break and Macroetch Test Specimens 27
5.8A	Fillet Weld Break and Macroetch Test Specimens (U.S. Customary Units) 28
5.9	Lap Joint Fillet Macroetch Test Assembly and Specimen Location 29
5.10	Face- and Root-Bend Specimens 30
5.10A	Face- and Root-Bend Specimens (U.S. Customary Units) 31
5.11	Side-Bend Specimens 32
5.11A	Side-Bend Specimens (U.S. Customary Units) 33
5.12	Bend Test Jigs 34
5.12A	Bend Test Jigs (U.S. Customary Units) 35
5.13	All-Weld-Metal Tension and Impact Specimen Test Plate Design and Specimen Locations 36
5.13A	All-Weld-Metal Tension and Impact Specimen Test Plate Design and Specimen Locations (U.S. Customary Units) 37
5.14	All-Weld-Metal Tension Test Specimen Design 38
5.14A	All-Weld-Metal Tension Test Specimen Design (U.S. Customary Units) 39
5.15	Location of Charpy V-Notch Impact Test Specimen in Test Weld 39
5.16	Fillet Weld Shear Strength Specimens—Longitudinal from Plate 40
5.16A	Fillet Weld Shear Strength Specimens—Longitudinal from Plate (U.S. Customary Units) 41

5.17	Fillet Weld Shear Strength Specimens—Transverse from Plate	42
5.17A	Fillet Weld Shear Strength Specimens—Transverse from Plate (U.S. Customary Units)	43
5.18	Transverse Weld Shear Strength Test Coupon for Pipe	44
5.18A	Transverse Weld Shear Strength Test Coupon for Pipe (U.S. Customary Units).	44
5.19	Bridge Bend Test.	45
6.1	Ultrasonic Scanning Techniques.	53
6.2	Discontinuity Evaluation.	54
7.1	Location and Type of Test Specimens on Welded Plate Test Procedure Qualification Assembly, Class A Groove Welds	58
7.1A	Location and Type of Test Specimens on Welded Plate Test Procedure Qualification Assembly, Class A Groove Welds (U.S. Customary Units).	59
7.2	Location and Types of Test Specimens on Welded Pipe Test Procedure Qualification Assembly, Class A Groove Welds in Pipe	60
7.3	Type and Location of Bend Test Specimens for Welder Qualification, Class A Groove Welds	63
7.4	Test Assembly for T-, Y-, and K-Connections on Pipe or Square or Rectangular Tubing—Welding Procedure and Welder Performance Qualification, Class A Welds	64
7.4A	Test Assembly for T-, Y-, and K-Connections on Pipe or Square or Rectangular Tubing—Welding Procedure and Welder Performance Qualification, Class A Welds (U.S. Customary Units).	65
7.5	Acceptable and Unacceptable Weld Profiles for Class A Welds	66
7.6	Ultrasonic Inspection Acceptance Criteria	67
7.6A	Ultrasonic Inspection Acceptance Criteria (U.S. Customary Units).	69
8.1	Location and Types of Test Specimens on Welded Plate Test Procedure Qualification Assembly, Class B Groove Welds	73
8.1A	Location and Types of Test Specimens on Welded Plate Test Procedure Qualification Assembly, Class B Groove Welds (U.S. Customary Units).	74
8.2	Location and Types of Test Specimens on Welded Pipe Test Procedure Qualification Assembly, Class B Groove Welds in Pipe	75
8.3	Type and Location of Bend Test Specimens for Welder Qualification, Class B Groove Welds	77
8.4	Test Assembly for T-, Y-, and K-Connections on Pipe or Square or Rectangular Tubing—Welding Procedure and Welder Performance Qualification, Class B Welds	78
8.4A	Test Assembly for T-, Y-, and K-Connections on Pipe or Square or Rectangular Tubing—Welding Procedure and Welder Performance Qualification, Class B Welds (U.S. Customary Units).	78
8.5	Acceptable and Unacceptable Weld Profiles for Class B Welds	80

List of Forms

Form		Page No.
A-1	Welding Procedure Specification—Wet Welding and Dry Hyperbaric Welding.	86
A-2	Procedure Qualification Record (PQR)—Wet Welding Variables.	90
A-3	Welder or Welding Operator Performance Qualification Test Record—Wet Welding Process	92
A-4	Procedure Qualification Record (PQR)—Dry Hyperbaric Welding Variables.	93
A-5	Welder or Welding Operator Performance Qualification Test Record—Dry Welding Processes	95
A-6	Ultrasonic Examination Report Form	96
A-6A	Ultrasonic Examination Report Form (U.S. Customary Units)	97

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Underwater Welding Code

1. General Provisions

1.1 Scope. This Code covers underwater welding in both dry and wet environments. All provisions of this document apply equally to new construction and to modification and repair of existing structures underwater.

1.2 Normative References. The following standards contain provisions which, through reference in this text, constitute mandatory provisions of this AWS standard. For undated references, the latest edition of the referenced standard shall apply. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply.

AWS Documents¹:

AWS A2.4, *Standard Symbols for Welding, Brazing, and Nondestructive Testing*

AWS A3.0, *Standard Method for Standard Welding Terms and Definitions*

AWS B4.0, *Mechanical Testing of Welds*

AWS D1.1, *Structural Welding Code—Steel*

Other Documents:

ANSI Z49. 1, *Safety in Welding, Cutting and Allied Processes*²

API RP2X, *Recommended Practice for Ultrasonic and Magnetic Examination of Offshore Structural Fabrication and Guidelines for Qualification of Technicians*³

ASME BPV Code, Section IX, QW-470, *Etching Processes and Reagents*⁴

ASNT SNT-TC-1A, *Recommended Practice*⁵

ASTM A 370, *Standard Methods and Definitions for Mechanical Testing of Steel Products*⁶

ASTM E 92, *Test Method for Vickers Hardness of Metallic Materials*

ASTM E 164, *Standard Practice for Ultrasonic Contact Examination of Weldments*

ASTM E 165, *Standard Test Method for Liquid Penetrant Examination*

ASTM E 309, *Standard Practice for Eddy-Current Examination of Steel Tubular Products using Magnetic Saturation*

ASTM E 340, *Standard Test Method for Macroetching Metals and Alloys*

ASTM E 426, *Standard Practice for Electromagnetic (Eddy-Current) Examination of Seamless and Welded Tubular Products Austenitic Stainless Steel and Similar Alloys*

ASTM E 709, *Guide for Magnetic Particle Examination*

ASTM E 1219, *Standard Test Method for Fluorescent Liquid Penetrant Examination Using the Solvent-Removable Process*

ASTM E 1220, *Standard Test Method for Visible Liquid Penetrant Examination Using the Solvent-Removable Process*

ASTM E 1416, *Standard Test Method for Radioscopic Examination of Weldments*

¹ AWS standards are published by the American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126.

² This ANSI standard is published by the American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126.

³ API standards are published by the American Petroleum Institute, 1220 L Street, NW, Washington, DC 20005-4070.

⁴ ASME Codes are published by the American Society for Mechanical Engineers, Three Park Avenue, New York, NY 10016-5990.

⁵ ASNT standards are published by the American Society for Nondestructive Testing, PO Box 28518 1711 Arlingate Lane, Columbus, OH 43228-0518.

⁶ ASTM standards are published by the American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM E 1444, Standard Practice for Magnetic Particle Examination

ISO 148, Steel—Charpy Impact Test (V-Notch)⁷

ISO 3452, Nondestructive Testing—Penetrant Inspection—General Principles *ISO 4136, Fusion Welded Butt Joints in Steel—Transverse Tensile Test*

ISO 4969, Steel—Macroscopic Examination by Etching with Strong Mineral Acids *ISO 6892, Metallic Materials—Tensile Testing at Ambient Temperature*

ISO 6947, Welds—Working Positions—Definitions of Angles of Slope and Rotation

ISO 9304, Seamless and Welded (Except Submerged Arc Welded) Steel Tubes for Pressure Purposes—Eddy Current Testing for the Detection of Imperfections

ISO/DIS 9015.2, Welding—Welded Joints in Metallic Materials—Hardness Testing

ISO/DIS 9016.2, Welding—Welded Joints in Metallic Materials—Specimen Location and Notch Orientation for Impact Tests

1.3 Purpose. This Code addresses fabrication and quality standards for underwater welding. This document may be used in conjunction with other applicable codes or specifications for design, construction, or repair.

1.4 Application

1.4.1 All references to the need for approval shall be interpreted to mean approval by a duly designated person acting for and in behalf of the Customer on all matters within the scope of this Code. The Customer may designate an engineer, inspector, or other(s) to act in the Customer's behalf to ensure that the requirements of this Code are fulfilled. The Customer should specify the authority of the authorized representatives. Hereinafter, the term *Customer* shall be used to mean the party contracting for the work or the authorized representative.

1.4.2 In this Code, the term "shall" indicates a mandatory requirement and has the significance of excluding the idea of discretion. The word "should" indicates a nonmandatory recommended practice. The word "may" implies no obligation and expresses liberty or permission.

1.4.3 Where alternative requirements are permitted by the specification, all requirements that modify this Code shall be incorporated into contract documents.

1.4.4 For **Class O** welds (see 2.1.6 and 5.6), conflicts between referenced documents and this document shall be brought to the attention of the Customer for disposition. In general, the referenced documents may take precedence in matters not affected by the underwater environment. However, this document shall take precedence in matters related to the underwater welding environment and working conditions.

1.5 Base Metals

1.5.1 This standard covers the welding of carbon and low alloy steels, and austenitic stainless steels. The weldability of the steel and the procedures for welding it shall be established by qualification. Both carbon equivalence and strength of carbon and low alloy steels are critical variables for underwater welding. Production welding on carbon and low alloy base metal of carbon equivalence or strength above that qualified shall require requalification of the procedure.

1.5.2 This Code may be used for welding of other base metals. In such cases, applicability of specific requirements shall be determined by the Customer.

1.6 Welding Process

1.6.1 Gas metal arc welding (GMAW), gas tungsten arc welding (GTAW), flux cored arc welding (FCAW), plasma arc welding (PAW), and shielded metal arc welding (SMAW) are the principal joining processes addressed by this Code. These processes may be used, provided the welding procedure is qualified in accordance with all applicable requirements of this document.

1.6.2 Other welding processes may be used at the discretion of the Customer, provided the applicable qualification requirements of this Code are met.

⁷ ISO standards are published by the International Organization for Standardization, 1 rue de Varembe, Case postale 56, CH-1211 Geneva 20, Switzerland.

1.7 Definitions. The welding terms used in this Code shall be interpreted in accordance with the definitions given in the latest edition of ANSI/AWS A3.0, *Standard Welding Terms and Definitions*, supplemented by Annex B of this document (AWS D3.6M).

1.8 Welding and NDE Symbols. Welding and examination symbols shall be those shown in ANSI/AWS A2.4, *Standard Symbols for Welding, Brazing, and Nondestructive Examination*. Special conditions shall be fully explained by added notes or details.

1.9 Safety and Health. Safety and health issues and concerns are beyond the scope of this standard and, therefore, are not fully addressed herein. Safety and health information is available from other sources, including, but not limited to, ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*, and applicable federal and state regulations. Annex D provides some guidance relative to safety in underwater welding and cutting. Additional pertinent welding safety information can be found in the documents referenced in Annex E. In addition, manufacturer's safety literature on equipment and materials, as well as other pertinent documents, should be considered. Each contractor must determine independently whether the safety precautions contained in the referenced publications are adequate.

1.10 Standard Units of Measure. This standard makes sole use of International System of Units (SI). Approximate mathematical equivalents in U.S. Customary Units are provided for comparison in parentheses or in appropriate columns in tables and figures.

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2. Classification and Design of Welded Connections

2.1 Classification of Welds

2.1.1 A weld class specifies a level of serviceability and a set of required properties, as defined by mechanical tests, surface appearance, and nondestructive examination requirements, to which welds of a given class must conform.

2.1.2 In any solicitation for work, contract, or bid, the Customer shall specify each weld class and any supplementary requirements for the proposed work. All welds produced in accordance with this Code shall be made in accordance with a qualified welding procedure and shall meet the general requirements applicable to all weld classes specified in clauses 1 through 6 and the unique requirements for one or more of the weld classes specified in this clause. Each designated weld must meet all the requirements for the weld class specified.

2.1.3 Toughness and hardness of weldments that are made underwater may be significantly different from those properties of similar weldments made above the surface. The Customer may specify supplemental hardness and toughness requirements for any class of weld.

2.1.4 Class A Welds. Class A underwater welds are intended to be suitable for applications and design stresses comparable to their conventional surface welding counterparts by virtue of specifying comparable properties and testing requirements. The unique requirements for Class A welds are specified in clause 7. Additional requirements may be appropriate for critical applications, and should be agreed to in advance and specified in the contract document.

2.1.5 Class B Welds. Class B underwater welds are intended for less critical applications where lower ductility, moderate porosity, and other limited discontinuities can be tolerated. The unique requirements for Class B welds are specified in clause 8. The suitability of a Class B weld for a particular application should be evaluated on a “Fitness for Purpose” basis.

2.1.6 Class O Welds. Class O underwater welds must meet the requirements of another designated code or standard, as well as additional requirements, specified herein, to cope with the underwater welding environment. The unique requirements for Class O welds are specified in Clause 9. The Customer shall specify the standard that applies to this class of weld.

2.2 Design. This Code does not address design considerations such as arrangement of parts or stress calculations. The Customer shall determine the service conditions, the required performance level, and the appropriate design stress level. The Customer shall specify the weld class, inspection method, and acceptance criteria.

3. Workmanship

3.1 General. All welds produced in accordance with this Code shall be examined using the criteria specified for the particular weld class. This requirement is met when the results of all required examinations are submitted to and accepted by the Customer.

3.2 Base Metal Preparation

3.2.1 Corrosion pits or other discontinuities that would adversely affect the integrity of the weld shall be repaired. When repair by welding is required, the welding procedure shall be qualified to the Code requirements of Clause 5 for the weld class specified. The repair procedure shall be submitted to the Customer for approval before weld repair begins. The surfaces to be welded and the surfaces adjacent to the weld shall be free from scale, paint, marine growth, or other foreign matter.

3.2.2 In the repair of excessive discontinuities observed on cut edges, such as entrapped slag, refractory inclusions, deoxidation products, porosity, or blow holes, the amount of metal removed shall be the minimum necessary to eliminate the discontinuity, unless otherwise specified in the repair procedure.

3.2.3 Laminations in plate edges may, with the approval of the Customer, be repaired by welding. The repair shall include complete removal of the lamination or removal of metal to a distance equal to the lesser of half of the base metal thickness or 10 mm (3/8 in) from the original prepared edge, using a method described in the approved repair procedure. Welding shall be performed with procedures qualified for production welding or with procedures qualified specifically for the repair. The Customer shall be notified before repair commences.

3.3 Assembly

3.3.1 Dry Welding

3.3.1.1 Tolerances for the weld preparation and joint fit-up shall be developed during welding procedure qualification. Alternatively, the tolerances given on Figure 3.1 may be applied to groove welds. In either case, the qualified welding procedure shall define the limits.

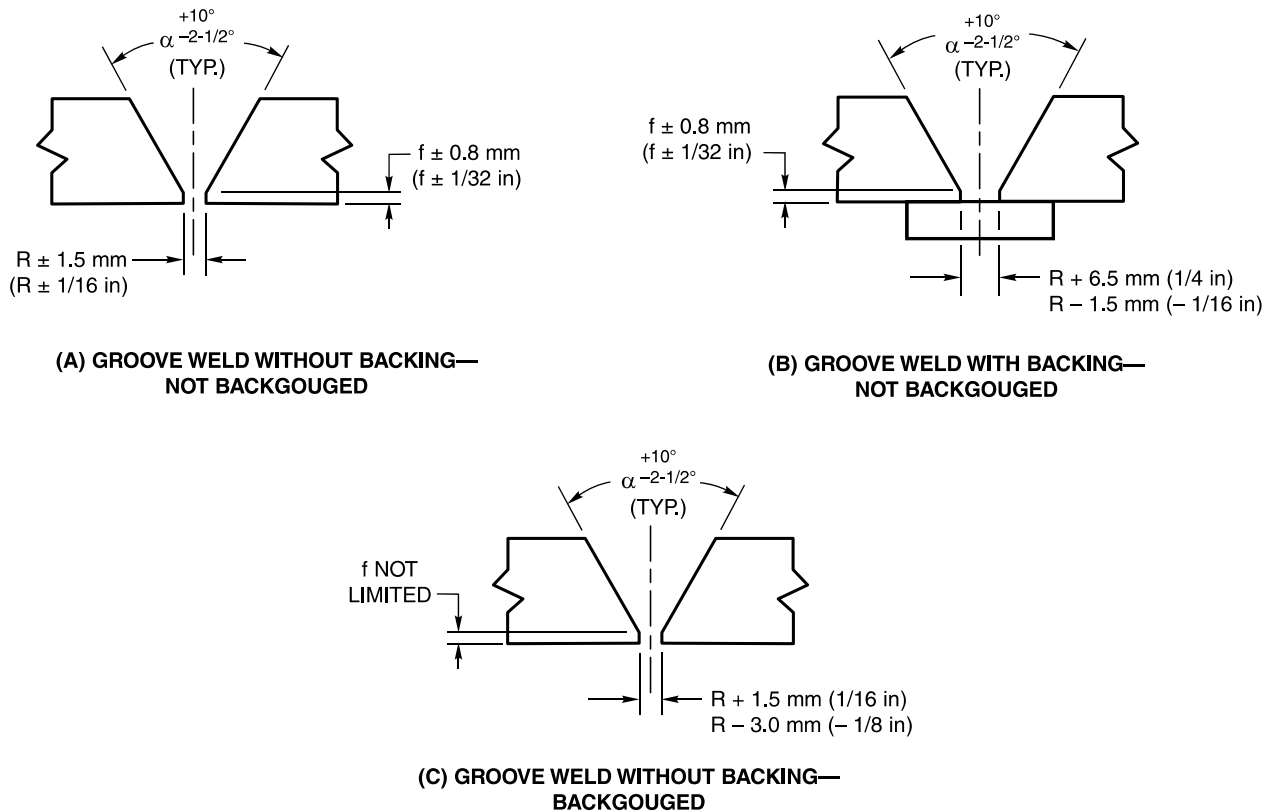
When the joint includes backing, the separation between faying surfaces of butt joints landing on a backing shall not exceed 1.5 mm (1/16 in). Where irregularities prevent alignment or fit-up to limits qualified in the welding procedure, the methods used to meet those limits shall be subject to the Customer's approval. Welding procedures required to achieve the correct fit shall also be qualified under the rules of this Code.

3.3.1.2 The parts to be joined by fillet welds shall be brought into as close contact as practical. The root opening shall not exceed the maximum permitted by the qualified welding procedure. If the root opening cannot be closed to meet this tolerance, a suitable compensating technique approved by the Customer shall be required. If the root opening is greater than 1.5 mm (1/16 in), the leg(s) of the fillet welds shall be increased by the amount of the root opening.

3.3.2 Wet Welding. Joint assembly tolerances shall be developed during welding procedure qualification. The assembly and fit-up tolerances shall be defined in the qualified welding procedure and approved by the Customer prior to the start of production welding.

3.4 Confirmation Weld. Unless otherwise specified by the Customer, the requirements of 3.4.1, 3.4.2, 3.4.3, and 3.4.4 apply.

3.4.1 General. Prior to production underwater welding, a confirmation weld test shall be satisfactorily completed at the job site at the depth at which production welding will take place. At least one confirmation weld, excluding automated



Notes:

 α – Groove single

R – root opening

f – root face

The groove configurations shown are for illustration only.

Figure 3.1—Tolerances in Assembly of Groove Weld Butt Joints—Dry Welding

welding, shall be satisfactorily completed for each welding system to be used during production. The confirmation test weld shall be a fillet break weld conforming to the requirements of 5.11.7 except that the length shall be a minimum of 200 mm (8 in). Unless otherwise specified by the Customer, the requirements of 3.4.2, 3.4.3, and 3.4.4 apply.

3.4.2 Base Metals. The base metal for the confirmation weld should be 10 mm (3/8 in) minimum thickness and carbon equivalent within 0.05 of the maximum CE of the base metal welded in production.

3.4.3 Position. Where the production weld is to be made in only one welding position, the confirmation weld shall be made in that position. Where welding in more than one position is necessary, the confirmation weld shall be made in the position in production in which the majority of welding will be done or as directed by the Customer.

3.4.4 Examination Requirements. Each confirmation weld shall undergo visual inspection and fillet break testing. Macroetch testing shall not be required. The test plate may be cut into smaller sections by any convenient means (e.g., thermal cutting) to facilitate breaking. However, cutting shall not interfere with evaluation of the root pass start and stop. Acceptance criteria shall be as specified in Clause 7, 8, or 9 for the class of weld.

3.5 Dimensional Tolerances. The sizes and lengths of welds shall not be smaller than those specified. Fillet weld sizes shall not exceed the specified sizes by more than 25 percent or 3 mm (1/8 in), whichever is greater. The lengths of the weld shall not exceed the specified length by more than 25 mm (1 in) or 15 percent, whichever is greater, without the Customer's approval. The location of welds shall not be changed without the approval of the Customer.

3.6 Weld Profiles. All welds shall meet the visual acceptance criteria for weld profiles as defined in Part III of Clauses 7 through 9 for Class A through O welds, respectively.

3.7 Tack Welds and Temporary Welds

3.7.1 All tack welds incorporated in the final weld shall be subject to the same qualification requirements and acceptance criteria as the final welds.

3.7.2 The location and dimensions of temporary welds shall be subject to prior approval by the Customer. Temporary welds, including tack welds that are not incorporated in the final weld, shall be removed, unless otherwise permitted by the Customer. Removal of temporary welds shall be accomplished using a procedure that does not cause damage to the base metal. Temporary welds not removed shall conform to the requirements of this Code for the class of weld selected.

3.8 Repairs

3.8.1 The removal of weld metal or portions of the base metal shall be done by a method approved by the Customer, and in such a manner that the remaining weld metal or base metal is not damaged. The surfaces shall be restored to a suitable condition before rewelding.

3.8.2 Flaws may be removed by grinding. The base metal thickness shall not be reduced below the required minimum thickness. If the required minimum base metal thickness is violated, the thickness shall be restored by welding, using a qualified procedure.

3.8.3 Prior approval shall be obtained from the Customer for all corrections. The repaired or replaced weld shall be reinspected using the technique and acceptance criteria as originally specified.

3.8.4 The correction shall be in accordance with the original welding procedure or with a procedure prepared specifically for the repair, and qualified in accordance with this Code.

3.9 Peening. The root layer shall not be peened. Peening of subsequent beads shall be permitted only with prior approval of the Customer. Care shall be taken to prevent slag entrapment, overlap, or cracking of the welds. The cap or toe of a finished weld may be peened with a blunt instrument, when approved by the Customer, but such peening shall be preceded by all required nondestructive examination and followed by an additional examination using magnetic particle methods.

3.10 Arc Strikes. Arc strikes outside the area of permanent welds should be avoided on any base metal. Cracks or blemishes caused by arc strikes shall be ground to a smooth contour under the restrictions stated in 3.8.2.

3.11 Weld Cleaning. After completion of a weld, the weldment surfaces shall be cleaned and prepared such that surface finish conditions will not interfere with inspections or nondestructive examinations to be employed. Excessive slag and spatter shall be removed from the weld and adjacent base metal. Surface discontinuities which could mask weld defects shall be removed.

4. Technique

4.1 Filler Metal

4.1.1 After filler metals are removed from their original package, they shall be protected or stored so that their characteristics and welding properties are not adversely affected. Surface storage conditions shall conform to the filler metal manufacturer's recommended practice, or an alternate written procedure shall be submitted to the Customer for approval.

4.1.2 There shall be no addition or deletion of electrode coatings (e.g., waterproofing) from those used during welding procedure qualification.

4.1.3 Methods of underwater transport and storage of filler metals shall be specified in the welding procedure.

4.2 Measurement of Variable Conditions. Effective means of verifying variables (such as welding current, arc voltage, and shielding gas composition and flow rate) should be provided at the location underwater where the welding is to be performed. If not measured at the weld location, provisions shall be made to ensure that compensation has been made for the effects of the leads, ambient pressure, and other operating conditions. Records of welding variables to be maintained during production shall be as specified by the Customer.

4.3 Weld Temperature Control. Where weld temperature control is utilized during procedure qualification, the procedure qualification record shall state the required temperature range and the time at temperature. The method used for temperature measurement and control and the maximum and minimum heating and cooling rates at temperatures exceeding 260°C (500°F) shall be specified.

5. Qualification

Part I

General Requirements

5.1 Approved Procedure

5.1.1 Procedure Specification. All welding shall be performed in accordance with a Welding Procedure Specification (WPS) which meets the requirements of this clause. The WPS employed shall be qualified prior to production welding in accordance with the requirements of this clause. Satisfactory evidence that the procedure has been qualified shall be submitted to the Customer in the form of a Procedure Qualification Record (PQR) supporting the WPS and approved by the Customer prior to any production welding.

5.1.2 Procedure Qualification. A welding procedure specification shall be qualified by testing weldments produced under actual or simulated site conditions. The test welds shall demonstrate that a joint of required integrity can be made within the essential variables of the procedure specification. The specific tests required for each weld class are identified in Part I of Clauses 7 through 9 for Class A through O welds, respectively.

5.2 Previous Qualification. The Customer may accept evidence of previous qualification, provided all the requirements of this standard are met.

5.3 Performance Qualification. All persons performing any welding shall be qualified for a given weld class in accordance with this clause. Satisfactory evidence that the requirements are met shall be submitted to and approved by the Customer prior to any production welding.

Welders qualified to deposit Class A welds are also qualified to deposit Class B welds in the same environment qualified.

5.4 Qualification Responsibility. Each Contractor shall be responsible for the qualification of welding procedures and welders employed in performing work to this standard and shall conduct the tests required to accomplish these qualifications. Satisfactory evidence that the procedure and welders have been qualified shall be submitted to and approved by the Customer prior to production welding.

Part II

Procedure Qualification

5.5 Limitation of Variables

5.5.1 Essential and Nonessential Variables. Each welding variable described in 5.6 shall be designated as either an essential or nonessential variable for each process.

5.5.2 Limitations on Essential and Nonessential Variables. Changes in essential variables beyond the limits specified in Table 5.1 (Dry Welding Variables) and Table 5.2 (Wet Welding Variables) require development and qualification of a separate procedure or revision and requalification of an existing welding procedure. The qualified ranges of essential variables are those used during the procedure qualification test. Changes may be made in the nonessential variables without requalification of the procedure. This may be documented by revising or amending the original Welding Procedure Specification (WPS) or by preparing a new WPS.

5.5.3 Electrical Measurement Accuracy. Electrical measurements made under qualification and production conditions will involve different levels of accuracy. Accordingly, the electrical ranges discussed in this Code shall be considered nominal values.

Table 5.1
Welding Variables

Dry Welding by Shielded Metal Arc, Gas Metal Arc, Flux Cored Arc, Gas Tungsten Arc, and Plasma Arc Welding Processes

A. Variables Common to all Welding Processes

1. Joints

(a) Fillet weld to groove weld	Essential
(b) Multiple pass fillet weld to single pass fillet weld and vice versa	Essential
(c) Omission of backing	Essential
(d) A backing thickness change of 1.5 mm (1/16 in) or 25%, whichever is greater	Essential
(e) Groove shape: a decrease in included angle, a decrease in root opening, or an increase in root face beyond the range specified in 5.9.3	Essential
(f) Groove weld to multiple pass fillet weld, subject to paragraph 5.9.2	Nonessential
(g) Fillet Weld Size: For single pass fillet welding procedure qualification, the production weld size (leg length) shall be 1.5S where S is the size of the qualification weld and smaller. For multiple pass fillet welding procedure qualification, the production weld size shall be the qualification size or larger.	Essential

2. Base Metal

(a) Thickness: For groove welding procedure qualification with a test plate or pipe thickness, t, the maximum production thickness shall be 1.5t. The minimum production plate or pipe thickness shall be 0.5t. Qualification on two different thicknesses of plate or pipe also qualifies all intermediate thicknesses	Essential
(b) A change in chemical composition beyond the limits of 5.6.1 except for carbon equivalent.	Essential
(c) An increase in specified minimum tensile strength beyond the greater of (a) the all-weld-metal tensile strength or (b) the tensile strength measured in the transverse tension test.	Essential

3. Filler Metal

(a) Filler metal Classification or type	Essential
(b) Procedure for underwater transport and storage, including (but not limited to) change from internally pressurized to unpressurized transfer containers.	Essential
(c) Addition or deletion of supplementary coatings	Essential
(d) An increase in exposure time of filler metal in the qualification depth atmosphere	Essential

4. Position

(a) Filler metal Classification or type	Essential
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5. Weldment Temperature

(a) A decrease in preheat or interpass temperature	Essential
(b) A decrease in postweld heat treatment temperature or time at postweld heat treatment temperature	Essential

6. Electrical Characteristics

(a) Welding current type (direct current electrode positive, direct current electrode negative, pulsed current, and others)	Essential
(b) Type of power source (constant current, constant voltage)	Essential
(c) Welding current	Essential

7. Technique

(a) Stringer bead to weave and vice versa	Essential
(b) Progression up or down	Essential
(c) Deletion of temper bead	Essential
(d) Decrease in accessibility or visibility from change in dimensions of shroud or components	Essential
(e) Change in travel speed or electrode run length	Essential
(f) Welding method (manual, semiautomatic, automatic)	Essential
(g) Joint cleaning	Essential
(h) Addition or elimination of peening	Essential
(i) Addition of temper bead	Nonessential
(j) Progression direction for the initial pass on joints welded from both sides where the root pass is backgouged to sound weld metal prior to welding the second side	Nonessential

(Continued)

Table 5.1 (Continued)
Welding Variables

8. Environment	
(a) Change in depth beyond that allowed in 5.6.2	Essential
(b) Back side dry to wet	Essential
(c) Change in background gas composition or type or oxygen partial pressure beyond that associated with the depth allowance in 5.6.2	Essential
(d) Back side wet to dry	Nonessential
B. Shielded Metal Arc Welding	
3. Filler Metal	
(a) Manufacturer	Essential
(b) Manufacturer's trade name	Essential
(c) In root, hot, and cap passes, a change in electrode diameter (standard size)	Essential
(d) In fill passes, use of an electrode with a diameter not used during overall qualification	Essential
6. Electrical Characteristics	
(a) Welding current exceeding +15% of the maximum, or –15% of the minimum of that qualified	Essential
C. Gas Metal Arc Welding	
3. Filler Metal	
(a) Manufacturer	Nonessential
(b) Manufacturer's trade name, for ERXXS-G(X) or EXXC-G(X) (AWS A5 .18 or A5.28)	Essential
(c) Manufacturer's trade name, except classification ERXXS-G	Nonessential
(d) Diameter	Essential
6. Electrical Characteristics	
(a) Welding current exceeding +10% of the maximum, or –10% of the minimum of that qualified	Essential
(b) Arc voltage exceeding +7% of the maximum, or –7% of the minimum of that qualified	Essential
(c) Mode of metal transfer (spray, globular, short-circuiting)	Essential
9. Shielding Gas	
(a) Nominal percentage composition or classification in AWS A5.32/A5.32M	Essential
(b) Flow rate changes exceeding +25% of the maximum, or –25% of the minimum of that qualified	Essential
(c) Nozzle orifice diameter (size change)	Essential
D. Flux cored Arc Welding	
3. Filler Metal	
(a) Manufacturer	Essential
(b) Manufacturer's trade name (even if both meet the same AWS Classification)	Essential
(c) Diameter	Essential
6. Electrical Characteristics	
(a) Welding current exceeding +10% of the maximum, or –10% of the minimum of that qualified	Essential
(b) Arc voltage exceeding +7% of the maximum, or –7% of the minimum of that qualified	Essential
(c) Mode of metal transfer (spray, globular)	Essential
9. Shielding Gas	
(a) Addition, or deletion or change in gas or classification in AWS A5.32/A5.32M	Essential
(b) Flow rate change exceeding +25% of the maximum, or –10% of the minimum of that qualified	Essential
(c) Nozzle orifice diameter (size change)	Essential
E. Gas Tungsten Arc and Plasma Arc Welding	
3. Filler Metal	
(a) Manufacturer	Nonessential
(b) Manufacturer's trade name (even if both meet the same AWS Classification)	Nonessential
(c) Diameter	Essential

(Continued)

Table 5.1 (Continued)
Welding Variables**6. Electrical Characteristics**

(a) Welding current exceeding +10% of the maximum, or –10% of the minimum of that qualified	Essential
(b) Arc Voltage exceeding +7% of the maximum, or –7% of the minimum of that qualified	Essential
(c) Arc initiation method	Nonessential
(d) Electrode (nonconsumable) type	Nonessential
(e) Electrode (nonconsumable) size	Nonessential

9. Shielding Gas

(a) Gas nominal percentage composition (shielding and orifice) or classification in AWS A5.32/A5.32M	Essential
(b) Flow rate change exceeding +25% of the maximum, or –10% of the minimum of that qualified	Essential
(c) Nozzle orifice diameter (size change)	Essential

Table 5.2
Welding Variables**Wet Welding by Shielded Metal Arc or Flux Cored Arc Welding****A. Variables Common to All Welding Processes****1. Joints**

(a) Fillet weld to groove weld	Essential
(b) Multiple pass fillet weld to single pass fillet weld and vice versa	Essential
(c) Omission of backing	Essential
(d) Groove shape: a decrease in included angle, a decrease in root opening, or an increase in root face beyond the range qualified (refer to 5.9.4)	Essential
(e) Groove weld to multiple fillet weld subject to paragraph 5.9.2	Nonessential
(f) Fillet weld size: For single pass fillet welding procedure qualification, the maximum production weld size (leg length) shall be 1.0S and the minimum production weld size shall be 0.5S, where S is the leg length of the qualification weld. For multiple pass fillet welding procedure qualification, maximum production weld size (leg length) shall be 1.5S, and the minimum production weld size shall be 0.5S, where S is the leg length of the qualification weld.	Essential

2. Base Metal

(a) Thickness: For groove welding procedure qualification with a test plate or pipe thickness t, the maximum production plate or pipe thickness shall be 1.5t. The minimum production plate or pipe wall thickness shall be 0.5 t. However, if the production weld thickness is 6 mm (1/4 in) or less, the test weld shall be the same thickness.	Essential
(b) An increase in carbon equivalent or percent carbon of the steel above that qualified (not applicable to austenitic stainless steel)	Essential
(c) An increase in the specified minimum tensile strength beyond that qualified	Essential
(d) A change in chemical composition beyond that qualified in 5.6.1	Essential

3. Filler Metal

(a) Manufacturer	Essential
(b) Manufacturer's trade name (even if both meet the same Filler Metal Classification)	Essential
(c) Diameter	Essential
(d) Methods of underwater transport or storage	Essential
(e) Addition, deletion, or change of supplementary coatings or waterproofing	Essential
(f) An increase in exposure time of filler metal in the qualification depth atmosphere	Essential

4. Position

(a) Any change beyond that qualified in Table 5.4	Essential
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5. Weldment Temperature

(a) A change in any heat treatment	Essential
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(Continued)

Table 5.2 (Continued)
Welding Variables

6. Electrical Characteristics

(a) Welding current type (direct current electrode positive, direct current electrode negative, pulsed current, and others)	Essential
(b) Type of power source (constant current, constant voltage)	Essential
(c) Welding current exceeding +10% of the maximum, or –10% of the minimum of that qualified	Essential
(d) Arc voltage exceeding +10% of the maximum, or –10% of the minimum of that qualified	Essential

7. Technique

(a) Stringer bead to weave or vice versa	Essential
(b) Progression from up or down or vice versa	Essential
(c) Deletion of temper bead	Essential
(d) Change in weld bead sequence	Essential
(e) Travel speed or electrode run length beyond the range qualified	Essential
(f) Joint cleaning	Essential
(g) Addition, deletion, or change in any type of barrier to restrict water access during welding or cooling	Essential
(h) Addition of temper bead	Nonessential
(i) Progression direction for the root pass on double welded joints where second side is back gouged to sound metal	Nonessential

6. Environment

(a) Change in depth beyond that allowed in 5.6.2	Essential
(b) Back side dry to wet if material thickness is 6 mm (1/4 in) or greater	Essential
(c) Back side dry to wet and vice versa if material thickness is less than 6 mm (1/4 in)	Essential
(d) Pressure differential between back and front side of weld greater than that qualified	Essential
(e) Water Current	Nonessential
(f) Salinity (salt water to fresh water and vice versa)	Nonessential

5.6 Procedure Qualification Variables. Variables for welding procedure qualification are listed in Tables 5.1 and 5.2, and described in the following clauses. In general, for Class O welds, the referenced documents take precedence. However, essential variables, and the extent of nondestructive and destructive examination, shall also meet the requirements identified in this document.

5.6.1 Requirements for Base Metals

5.6.1.1 The chemical composition and carbon equivalent (if applicable) of procedure qualification test plates shall be determined through chemical analysis.

5.6.1.2 The chemical compositions of all base metals to be welded in production shall be known or determined in accordance with any of the following methods.

- (1) **Specification Limits**—The chemical composition of the metal may be based on the maximum values permitted by the applicable specification(s) if it can be demonstrated that all heats of the metals to be welded in production were produced in accordance with the referenced specification(s).
- (2) **Mill Test Reports**—The chemical composition of the metal may be based on the maximum values from ranges provided by the supplier for the heats of metal to be welded in production.
- (3) **Analysis Using Standard Test Methods**—The chemical composition of the metal may be based on the actual values as determined from analyses performed in accordance with ISO or ASTM standard test methods for each heat of material to be welded in production.
- (4) **Historical Data**—The chemical composition of the metal may, with Customer approval, be estimated based on the highest values from historical data, provided it can be demonstrated that the historical data is representative of all the metals to be welded in production.

5.6.1.3 The carbon equivalent of carbon and low-alloy steels used for welding procedure qualification shall not be less than the carbon equivalent of the steel to be welded in production, as determined by the following formula:

$$CE = C + \frac{Mn}{6} + \frac{Cr + Mo + V}{5} + \frac{Ni + Cu}{15} \quad (\text{Eq. 1})$$

When only carbon and manganese are known, the following alternative formula may be used:

$$CE = C + \frac{Mn}{6} + 0.05 \quad (\text{Eq. 2})$$

The values for the elements in the above formulas shall be expressed in weight percent. Other methods of determining the carbon equivalent may be used if permitted by the Customer.

5.6.1.4 Procedure qualification testing shall be performed on material with chemical composition and mechanical properties (e.g., equivalent material specification and grades) as close as practical to the production metal, but in no case with a carbon content less than the metal to be welded in production.

5.6.2 Depth Range

5.6.2.1 Welding procedure qualification depth limitations shall be in accordance with Table 5.3.

5.6.2.2 For all welding, qualification at two depths qualifies for any depth between the two.

5.6.2.3 The effects of wave action when welding at shallow depths should be considered.

5.7 Types of Tests. The welded test assemblies required to qualify a welding procedure are described in Part I of clauses 7 through 9 for **Class A** through **O** welds, respectively. The assemblies shall be welded with the procedure that is to be qualified, and shall satisfy all the test requirements for the weld class.

5.8 Position of Test Welds. Welding positions for groove and fillet welds are defined in ISO-6947 and ANSI/AWS A3.0 (Figures 5.1 and 5.2 reflect AWS A3.0 requirements).

5.8.1 Welding position is an essential variable. Production positions qualified by specific test positions are listed in Table 5.4.

Table 5.3
Depth Limitations for Qualification Welding

Type of Welding	Depth of Production Welding	Max. Depth Qualified	Min. Depth Qualified
Dry welding	All	X plus 20 m (66 ft)	X minus the greater of 20 m (66 ft) or 0.2X
Wet welding with carbon or low-alloy steel filler metal	Greater than 3 m (10 ft)	X plus 10 m (33 ft)	X minus the greater of 10 m (33 ft) or 0.2X
	Equal to or less than 3 m (10 ft)	X plus 10 m (33 ft)	X
Wet welding with austenitic stainless steel filler metal	All	X plus 3 m (10 ft)	X minus the greater of 20 m (66 ft) or 0.2X
Wet welding with other filler metal	All	X	X minus the greater of 20 m (66 ft) or 0.2X

Notes:

1. X is qualification test depth.
2. For the maximum depth qualified, depth shall be measured from the lower extremity of the test weldment with a tolerance of plus or minus 230 mm (9 in).
3. For the minimum depth qualified, depth shall be measured from the upper extremity of the test weldment with a tolerance of plus or minus 230 mm (9 in).

Table 5.4
Procedure Qualification—Type and Position Limitations

Qualification Test		Type of Weld and Position of Welding Qualified ^a			
		Plate ^b		Pipe ^b	
Weld	Plate or Pipe Positions ^c	Groove	Fillet	Groove	Fillet ^d
Plate-groove	PA (1G)	F	F	F	F
	PC (2G)	H	H	H	H
	PG (3G)	V down	V down		
	PF (3G)	V up	V up		
	PE (4G)	OH	OH		
Plate-fillet	PA (1F)		F		
	PB (2F)		H		
	PG (3F)		V down		
	PF (3F)		V up		
	PD (4F)		OH		
Pipe-groove	PA (1G)	F	F	F	F
	PC (2G)	H	H	H	H
	PG (5G)	V down	V down	F, V, OH	F, V, OH
	PF (5G)	V up	V up	F, V, OH	F, V, OH
	H-, J-L045 (6G) ^e	F, H, V, OH ^e	F, H, V, OH	F, H, V, OH ^e	F, H, V, OH ^e
Pipe-fillet	H-, J-L045 Restricted (6GR)	All	All	All	All
	PA (1F)		F		F
	PB (2F)		H		H
	PB 2FR		H		H
	PD (4F)		OH		OH
	PG (5F)		V down		All
	PF (5F)		V up		All

^a Positions of welding: F = flat, H = horizontal V = vertical, OH = overhead.

^b Plate qualifies for welding pipe or tubing over 600 mm (24 in) in diameter.

^c Positions as defined in 5.8.

^d See 5.9.2 and Part I of clauses 7 through 9 for requirements.

^e Qualifies for fillet and groove welds in all positions except for complete joint penetration groove welding of T-, Y-, and K-connections.

5.8.2 After a groove weld procedure for plate has been qualified in one position, a smaller test plate and fewer tests are required to qualify additional positions. The “first position” and “additional position” test plates are identified in Part I of clauses 7 and 8 for Class A and B welds, respectively. The Customer shall determine which position shall be used for the first position (i.e., larger test plate).

5.8.3 After a groove weld procedure for pipe has been qualified in one position, additional positions may be qualified by making similar welds that are tested as identified in Part I of Clauses 7 and 8 for Class A and B welds, respectively. Each procedure shall be tested in the manner indicated in 5.8.5.

5.8.4 Plate Groove Welds. In making the tests to qualify groove welds, test plates shall be welded in the following positions (see Figure 5.3):

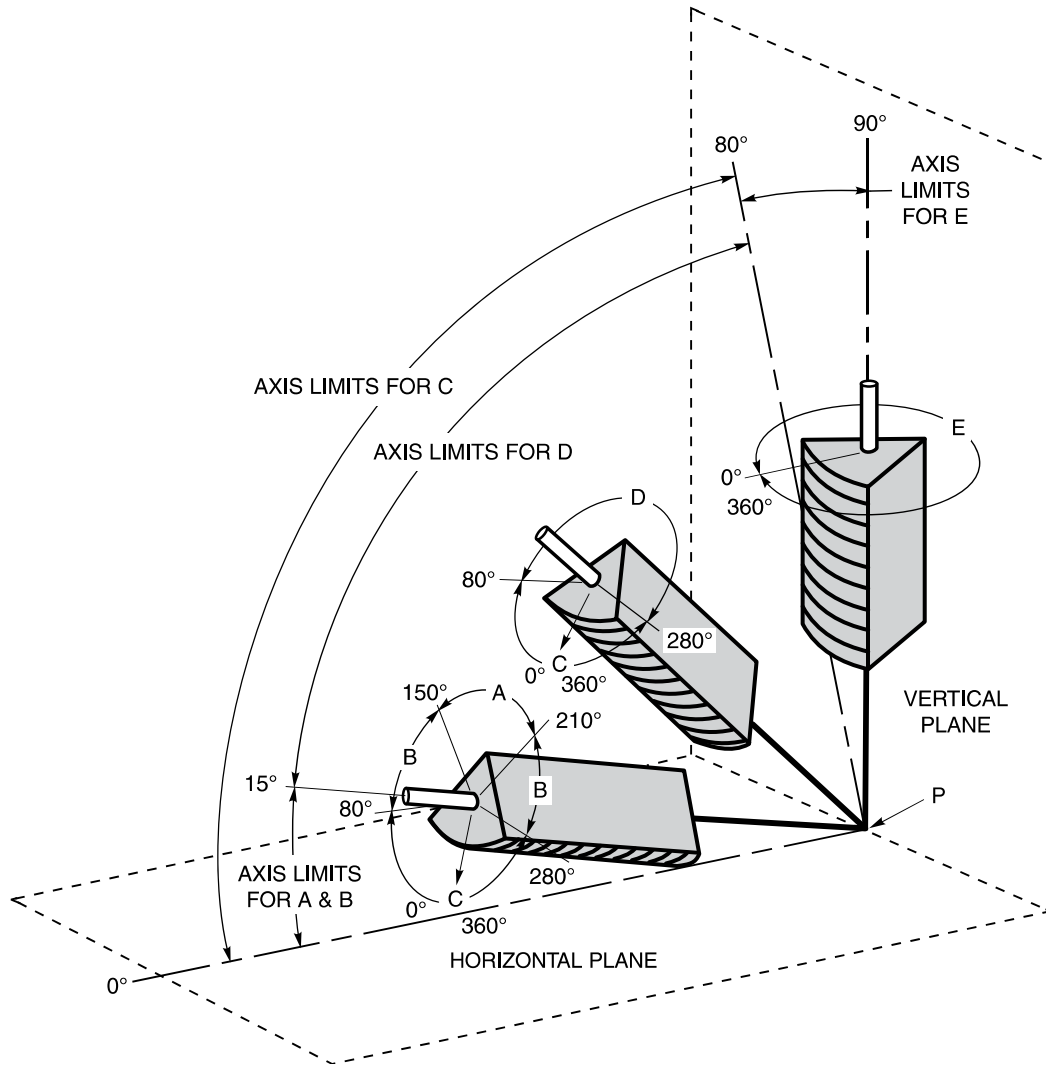
5.8.4.1 Position PA (1G) Flat. The plates are placed in an approximately horizontal plane and the weld metal is deposited from the upper side [see Figure 5.3(A)].

5.8.4.2 Position PC (2G) Horizontal. The plates are placed in an approximately vertical plane with the groove approximately horizontal [see Figure 5.3(B)].

5.8.4.3 Position PG (3G down) or PF (3G Up). The plates are placed in an approximately vertical plane with the groove approximately vertical [see Figure 5.3(C) and (D)].

5.8.4.4 Position PE (4G) Overhead. The plates are placed in an approximately horizontal plane, and the weld metal is deposited from the under side [see Figure 5.3(E)].

Tabulation of Positions of Groove Welds			
Position	Diagram Reference	Inclination of Axis	Rotation of Face
Flat	A	0° to 15°	150° to 210° 80° to 150°
Horizontal	B	0° to 15°	210° to 280° 0° to 80°
Overhead	C	0° to 80°	280° to 360°
Vertical	D	15° to 80°	80° to 280°
	E	80° to 90°	0° to 360°



Notes:

1. The horizontal reference plane is always taken to lie below the weld under consideration.
2. The inclination of axis is measured from the horizontal reference plane toward the vertical reference plane.
3. The angle of rotation of the face is determined by a line perpendicular to the theoretical face of the weld which passes through the axis of the weld. The reference position (0°) of rotation of the face invariably points in the direction opposite to that in which the axis angle increases. When looking at point P, the angle of rotation of the face of the weld is measured in a clockwise direction from the reference position (0°).

Figure 5.1—Positions of Groove Welds

Tabulation of Positions of Fillet Welds			
Position	Diagram Reference	Inclination of Axis	Rotation of Face
Flat	A	0° to 15°	150° to 210°
Horizontal	B	0° to 15°	125° to 150°
			210° to 235°
Overhead	C	0° to 80°	0° to 125°
			235° to 360°
Vertical	D	15° to 80°	125° to 235°
	E	80° to 90°	0° to 360°

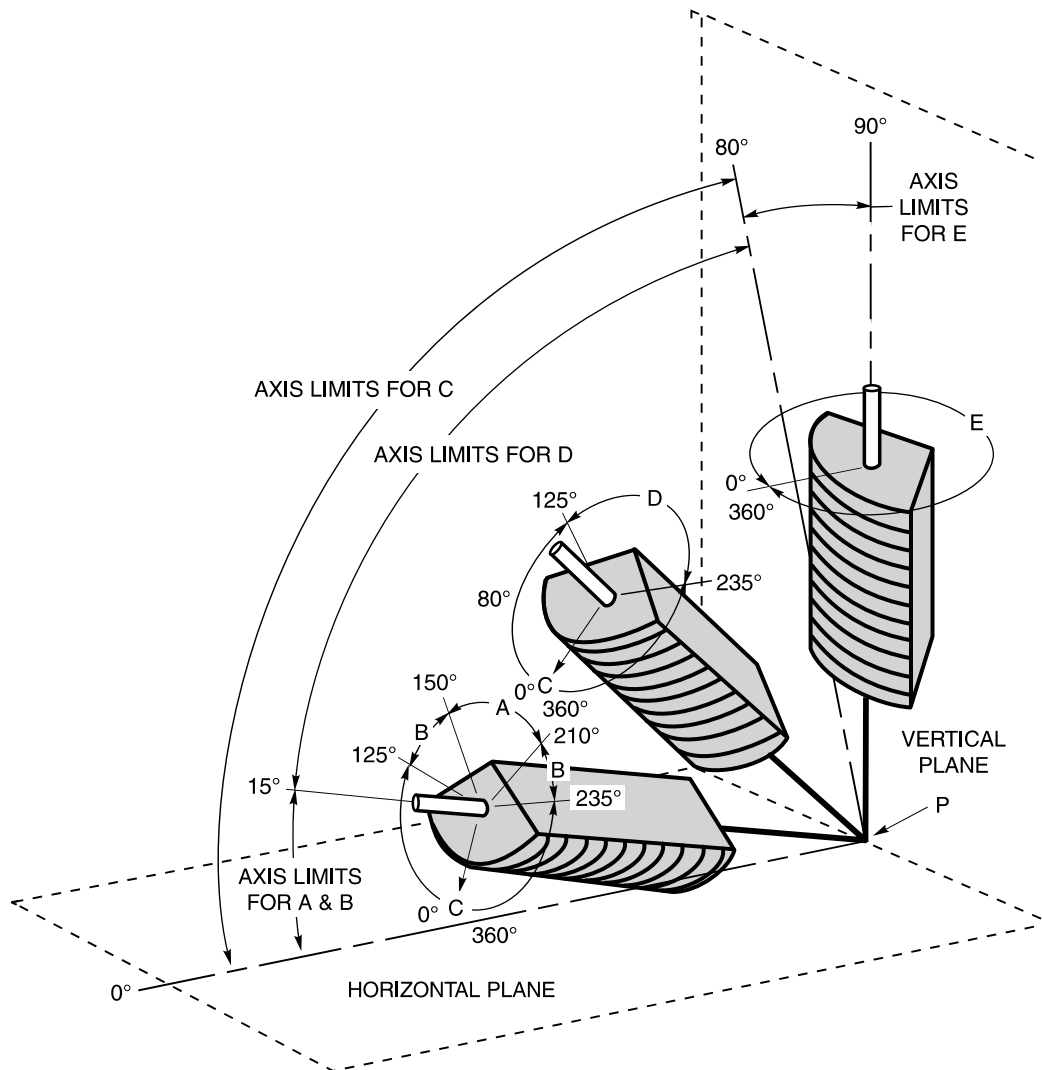


Figure 5.2—Positions of Fillet Welds

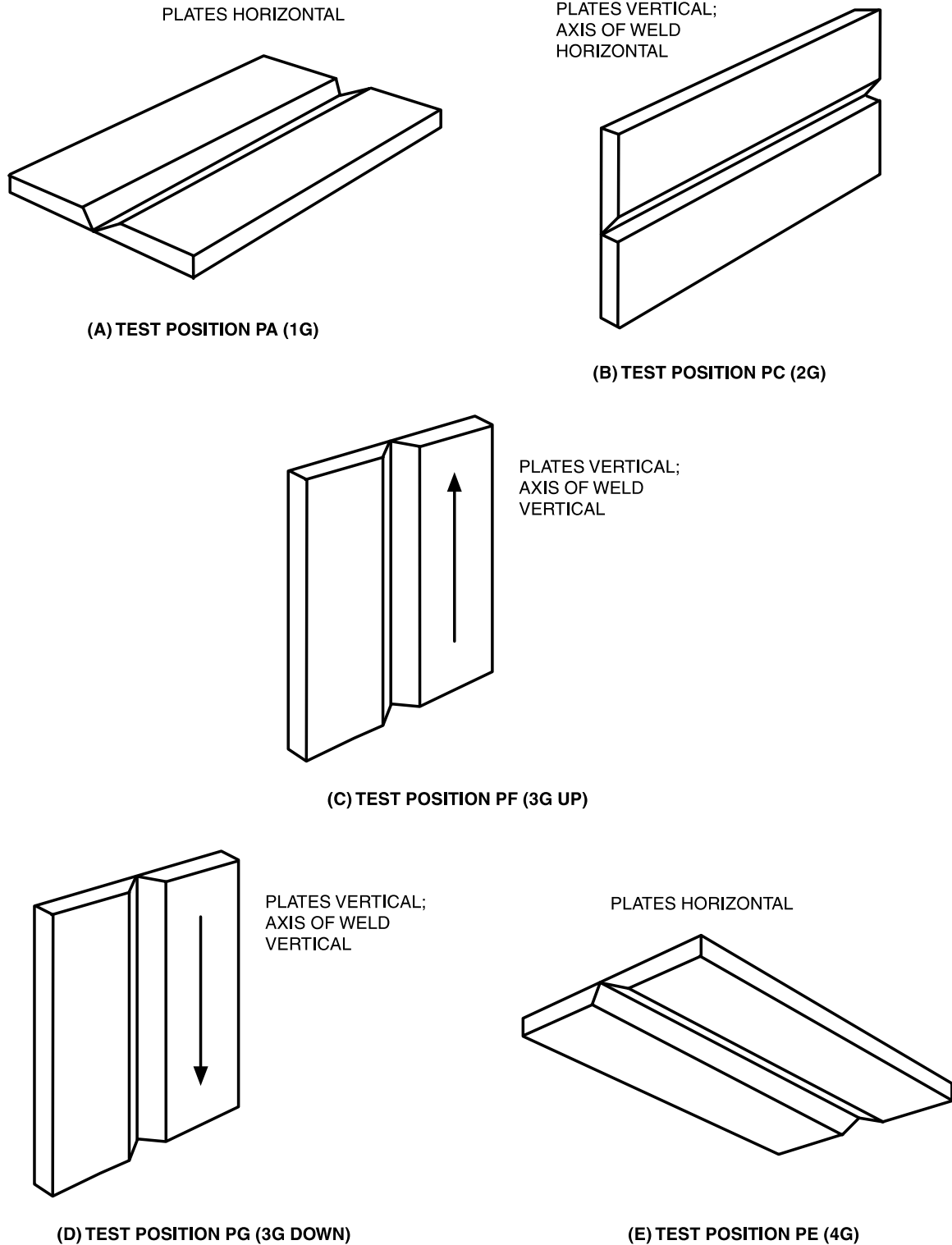


Figure 5.3—Positions of Test Plates for Groove Welds

5.8.5 Pipe Groove Welds. In making the tests to qualify groove welds, the positions shall be as indicated below (see Figure 5.4):

5.8.5.1 Position PA (1G) Pipe Horizontal Rolled. The pipe shall be placed with its axis horizontal and the groove in an approximately vertical plane. The pipe shall be rotated during welding, so the weld metal is deposited from the upper side [see Figure 5.4(A)].

5.8.5.2 Position PC (2G) Pipe Vertical. The pipe shall be placed with its axis vertical and the welding groove approximately horizontal. The pipe shall not be rotated during welding [see Figure 5.4(B)].

5.8.5.3 Position PG (5G down) or PF (5G up) Pipe Horizontal Fixed. The pipe shall be placed with its axis horizontal and the groove in an approximately vertical plane. The pipe shall not be rotated during welding [see Figure 5.4(C) and (D)].

5.8.5.4 Position H-, J-L 045 (6G down) or H-L 045 (6G up) Pipe Inclined Fixed. The pipe shall be inclined at 45 degrees with the horizontal. The pipe shall not be rotated during welding [see Figure 5.4(E) and (G)].

5.8.5.5 Position H-, J-L 045 Restricted (6GR). Test for complete joint penetration groove welds of tubular T-, Y-, and K-connections—the pipe shall be inclined at 45 degrees with the horizontal. The pipe (or tube) shall not be rotated during welding [see Figures 5.4(F) and (H), 7.4 and 8.4].

5.8.6 Plate Fillet Welds. In making the tests to qualify fillet welds, the test plate positions shall be as indicated below (see Figure 5.5):

5.8.6.1 Position PA (1F) Flat. The plates are placed such that each fillet weld is deposited with its axis approximately horizontal and its throat approximately vertical [see Figure 5.5(A)].

5.8.6.2 Position PB (2F) Horizontal. The plates are placed such that each fillet weld is deposited on the upper side of a horizontal surface and against a vertical surface [see Figure 5.5(B)].

5.8.6.3 Position PG (3F Down) or PF (3F Up) Vertical. The plates are placed such that each fillet weld is deposited with its axis approximately vertical [see Figure 5.5(C) and (D)].

5.8.6.4 Position PD (4F) Overhead. The plates are placed such that each fillet weld is deposited on the underside of a horizontal surface and against a vertical surface [see Figure 5.5(E)].

5.8.7 Pipe Fillet Welds. In making tests to qualify fillet welds, test pipes shall be welded in the positions indicated below (see Figure 5.6):

5.8.7.1 Position PA (1F) Flat. The assembly shall be placed with the pipe axis inclined at 45 degrees to horizontal and rotated during welding; the weld metal shall be deposited from above and at the highest point of rotation of the joint. The axis of the weld at that point shall be horizontal and the throat vertical [see Figure 5.6(A)].

5.8.7.2 Position PB (2F) Horizontal. The assembly shall be placed with the pipe axis vertical so that the weld is deposited on the upper side of a horizontal surface and against a vertical surface. The axis of the weld shall be horizontal, and the pipe shall not be rotated during welding [see Figure 5.6(B)].

5.8.7.3 Position PB (2FR) Horizontal Rotated. The assembly shall be placed with the pipe axis horizontal and rotated during welding. The weld metal shall be deposited at the highest point of rotation of the pipe, on the upper side of a horizontal surface and against a vertical surface [see Figure 5.6(C)].

5.8.7.4 Position PD (4F) Overhead. The assembly shall be placed with the pipe axis vertical so that the weld is deposited on the underside of a horizontal surface and against a vertical surface. The axis of the weld shall be horizontal, and the pipe shall not be rotated during welding [see Figure 5.6(D)].

5.8.7.5 Position PG (5F down) or PF (5F up) Multiple Positions. The assembly shall be placed with the pipe axis horizontal and the axis of the deposited weld in a vertical plane. The pipe shall not be rotated during welding [see Figure 5.6(E) and (F)].

5.9 Joint Configuration

5.9.1 Joint configuration shall be an essential variable for welding procedure specifications (refer to Tables 5.1 and 5.2).

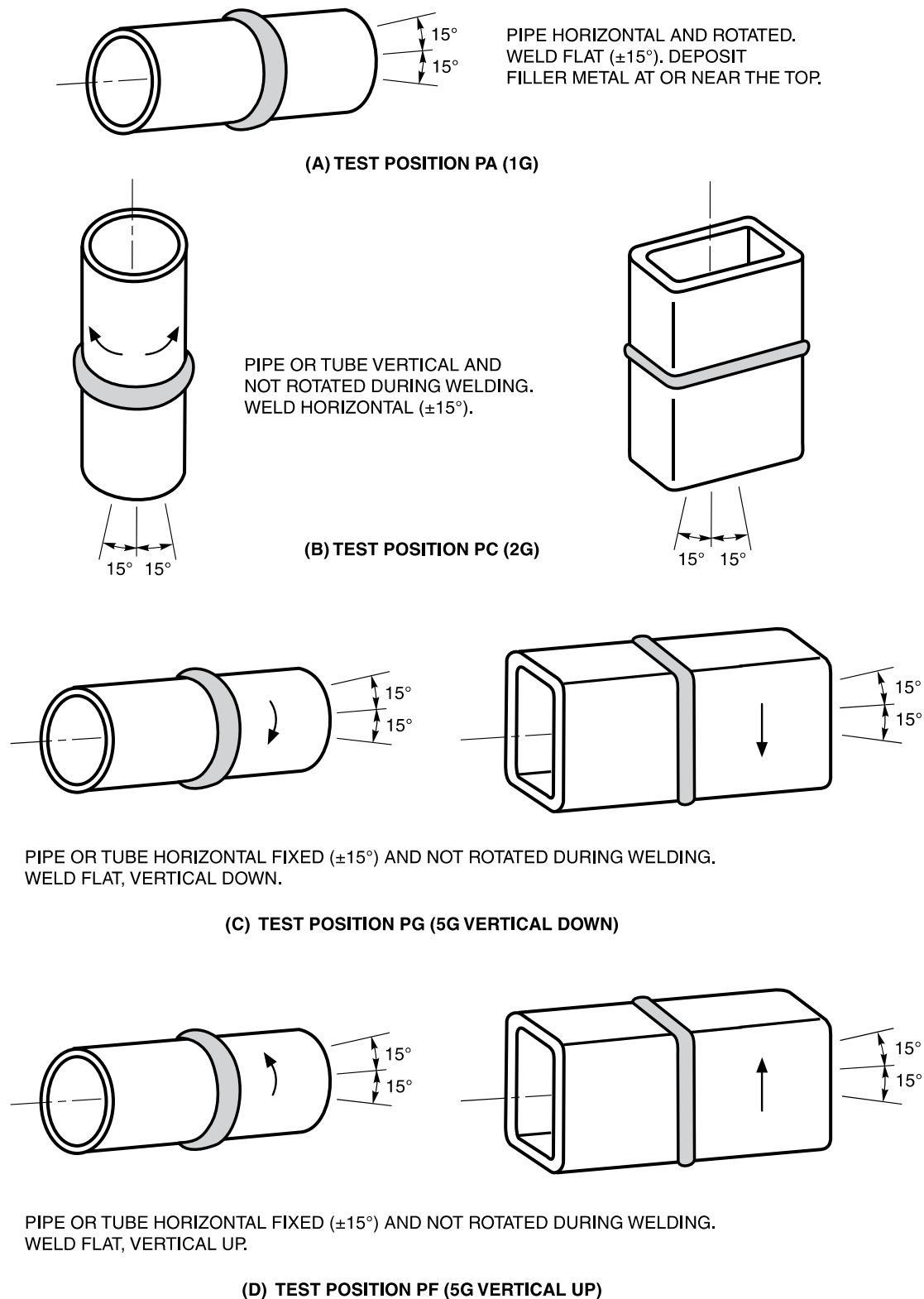


Figure 5.4—Positions of Test Pipe or Tubing for Groove Welds

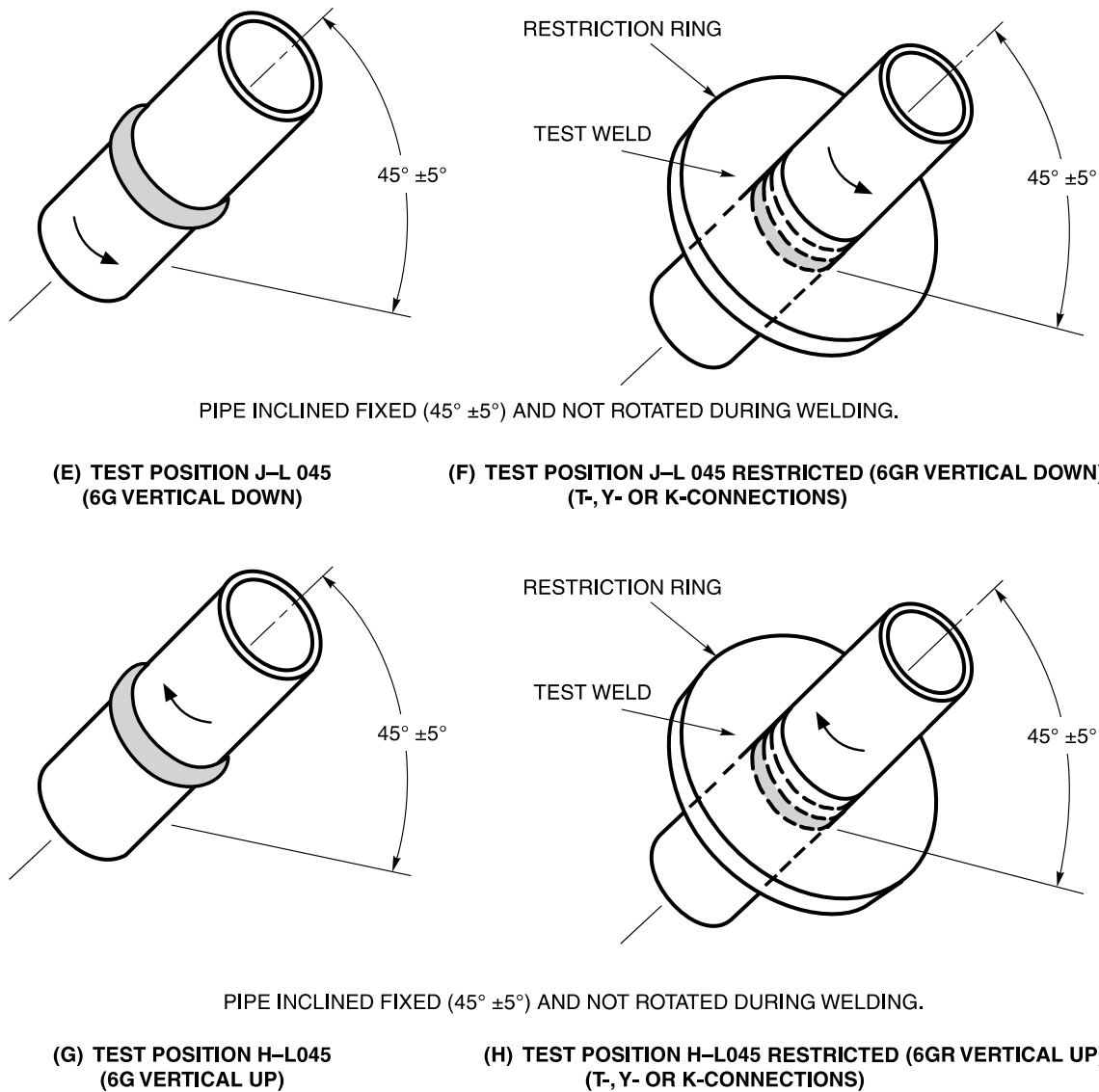


Figure 5.4 (Continued)—Positions of Test Pipe or Tubing for Groove Welds

5.9.2 A procedure qualified to perform groove welds shall be qualified to perform multiple-pass fillet welds. Single-pass fillet welds are not qualified by groove weld qualification.

5.9.3 Tolerances for the weld preparation and joint fit-up for dry welding may be developed during welding procedure qualification.

5.9.4 Joint assembly tolerances for wet welding shall be developed during welding procedure qualification and identified on the welding procedure specification.

5.10 Test Specimens: Number and Type. The number and type of test specimens required for procedure qualification to test the first position and additional positions, as required by 5.8, for one process are summarized in Part I of Clauses 7 through 9 for Class A through O welds, respectively. Specimens shall be removed and tested in accordance with 5.11. Test results shall be in accordance with Part I of Clauses 7 through 9, as applicable.

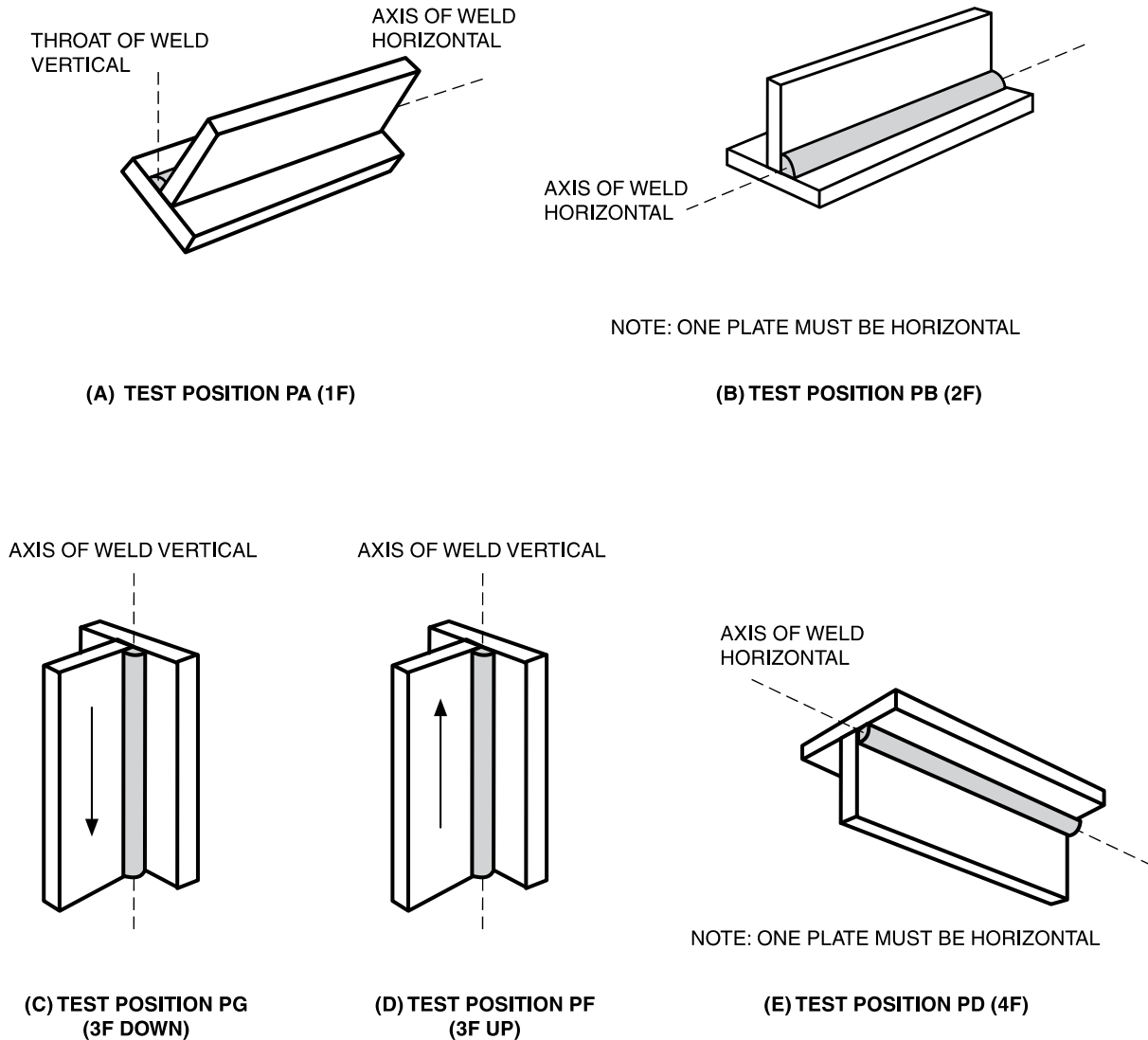


Figure 5.5—Positions of Test Plates for Fillet Welds

5.11 Preparation and Testing of Specimens. Test assemblies and specimens shall be prepared in accordance with the requirements of Part I of Clauses 7 through 9 for Class A through O welds, respectively. In addition, the following requirements shall apply:

5.11.1 Reduced-Section Tension Specimens. Specimens shall be prepared to the dimensions shown in Figure 5.7. Before testing, the least width and corresponding thickness of the reduced section shall be measured. The specimen shall be tested to rupture under tensile load, and the maximum load shall be determined. The tensile strength shall be obtained by dividing the maximum load by the cross-sectional area.

5.11.2 Macroetch Test. Specimens shall be removed as shown in Figures 5.8, 5.9, 7.1, 7.2, 8.1, or 8.2, as applicable. The cross-section surfaces cut from the test weld for macroscopic examination shall be prepared with a surface finish appropriate for macroetching. A suitable etching solution shall be used to give a clear definition of the weld metal and the heat-affected zone. (Refer to ISO 4969 or ASTM E 340.)

5.11.3 Root-, Face-, and Side-Bend Specimens. Transverse bend specimens, 10 mm (3/8 in) thick, shall be prepared in accordance with Figures 5.10 or 5.11. Specimens may be machine cut or oxyfuel gas cut from the test plates. If they

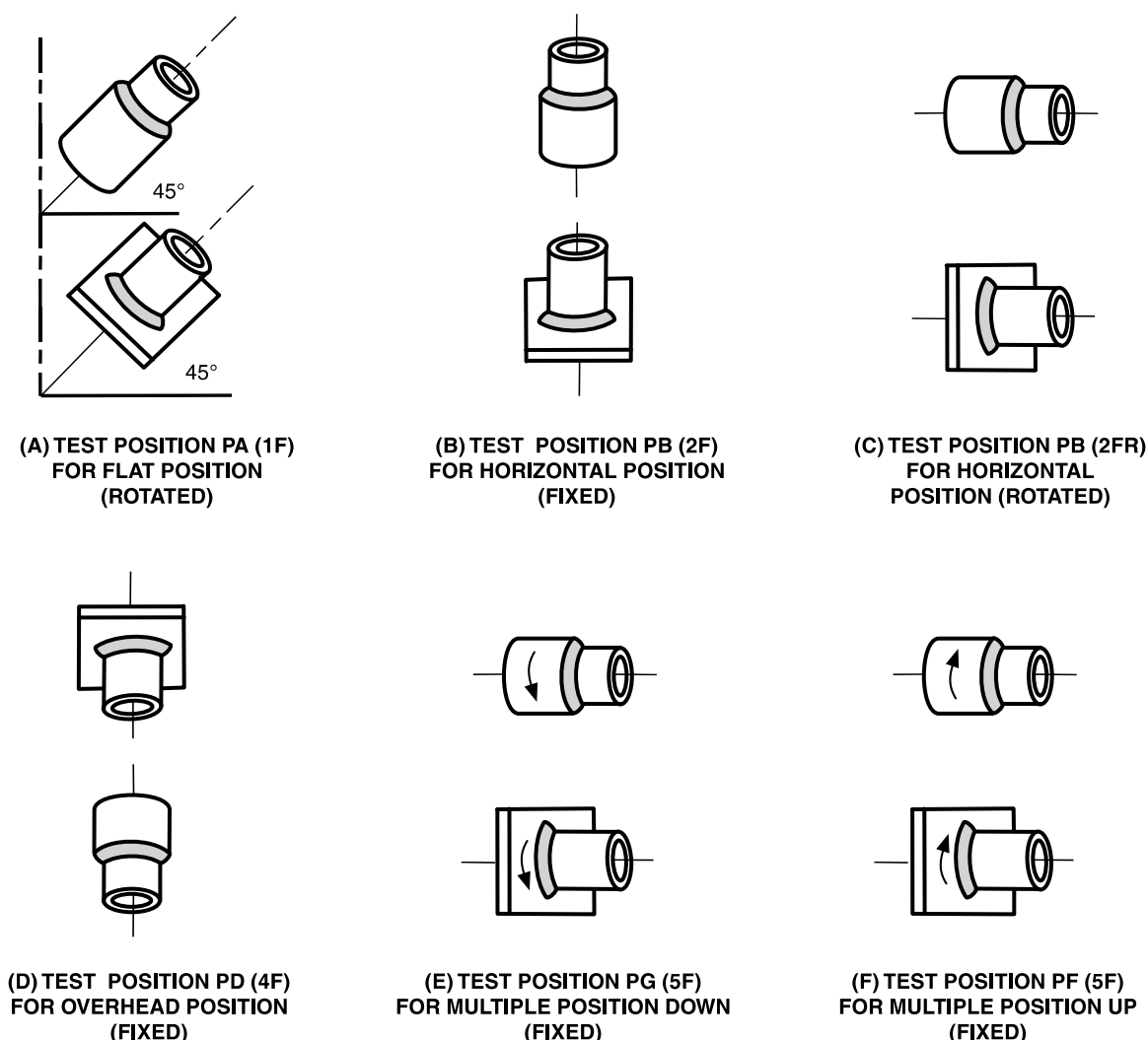


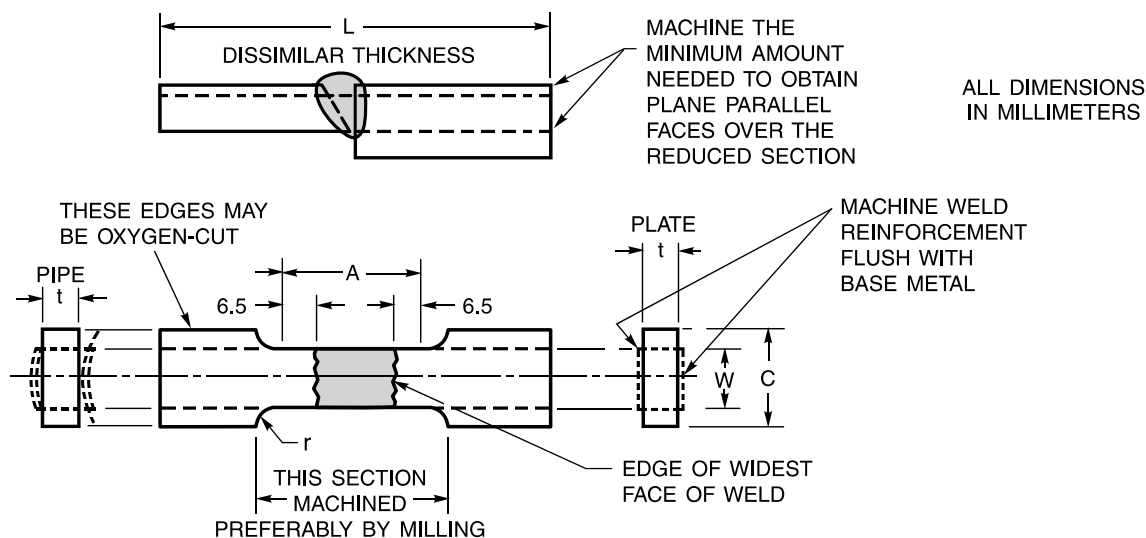
Figure 5.6—Positions of Test Pipes for Fillet Welds

are oxyfuel gas cut, an additional 3 mm (1/8 in) of metal shall be included on both sides of the rough-cut sample. The sample shall be machined or ground to the final dimensions. Each specimen shall be bent a full 180 degrees in a guided bend test jig having the contour dimensions shown in Figure 5.12. Bend radius shall be as specified in Part I of Clauses 7 through 9 for Class A through O welds, respectively.

5.11.3.1 Any convenient means may be used to move the plunger member of the guided bend test jig (Figure 5.12) with relation to the die member. The specimen shall be placed on the die member of the jig with the weld at mid span. Face-bend specimens shall be placed with the face of the weld toward the die member and root-bend specimens with the root of the weld toward the die member. Side-bend specimens shall be placed with that side showing the greater number of discontinuities, if any, toward the die member.

The plunger shall force the specimen into the die until the specimen assumes a U-shape. The weld- and heat-affected zones shall be centered and completely within the bent portion of the specimen after testing.

5.11.3.2 When using the alternate wraparound jig [Figure 5.12 (B)], the specimen shall be firmly clamped on one end so that there is no sliding of the specimen during the bending operation. The weld- and heat-affected zones shall be completely in the bent portion of the specimen after testing. Test specimens shall not be removed from the jig until the



Dimensions in mm				
	Test Plate		Test Pipe	
	$T_p^a \leq 40$ mm	$T_p \geq 40$	Less than 150 mm (nominal) Outside Diameter	150 mm (nominal) and Greater Outside Diameter
A—Length of reduced section	Widest face of weld + 12, 60 min.		Widest face of weld + 12, 60 min.	
L—Overall length, min ^b	As required by testing equipment		As required by testing equipment	
W—Width of reduced section ^{c, d}	20	20	12	20
C—Width of grip section ^{d, e}	W + 12 min.	W + 12 min.	W + 12 min.	W + 12 min.
t—Specimen thickness ^f	T_p	T_p/n^f	Maximum possible with plane parallel faces within length A	
r—Radius of fillet, min	35	35	25	25

^a T_p = Nominal Thickness of Plate. Metric specimens may be produced in accordance with ISO 4136.

^b It is desirable, if possible, to make the length of the grip section large enough to allow the specimen to extend into the grips a distance equal to two-thirds or more of the length of the grips.

^c The ends of the reduced section shall not differ in width by more than 0.1 mm. Also, there may be a gradual decrease in width from the ends to the center, but the width of either end shall not be more than 0.4 mm larger than the width at the center.

^d Narrower widths (W and C) may be used when necessary. In such cases, the width of the reduced section should be as large as the width of the material being tested permits. If the width of the material is less than W, the sides may be parallel throughout the length of the specimen.

^e For standard plate-type specimens, the ends of the specimen shall be symmetrical with the centerline of the reduced section within 6.5 mm.

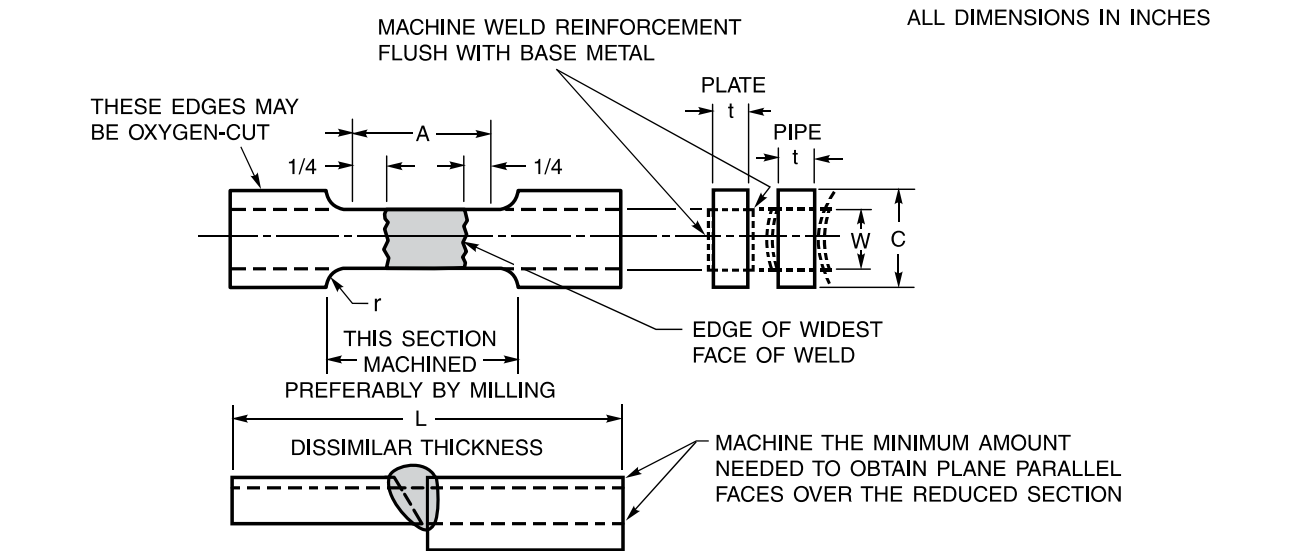
^f For plates over 40 mm thick, specimens may be cut into "n" approximately equal strips. Each strip shall be at least 20 mm thick. The test results of each strip shall meet the minimum requirements.

Figure 5.7—Reduced-Section Tension Specimens

outer roll has been moved 180 degrees from the starting point. Bend specimens shall be positioned with respect to the fixed pin of diameter A in the same manner as with the plunger member of Figure 5.12(A).

5.11.4 All-Weld-Metal Tension Test. An all-weld-metal tension test specimen shall be prepared as shown in Figures 5.13 or 5.14. If approved by the Customer, the specimen may be machined from the procedure test weld. The test specimen shall be tested in accordance with ISO 6892 or ANSI/AWS B4.0.

5.11.5 Charpy Impact Tests. The location and orientation of Charpy V-notch impact specimens are to be as shown in Figure 5.13. Charpy V-notch specimens shall be machined in accordance with ISO/DIS 9016.2 or ASTM A 370. For groove weld qualifications, three Charpy V-notch impact specimens shall be machined from the weld metal and three



	Dimensions in inches	
	Test Plate	Test Pipe
	$T_p^a \leq 1\text{--}1/2$ in	$T_p > 1\text{--}1/2$ in
A—Length of reduced section	Widest face of weld + 1/2 in, 2–1/4 min.	Widest face of weld + 1/2 in, 2–1/4 min.
L—Overall length, min ^b	As required by testing equipment	As required by testing equipment
W—Width of reduced section ^{c, d}	3/4 in min.	3/4 in min.
C—Width of grip section ^{d, e}	W + 1/2 in min.	W + 1/2 in min.
t—Specimen thickness ^f	T_p	T_p/n^f
r—Radius of fillet, min	1/2	1/2

^a T_p = Nominal Thickness of the Plate.

^b It is desirable, if possible, to make the length of the grip section large enough to allow the specimen to extend into the grips a distance equal to two-thirds or more of the length of the grips.

^c The ends of the reduced section shall not differ in width by more than 0.004 in. Also, there may be a gradual decrease in width from the ends to the center, but the width of either end shall not be more than 0.015 in larger than the width at the center.

^d Narrower widths (W and C) may be used when necessary. In such cases, the width of the reduced section should be as large as the width of the material being tested permits. If the width of the material is less than W, the sides may be parallel throughout the length of the specimen.

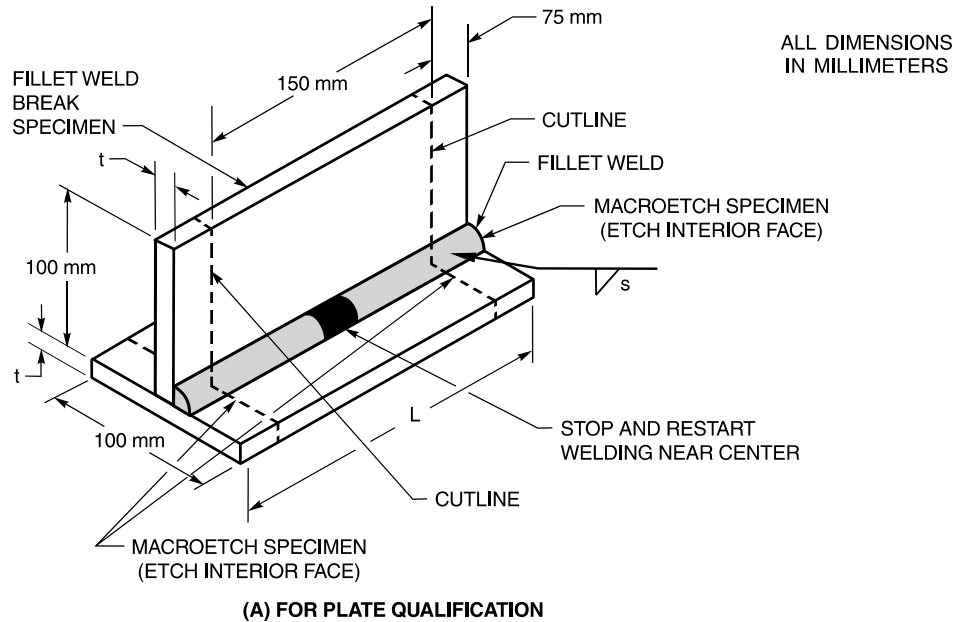
^e For standard plate-type specimens, the ends of the specimen shall be symmetrical with the centerline of the reduced section within 0.25 in

^f For plates over 1.5 in thick, specimens may be cut into “n” approximately equal strips. Each strip shall be at least 3/4 in thick. The test results of each strip shall meet the minimum requirements.

Figure 5.7A—Reduced-Section Tension Specimens (U.S. Customary Units)

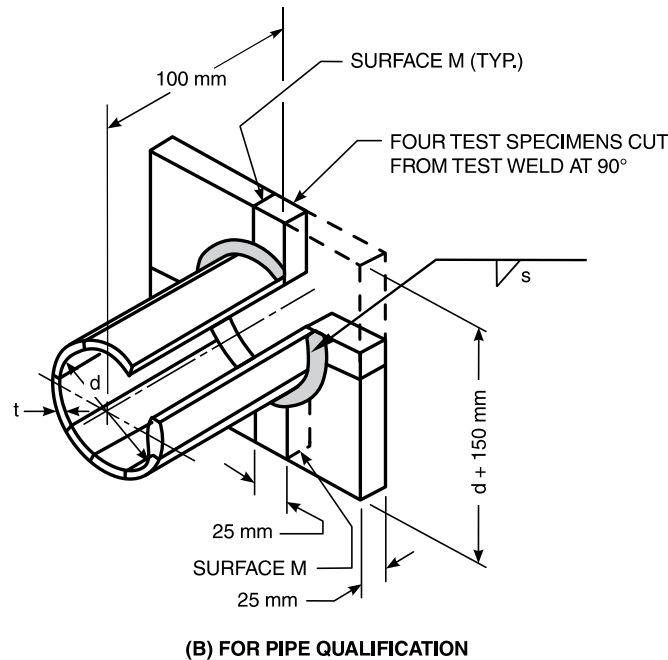
from the heat-affected zone in accordance with Figure 5.15. For qualification of fillet welds, three Charpy V-notch impact specimens shall be machined from the weld metal only. Specimen preparation and testing shall be in accordance with ISO 148 or ASTM A 370. The test temperature shall be the minimum design service temperature, unless a lower test temperature is specified by the Customer.

When the average value of the three specimens equals or exceeds the minimum value permitted for a single specimen and the value for more than one specimen is below the required average value, or when the value for one specimen is below the minimum value permitted for a single specimen, a retest of three additional specimens shall be made. The value for each of these retest specimens shall equal or exceed the required average value.



Notes:

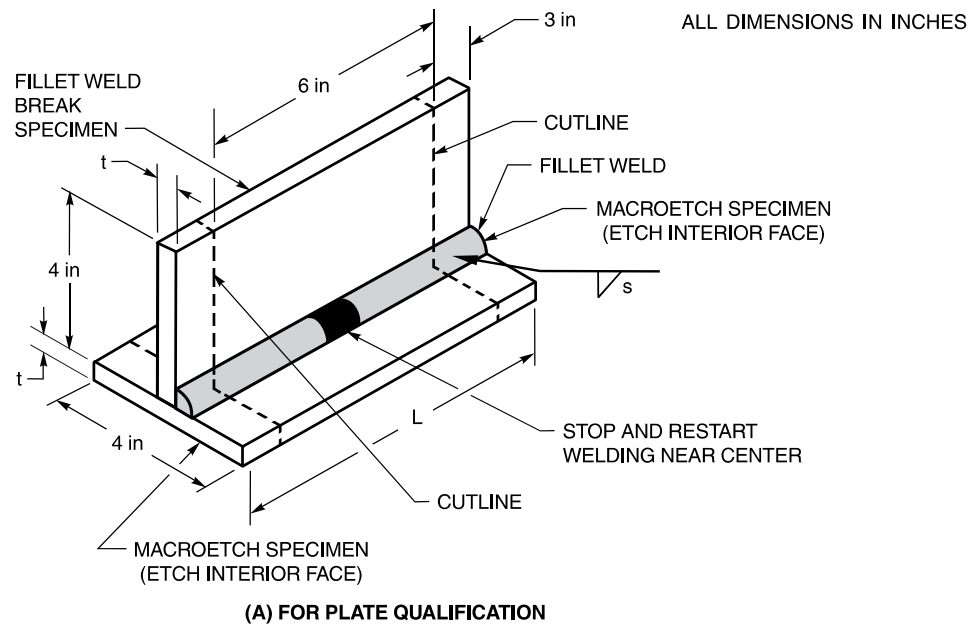
1. t in accordance with Tables 5.1 [Item A, 1(g)], and 5.2 [Item A, 1(g)]. As a minimum, $t = s + 3$ mm.
2. L —equal to 300 mm min, for welder performance qualification and for welding procedure qualification.
3. Fillet weld break specimen may be cut in sections to facilitate breaking.



Notes:

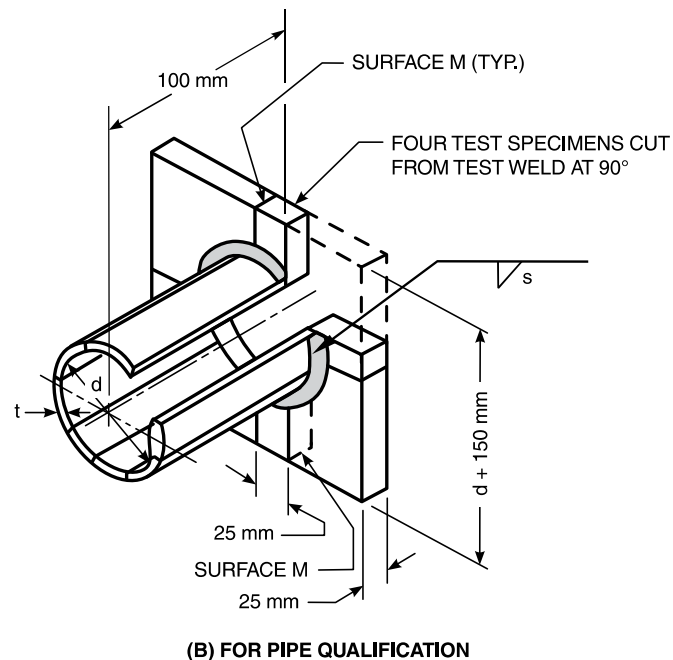
1. Diameter of d selected from Table 5.6 to qualify for production pipe sizes (welder qualification only).
2. Thicknesses t in accordance with Tables 6.1 [Item A, 1(g)] and 5.2 [Item A, 1(g)] for procedure qualification and clause 5, Part III for performance qualification. As a minimum, $t = s + 3$ mm.
3. Surfaces M to be examined for macroetch test. Hardness tests, when required, shall be made on the specimen from the six o'clock position.

Figure 5.8—Fillet Weld Break and Macroetch Test Specimens



Notes:

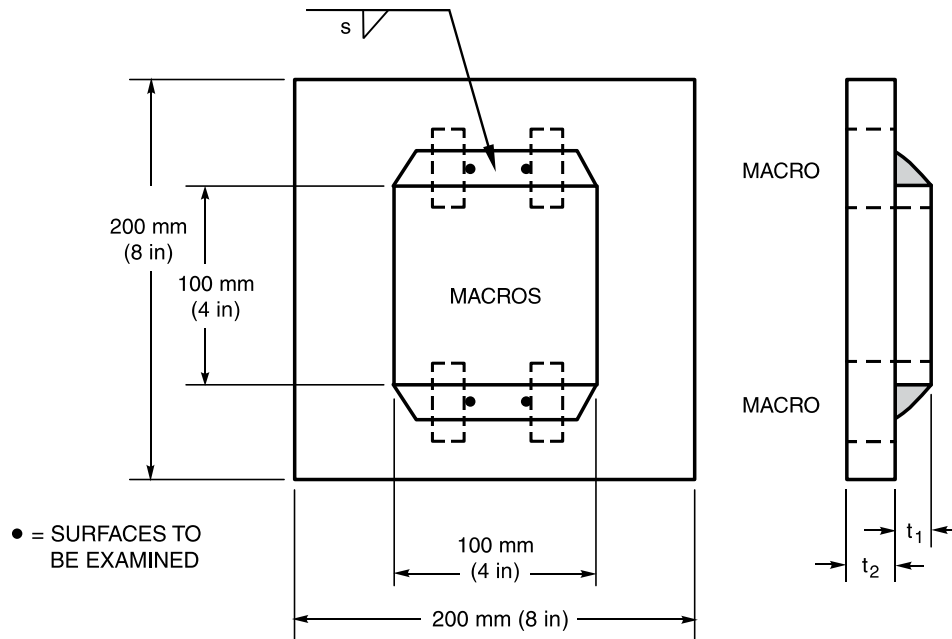
1. t in accordance with Tables 5.1 [Item A. 1(g)], and 5.2 [Item A. 1(g)]. As a minimum, $t = s + 1/8$ in.
2. L —equal to 12 in. min. for welded performance qualification and for welding procedure qualification.
3. Fillet weld break specimen may be cut in clause to facilitate breaking.



Notes:

1. Diameter of a selected from Table 5.6 to qualify for production pipe sizes (welder qualification only).
2. Thickness in accordance with Tables 5.1 [Item A. 1(g)] and 5.2 [Item A. 1(g)] for procedure qualification and clause 5, Part III for performance qualification. As a minimum, $t = s + 1/8$ in.
3. Surfaces M to be examined for macroetch test. Hardness tests, when required, shall be made on the specimen from the six o'clock position.

Figure 5.8A—Fillet Weld Break and Macroetch Test Specimens (U.S. Customary Units)



NOTE: THICKNESS t_1 , AND t_2 ARE TO BE IN ACCORDANCE WITH TABLES 5.1 AND 5.2 FOR PROCEDURE QUALIFICATION AND CLAUSE 5, PART III FOR PERFORMANCE QUALIFICATION.

Figure 5.9—Lap Joint Fillet Macroetch Test Assembly and Specimen Location

5.11.6 Hardness Test. The specimens used for macroetch and hardness test shall be prepared in accordance with ISO/DIS 9015.2 or ASTM E 92. The location of indentations shall be as shown in ISO/DIS 9015.2 or as specified by the Customer.

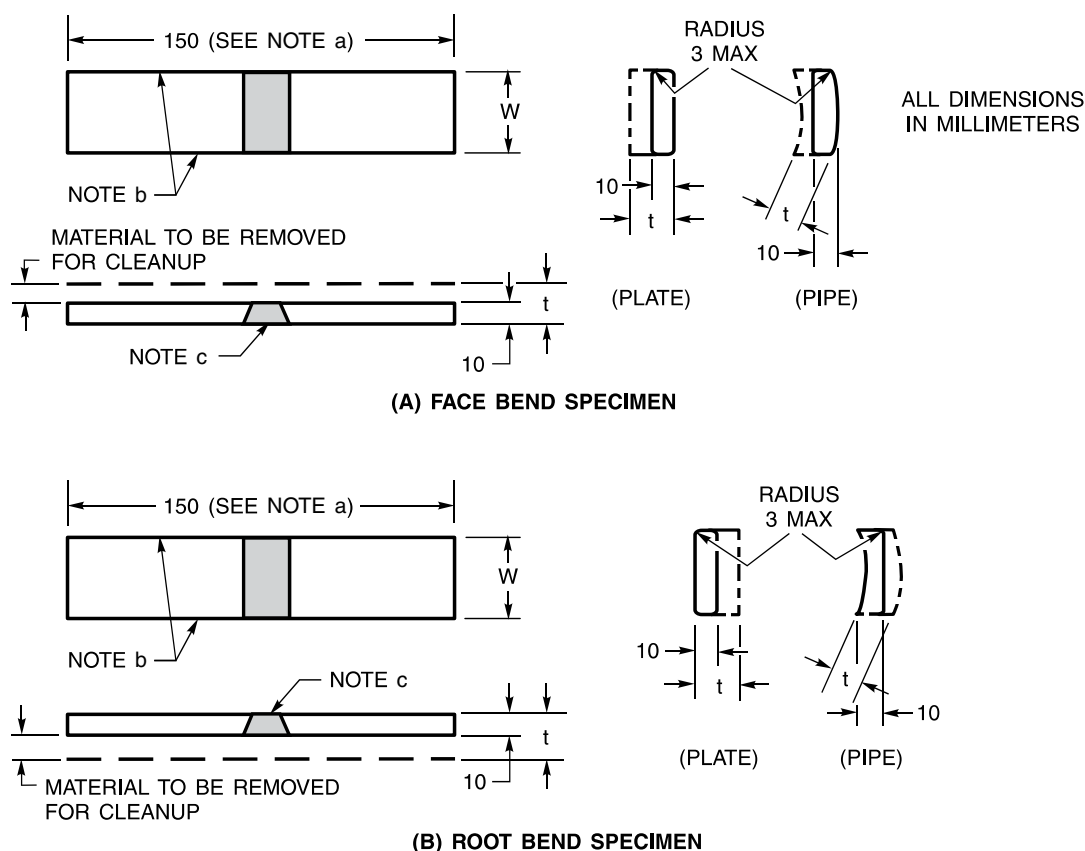
5.11.7 Fillet-Weld-Break Test. The coupon prepared for the fillet-weld-break test shall conform to Figure 5.8(A) for plate, and 5.8(B) for pipe qualifications. The entire length of the fillet weld shall be examined visually. For plate, one fillet weld break specimen approximately 150 mm (6 in) long, and for pipe, four (4) specimens [each containing approximately 25 mm (1 in) of weld] shall be tested. The specimens shall be loaded in such a way that the root of the weld is in tension until the specimen fractures or bends flat upon itself.

5.11.8 Fillet-Weld-Shear Strength Test. The specimen prepared for the fillet-weld-shear strength test shall conform to Figures 5.16, 5.17, or 5.18. The specimen type and welding position shall be specified by the Customer. Position of welding may have a significant effect on the properties of the weld, and the Customer should take this into consideration in design and in selection of the first and other positions during procedure qualification.

Before testing, the average throat and length of the test weld shall be measured. The throat of the fillet weld is the distance from the root of the joint preparation to the face of the weld, minus any convexity, disregarding any root penetration. The specimen shall be ruptured under tensile load, and the maximum load shall be determined. The cross-sectional area shall be obtained by multiplying the average throat of the weld by the length. The shear strength shall be obtained by dividing the maximum load by the cross-sectional area.

5.11.9 Bridge Bend Test. The weld test coupons shall be made as shown in Figure 5.19. The coupons shall be bent with the weld bead in tension. Bending shall proceed until a minimum angle of 20 degrees has been developed in the coupon on either side of the bead. The test will pass if no cracks have opened up in either the weld- or heat-affected zone. The specimen shall be unacceptable if a crack is detected.

5.12 Test Results Required. Required results for procedure qualification testing are identified in Part I of Clauses 7 through 9 for Class A through O welds, respectively.



Dimensions	
Test Weldment	Test Specimen Width, (W) mm
Plate	40
Test Pipe smaller than 150 mm (nominal)	25
Test Pipe 150 mm (nominal) or greater	40

^a A longer specimen length may be necessary when using a wraparound-type bending fixture or when testing bends with greater than 3T bend radius. A longer specimen will be necessary for testing Class B welds with a 6T bend radius.

^b These edges may be oxygen cut and may or may not be machined.

^c The weld reinforcement and backing, if any, shall be removed flush with the surface of the specimen. If a recessed backing is used, this surface may be machined to a depth not exceeding the depth of the recess to remove the backing; in such cases, the thickness of the finished specimen shall be that specified above. Cut surfaces shall be smooth and parallel.

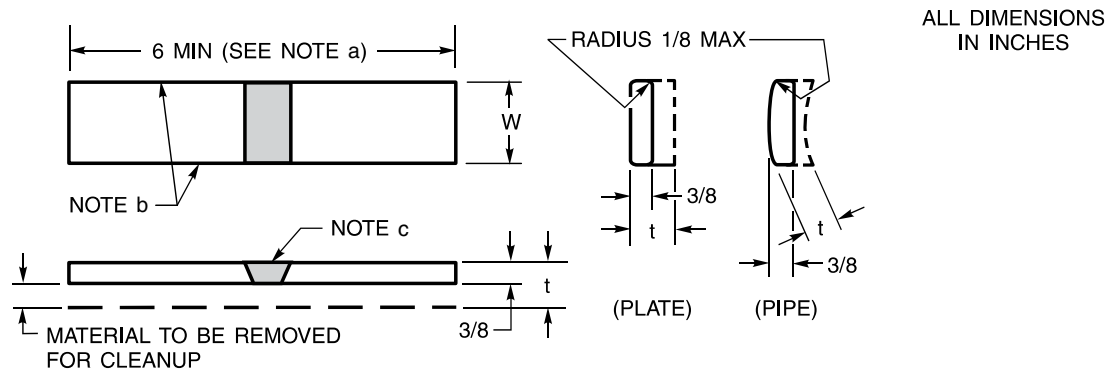
Figure 5.10—Face- and Root-Bend Specimens

5.13 Supplemental Requirements. At the discretion of the Customer, supplemental testing may be specified for qualification of any welding procedure.

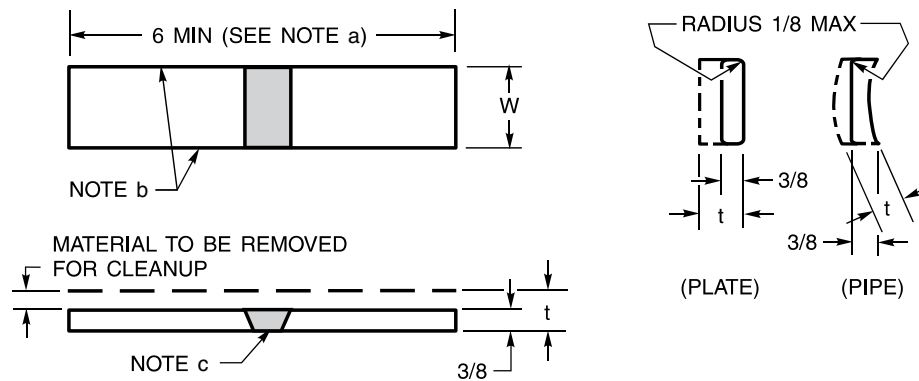
5.14 Records. The Procedure Qualification Record (PQR) shall contain all information necessary to support the essential variables defined in the Welding Procedure Specification (WPS) including the results of examinations and tests performed. The PQRs shall be maintained as long as the WPS is used. Supporting records shall be maintained for a minimum of one year unless otherwise specified by the Customer.

Part III Welder Qualification

5.15 General. All welders employed in executing work in accordance with the requirements of this Code shall be qualified prior to production welding in accordance with the requirements of this clause. Each Contractor shall conduct



(A) FACE BEND SPECIMEN



(B) ROOT BEND SPECIMEN

Dimensions	
Test Weldment	Test Specimen Width, (W) in
Plate	1-1/2
Test Pipe smaller than 6 NPS	1
Test Pipe 6 NPS and greater in outside diameter	1-1/2

^a A longer specimen length may be necessary when using a wraparound-type bending fixture or when testing bends with greater than 3T bend radius. A longer specimen will be necessary for testing Class B welds with a 6T bend radius.

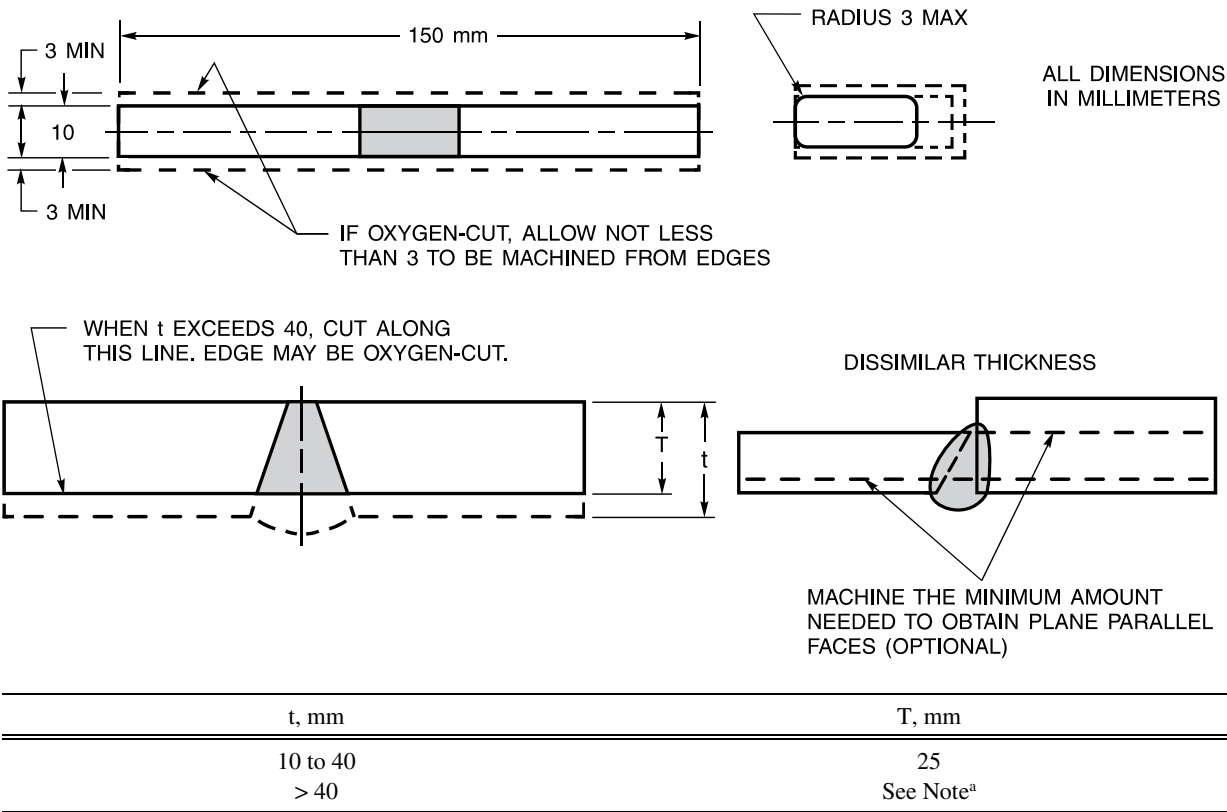
^b These edges may be oxygen cut and may or may not be machined.

^c These weld reinforcement and backing, if any, shall be removed flush with the surface of the specimen. If a recessed backing is used, this surface may be machined to a depth not exceeding the depth of the recess to remove the backing; in such cases, the thickness of the finished specimen shall be that specified above. Cut surfaces shall be smooth and parallel.

Figure 5.10A—Face- and Root-Bend Specimens (U.S. Customary Units)

the tests required to qualify the welders. The welder performance tests are intended to establish each welder's ability to make sound welds using a qualified welding procedure specification. In general, for Class O welds, the referenced documents take precedence. However, essential variables, and the extent of nondestructive and destructive examination, shall also meet the requirements identified in this document.

5.16 Limitations of Variables. Welders shall be qualified to weld with each procedure used for production. A welder shall requalify to weld with an appropriately qualified procedure when there are changes made in the following essential variables:



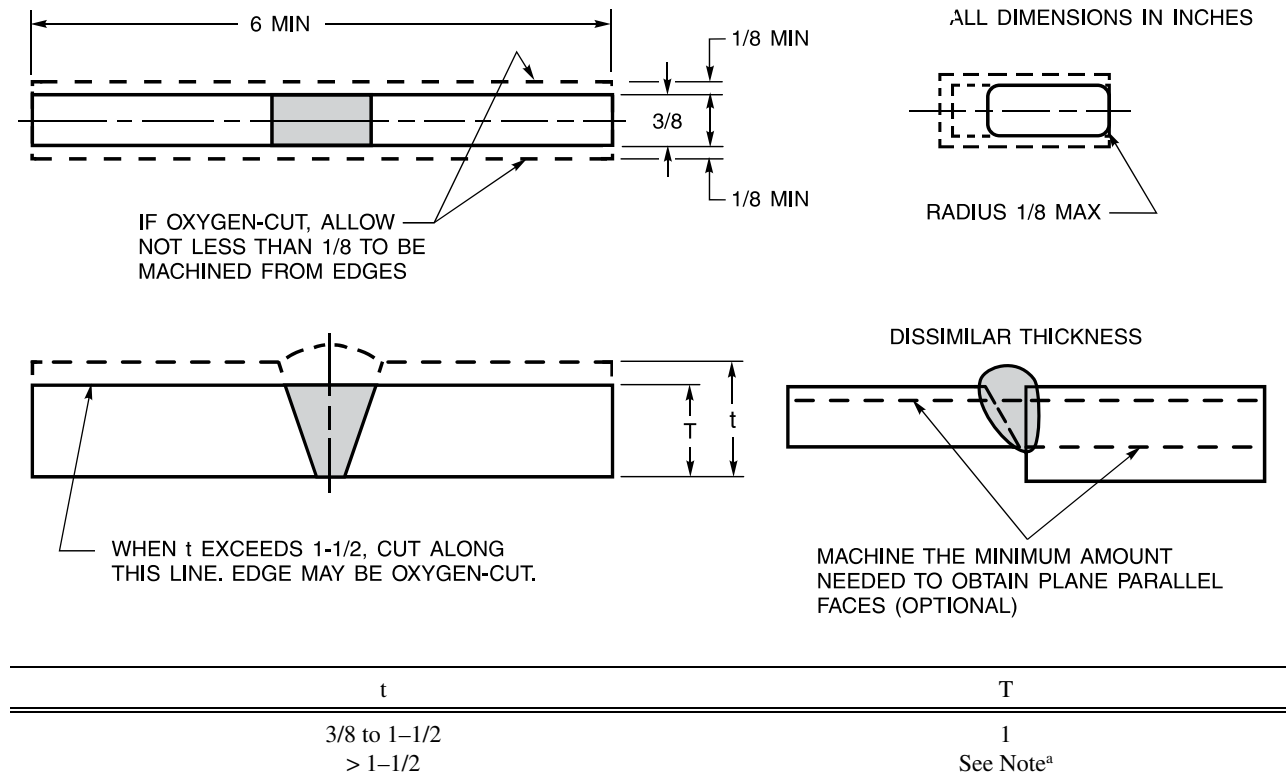
^a For plates over 40 mm thick, cut the specimen into approximately equal strips with T between 20 mm and 40 mm and test each strip.

Notes:

1. A longer specimen length may be necessary when using a wraparound-type bending fixture or when testing bends with greater than 3T bend radius.
A longer specimen will be necessary for testing Class B welds with a 6T bend radius.
2. t = plate or pipe thickness.

Figure 5.11—Side-Bend Specimens

- (1) Change in welding process
- (2) Change in welding method (manual, semiautomatic, automatic)
- (3) Omission of backing, but not vice versa
- (4) Change in diameter or thickness beyond the limits of Tables 5.1, 5.2, or 5.6
- (5) Change in electrode classification (e.g., AWS EXX10 to AWS EXX11) or proprietary type, including waterproofing
- (6) An increase in electrode diameter for wet welding
- (7) Change in position from that qualified in accordance with Table 5.5
- (8) Change in depth beyond the limits specified in 5.6.2
- (9) Change from a mixed breathing gas to air
- (10) Change in shielding gas beyond the limits of Tables 5.1 or 5.2
- (11) Change in direction of vertical travel from upward to downward or vice versa
- (12) Change from stringer bead to weave technique
- (13) Where production welding visibility is less than 150 mm (6 in), unless the welder has already qualified with visibility less than 150 mm (6 in)



^a For plates over 1-1/2 in thick, cut the specimen into approximately equal strips with T between 3/4 in and 1-1/2 in and test each strip.

Notes:

1. A longer specimen length may be necessary when using a wraparound-type bending fixture or when testing bends with greater than 3T bend radius. A longer specimen will be necessary for testing Class B welds with a 6T bend radius.
2. t = plate or pipe thickness.

Figure 5.11A—Side-Bend Specimens (U.S. Customary Units)

In addition to the above-listed performance variables, other factors unique to work in the underwater environment which could affect performance (thermal conditions, diver dress, amount of assistance provided, etc.) should be considered during welder performance qualification testing.

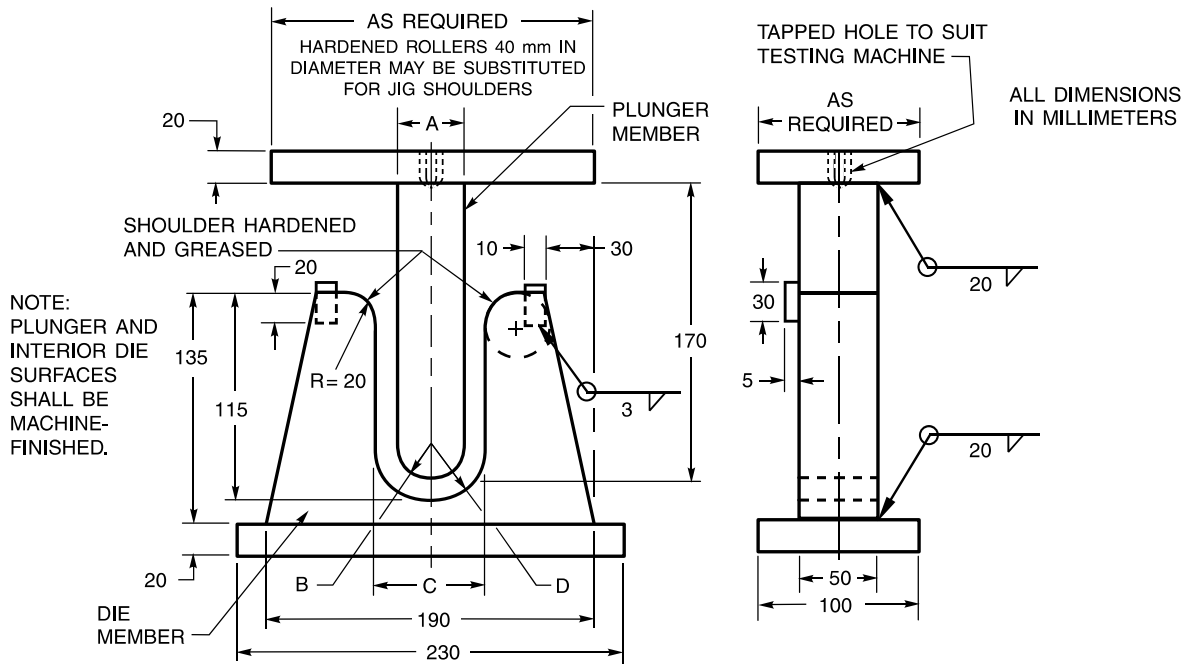
5.17 Qualification Tests Required

5.17.1 A welder may be qualified either under simulated conditions or at the site of the production welds, provided the essential variables for welder qualification are satisfied.

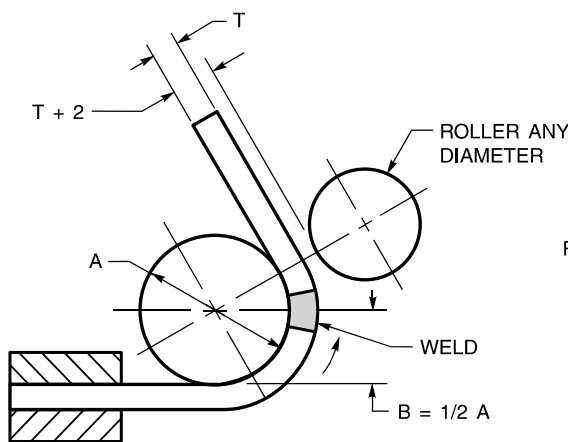
5.17.2 The Customer may accept evidence of previous qualification, provided all the requirements of this Code are met.

5.17.3 Groove Welds. Test assemblies shall be welded for position, thickness, and diameters in accordance with the requirements for variables and positions of 5.16 and Table 5.5, to qualify a welder for groove welding in plate or pipe. The required type and number of specimens are described in Part II of Clauses 7 through 9 for Class A through O welds, respectively.

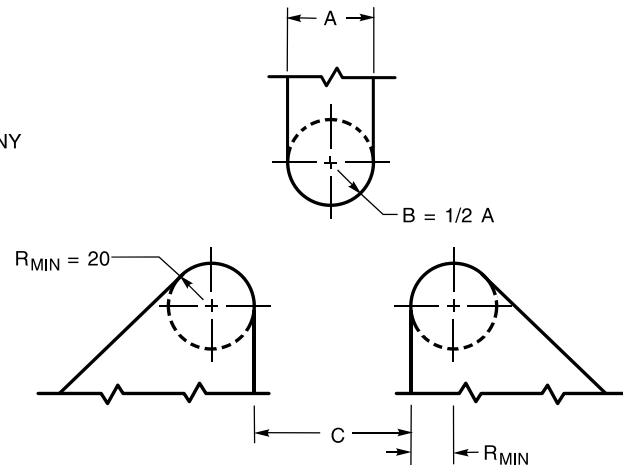
5.17.4 T-, Y-, and K-Connections. To qualify a welder for complete joint penetration groove welds in tubular T-, Y-, and K-connections, a welded H-, J-L 045 Restricted (6GR) test assembly (refer to Figures 7.4 or 8.4) shall be required in accordance with 5.16. Testing on 13 mm (1/2 in) or greater wall thickness qualifies for welding T-, Y-, and K-connections for all wall thicknesses and diameters for which the welder is qualified with a given procedure. The type and number of specimens required to qualify from each assembly are described in Part II of clauses 7 and 8 for Class A and B welds, respectively.



(A) GUIDED BEND TEST JIG



(B) ALTERNATIVE WRAPAROUND GUIDED BEND TEST JIG

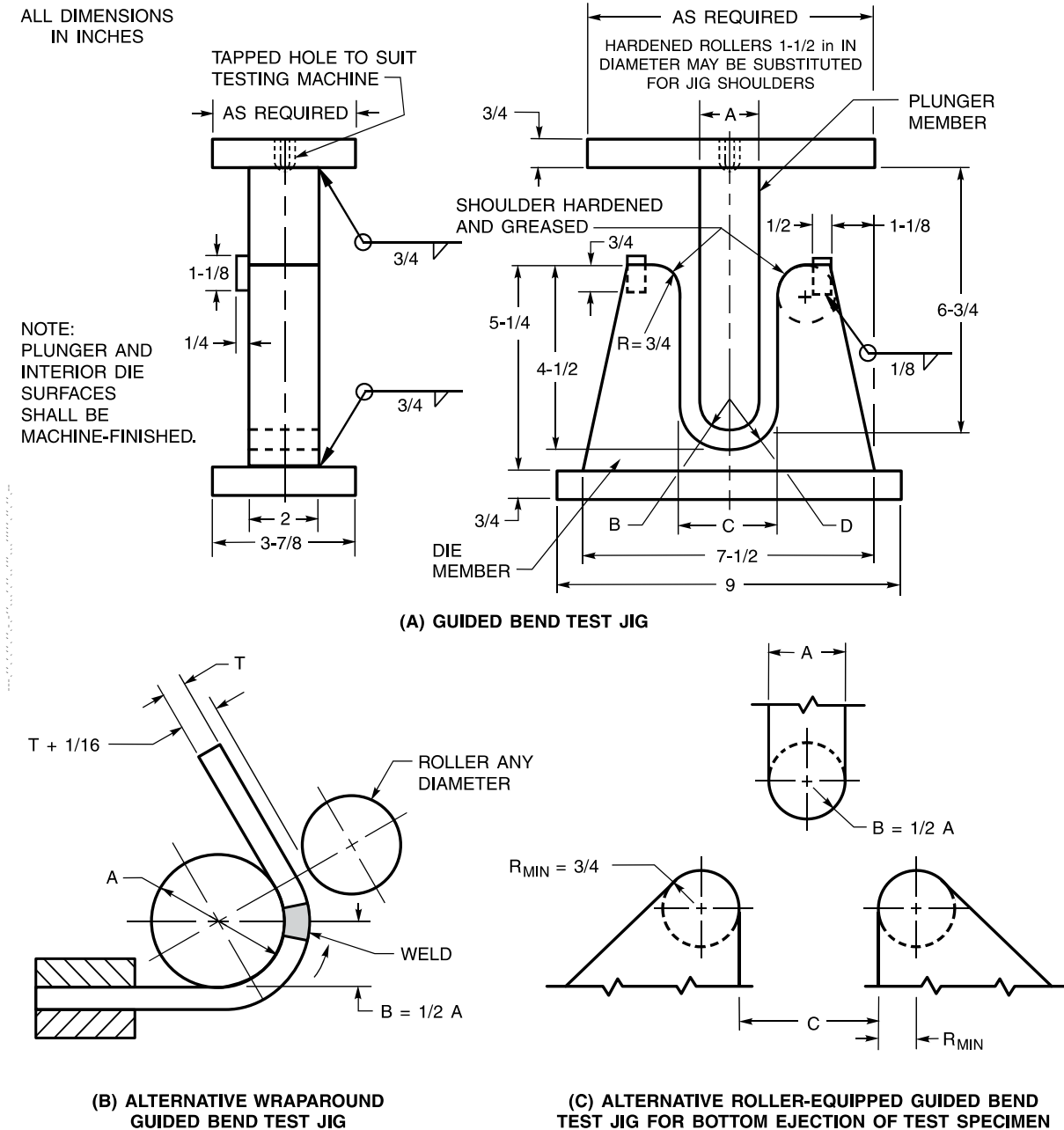


(C) ALTERNATIVE ROLLER EQUIPPED GUIDED BEND TEST JIG FOR BOTTOM EJECTION OF TEST SPECIMEN

Dimensions in mm				
Bend Radius (B)	A	B	C	D
2T	40	20	63	32
2-2/3T	53	27	76	38
3-1/3T	67	33	90	45
6T	120	60	143	72

Note: For required radius, refer to Parts I and II of clauses 7 through 9 for Class A through O welds, respectively. Bending fixture dimensions are for specimen radius bends on 10 mm thick specimens. If qualification welds are required on thinner material, fixture dimensions may be altered so bending radius remains as specified. T equals thickness of bend specimen. Weld sizes are recommendations. The actual fillet weld size is the responsibility of the user to ensure rigidity and design adequacy.

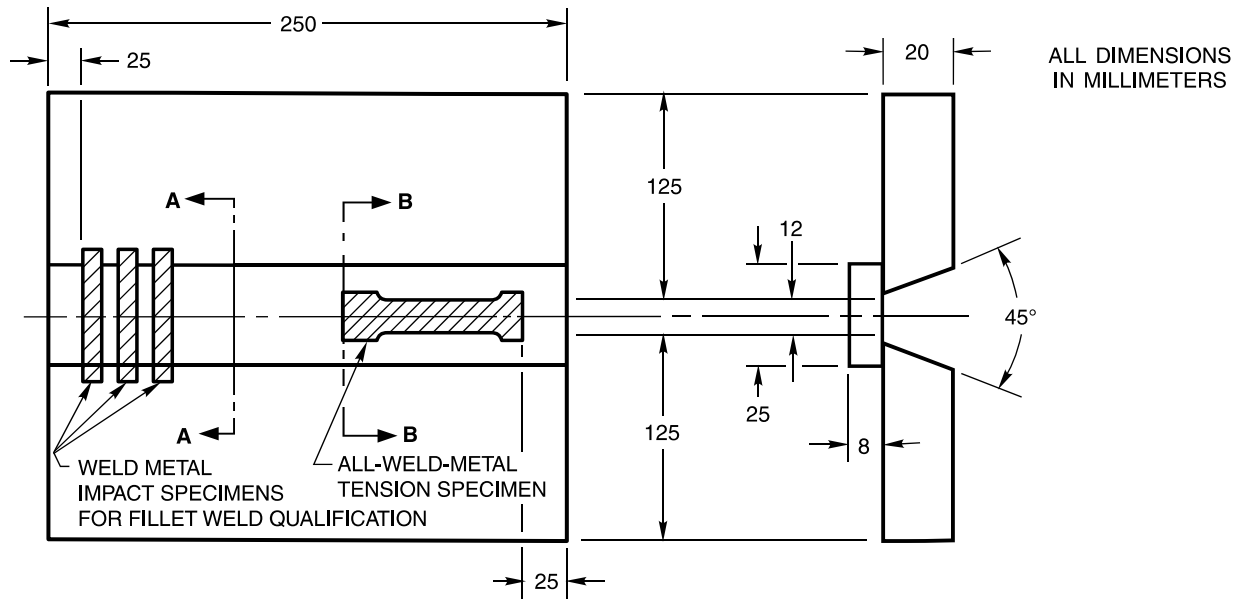
Figure 5.12—Bend Test Jigs



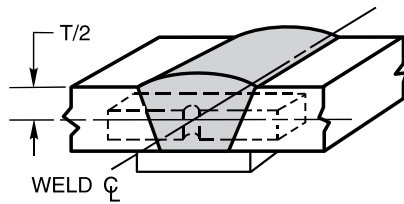
Dimensions in inches				
Bend Radius (B)	A	B	C	D
2T	1-1/2	3/4	2-3/8	1-3/16
2-2/3T	2	1	2-7/8	1-7/16
3-1/3T	2-1/2	1-1/4	3-3/8	1-11/16
6T	4-1/2	2-1/4	5-3/8	2-11/16

Note: For required radius refer to Parts I and II of clauses 7 through 9 for Class A through O welds, respectively. Bending fixture dimensions are for specimen radius bends on 3/8 in thick specimens. If qualification welds are required on thinner material, fixture dimensions may be altered so bending radius remains as specified. T equals thickness of bend specimen. Weld sizes are recommendations. The actual fillet weld size is the responsibility of the user to ensure rigidity and design adequacy.

Figure 5.12A—Bend Test Jigs (U.S. Customary Units)

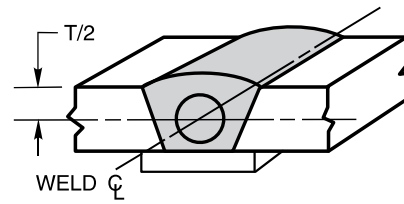


(A) TEST PLATE SHOWING LOCATION OF TEST SPECIMENS



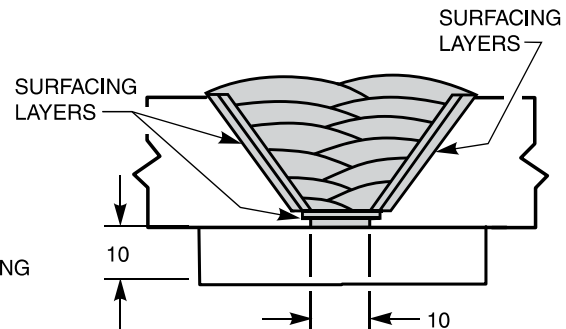
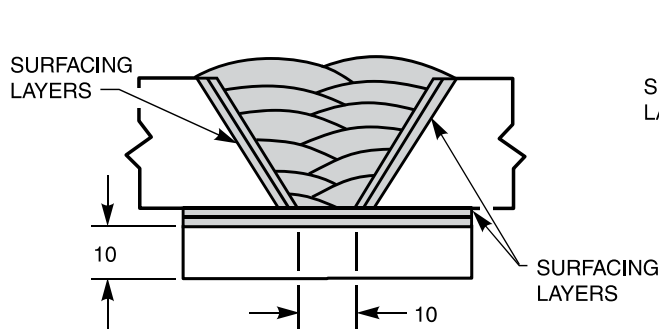
SECTION A-A

(B) ORIENTATION AND LOCATION OF WELD METAL IMPACT SPECIMEN (SEE ALSO 5.11.5 AND FIGURE 7.1)



SECTION B-B

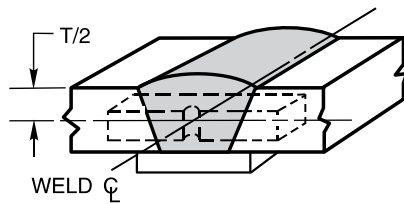
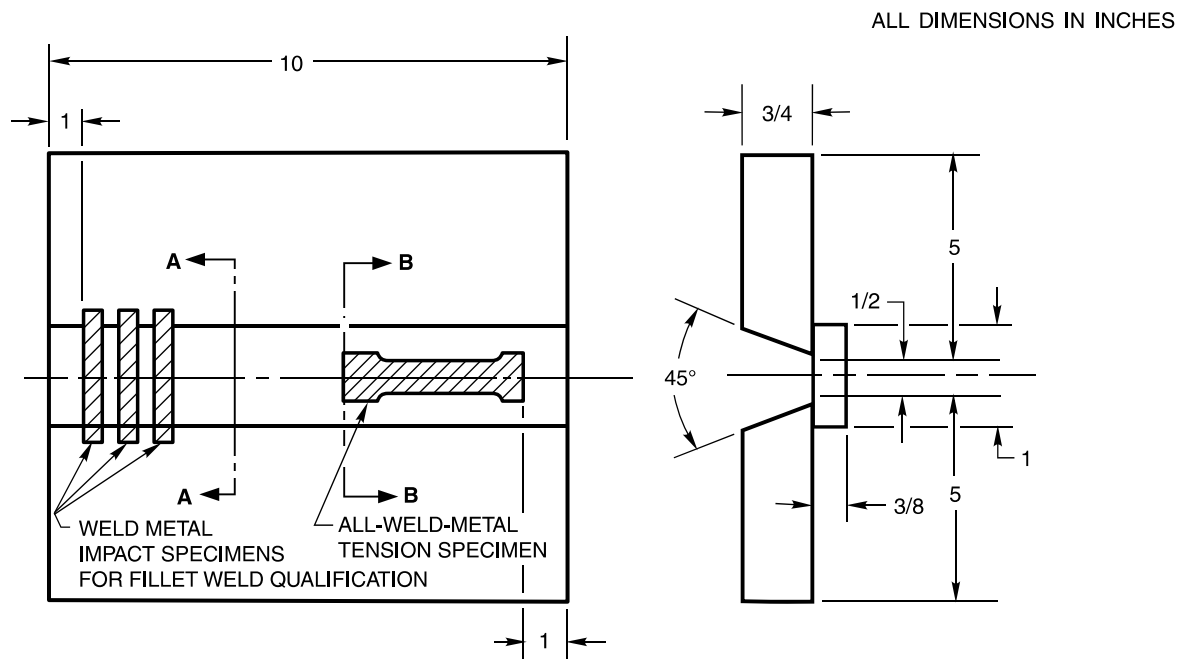
(C) LOCATION OF ALL-WELD-METAL TENSION SPECIMEN



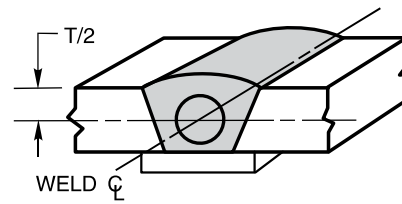
NOTE: EITHER SEQUENCE IS ACCEPTABLE.

(D) SEQUENCE FOR DEPOSITING THE WELD METAL

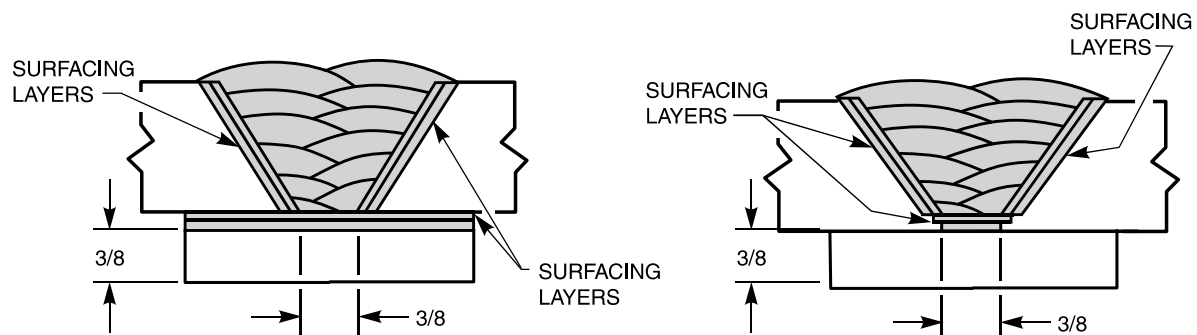
Figure 5.13—All-Weld-Metal Tension and Impact Specimen Test Plate Design and Specimen Locations



(B) ORIENTATION AND LOCATION OF
WELD METAL IMPACT SPECIMEN
(SEE ALSO 5.11.5 AND FIGURE 7.1)

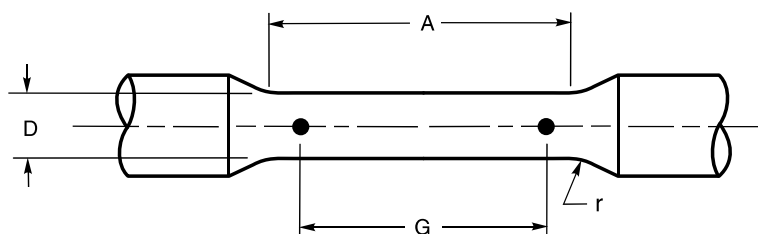


(C) LOCATION OF ALL-WELD-METAL
TENSION SPECIMEN



NOTE: EITHER SEQUENCE IS ACCEPTABLE.

Figure 5.13A—All-Weld-Metal Tension and Impact Specimen Test Plate Design and Specimen Locations (U.S. Customary Units)



	Standard Specimen	Small Size Specimens Proportional to Standard	
D—Diameter (Notes a, b)	20 ± 0.150	10 ± 0.075	5 ± 0.040
G—Gage Length (5:1)	100 ± 1.0	50 ± 0.5	25 ± 0.25
r—Radius of fillet, min	10	5	3
A—Length of reduced section, min (Note c)	110	55	28

^a Preferred ISO 6892 sizes are as shown. Other sizes may be used, provided the gauge length to diameter ratio of 6 is maintained, that is, $G/D = 5$, and $r \geq D/2$.

^b Metric specimens may be prepared in accordance with ASTM E 8M.

^c If desired, the length of the reduced section may be increased to accommodate an extensometer of any convenient gauge length. Reference marks for the measurement of elongation shall be spaced at the indicated gauge length.

Notes:

1. The reduced section may have a gradual taper from the ends toward the center, with the ends not more than one percent larger than the center (controlling dimension).
2. The gauge length and fillets shall be as shown, but the ends may be of any form to fit the holders of the testing machine in such a way that the load is axial. If the ends are to be held in wedge grips, it is desirable, if possible, to make the length of the grip section great enough to allow the specimen to extend into the grips a distance equal to two-thirds or more of the length of the grips.
3. The surface finish with the A dimension shall be no rougher than $1.5 \mu\text{m}$.
4. The weld coupon for the all-weld-metal tension coupon may be welded in the PA (1G) position.

Figure 5.14—All-Weld-Metal Tension Test Specimen Design

5.17.5 Fillet Welds. The welder shall weld fillet-weld test assemblies in accordance with the requirements of variables and positions of 5.16 and Table 5.5. The required type and number of specimens are described in Part II of clauses 7 through 9 for Class A through O welds, respectively.

5.18 Method of Testing

5.18.1 Visual and radiographic examination of welder qualification coupons shall be accomplished in accordance with clause 6, Parts II and III, as applicable.

5.18.2 Bend specimens shall be tested in accordance with the requirements of 5.11.3.

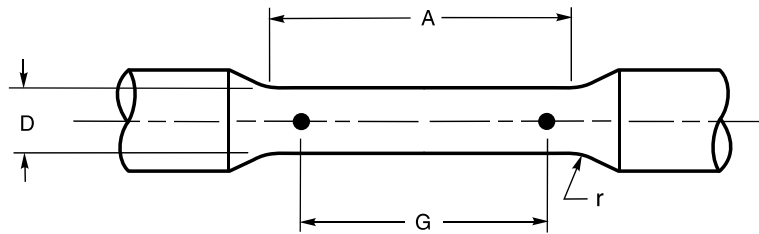
5.18.3 Fillet-weld specimens shall be tested in accordance with 5.11.6, 5.11.7, and 5.11.8, as applicable.

5.18.4 Macroetch test specimens shall meet the requirements of 5.11.

5.19 Test Results Required. Required results for welder qualification testing are identified in Part II of clauses 7 through 9 for Class A through O welds, respectively.

5.20 Retests. If a welder fails to satisfy the requirements of this clause in a given position, the welder may be retested in that position by welding two test welds. Both welds shall satisfy the requirements of this clause. If either or both welds are unsatisfactory, the welder must provide evidence of further training prior to retest.

5.21 Period of Effectiveness. Qualified welders shall remain qualified for one year from their last qualification or acceptable production weld within the range of variables in 5.16. Nevertheless, when a qualified welder has not welded with the procedure at any time during the previous 90 days, a 200 mm (8 in) long weld shall be welded in the vertical or overhead position or the position in production in which the majority of the welding will be done. Thickness of material



	Dimensions (inches)		
	Standard Specimen	Small Size Specimens	Proportional to Standard
Nominal Diameter	0.500 in round	0.350 in round	0.250 in round
G—Gage Length	2.000 ± 0.005	1.400 ± 0.005	1.000 ± 0.005
D—Diameter ^a	0.500 ± 0.010	0.350 ± 0.007	0.250 ± 0.005
r—Radius of fillet, min	3/8	1/4	3/16
A—Length of reduced section, min ^b	2-1/4	1-3/4	1-1/4

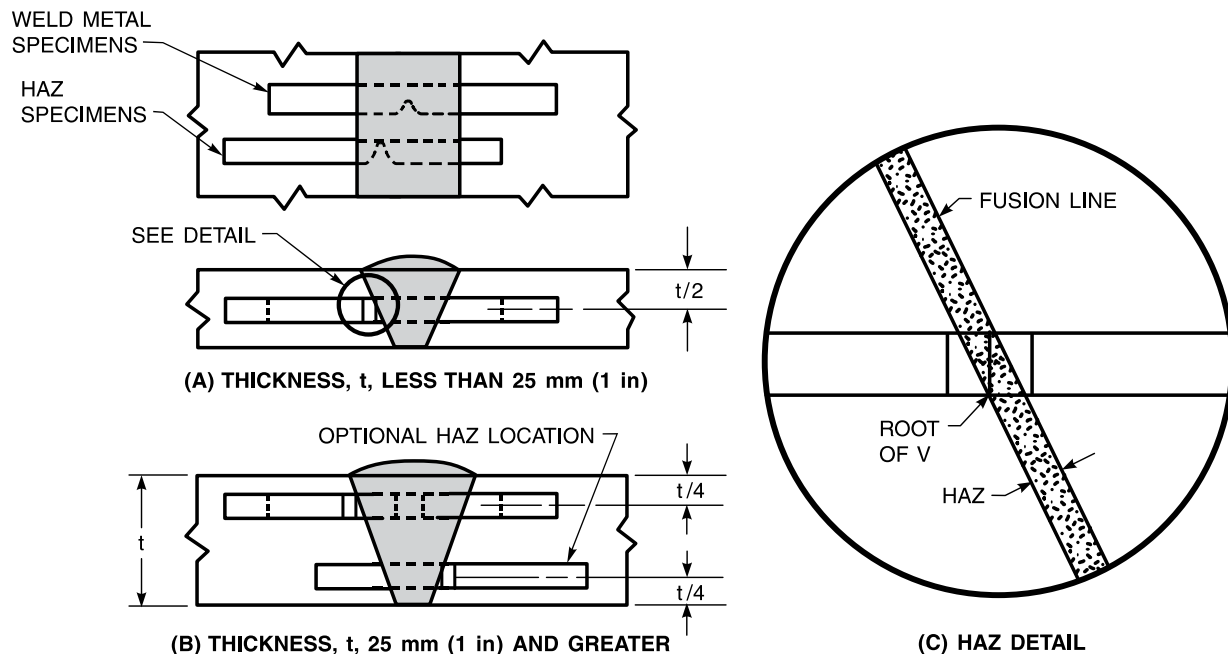
^a The reduced section may have a gradual taper from the ends toward the center, with the ends not more than one percent larger than the center (controlling dimension).

^b If desired, the length of the reduced section may be increased to accommodate an extensometer of any convenient gauge length. Reference marks for the measurement of elongation shall be spaced at the indicated gauge length.

Notes:

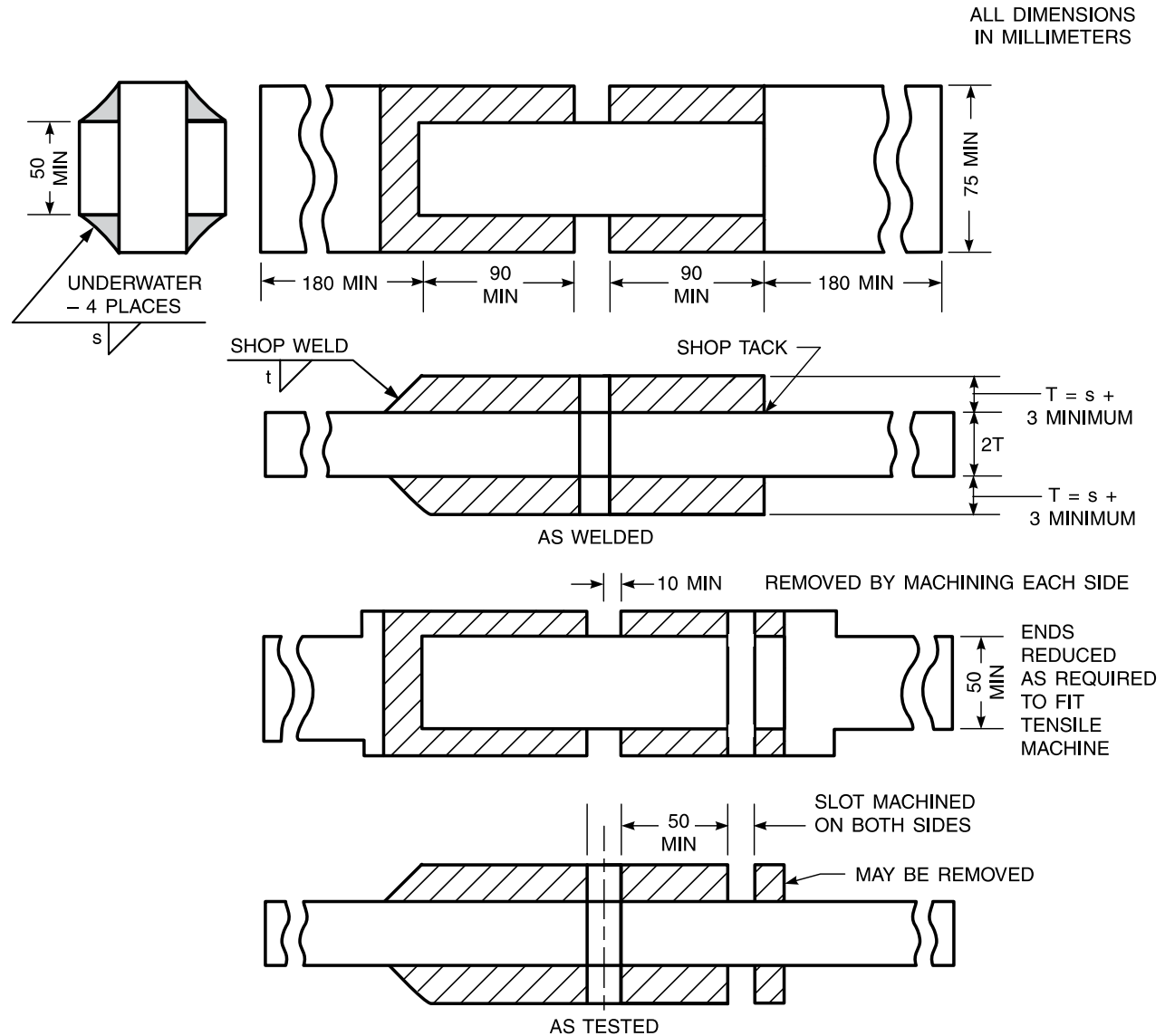
1. The gauge length and fillets shall be as shown, but the ends may be of any form to fit the holders of the testing machine in such a way that the load is axial. If the ends are to be held in wedge grips, it is desirable, if possible, to make the length of the grip section great enough to allow the specimen to extend into the grips a distance equal to two-thirds or more of the length of the grips.
2. The surface finish with the A dimension shall be no rougher than 63 μin .
3. If necessary, a subsize specimen, as shown in the filler metal specification, may be used.
4. The weld coupon for the all-weld-metal tension coupon may be welded in the PA (1G) position.

Figure 5.14A—All-Weld-Metal Tension Test Specimen Design (U.S. Customary Units)



NOTE: NOTCH IN EACH SPECIMEN IS TO RUN PERPENDICULAR TO THE PLATE SURFACE.

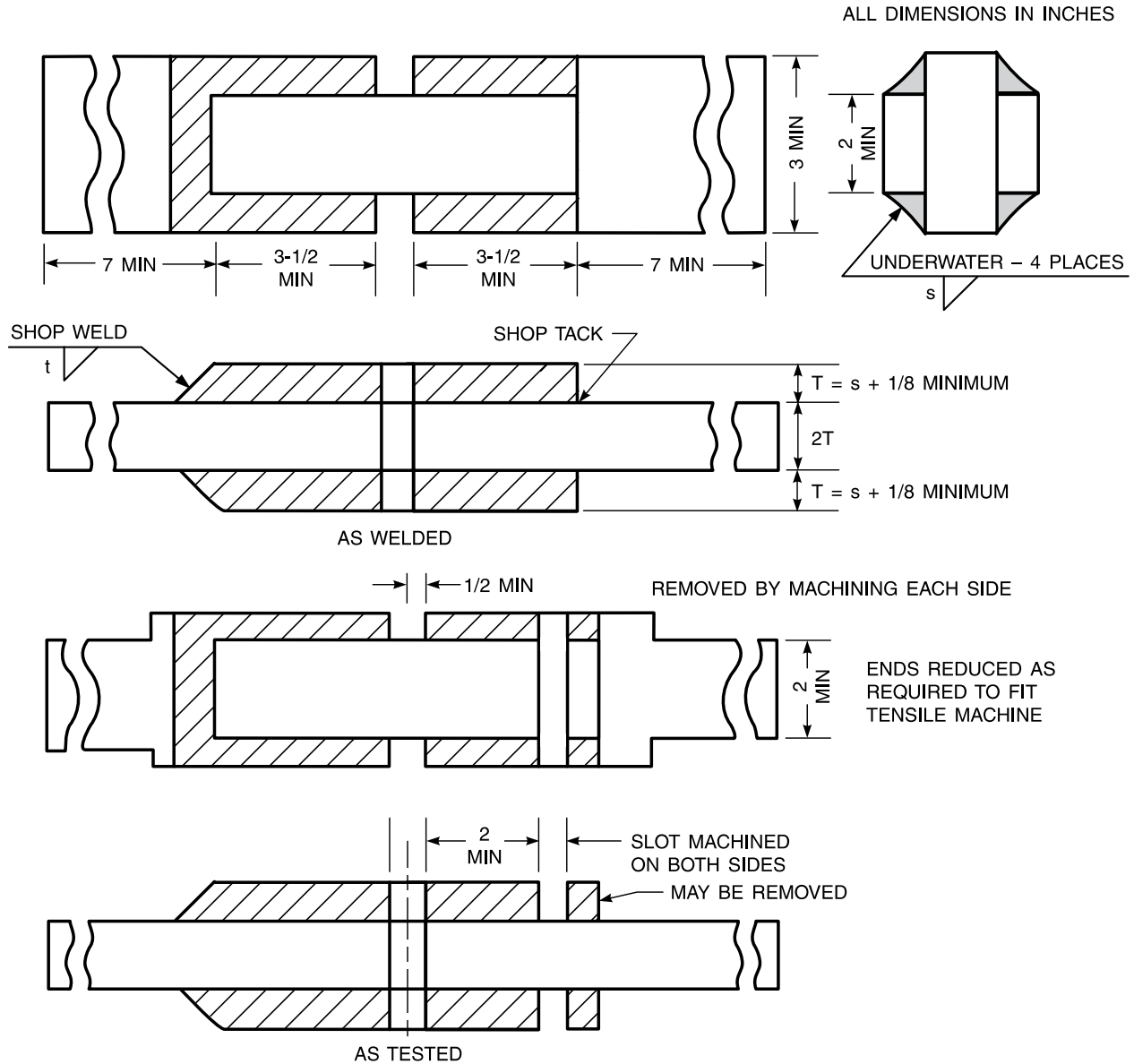
Figure 5.15—Location of Charpy V-Notch Impact Test Specimen in Test Weld



Notes:

1. Test fillet weld size $s = 10$ mm except for single-pass fillet welds.
2. Other plate thicknesses and fillet weld sizes may be used by agreement.
3. Total length of fillet weld tested in shear shall not exceed the total length of the shop fillet weld. The test length is determined by the distance between the machined slots. Minimum length of underwater fillet weld to be tested is 200 mm.
4. Prior to testing, the average throat and total test length of the test fillet weld shall be measured. The throat of the weld is the minimum distance from the root of the joint to the face of the fillet weld. Root penetration is disregarded. The weld area in shear is calculated by multiplying the average throat by the total test length.
5. The specimen shall be tested in tension to failure, which shall be by shear through the test fillet welds. The maximum load is recorded.
6. The shear strength is determined by dividing the maximum load by the total weld area (throat times length) in shear.
7. Wider cover plates may be necessary to prevent tensile failure across the cover plates. Higher tensile strength plate may be used.
8. This specimen may also be used for procedure qualification of fillet welds on pipe.

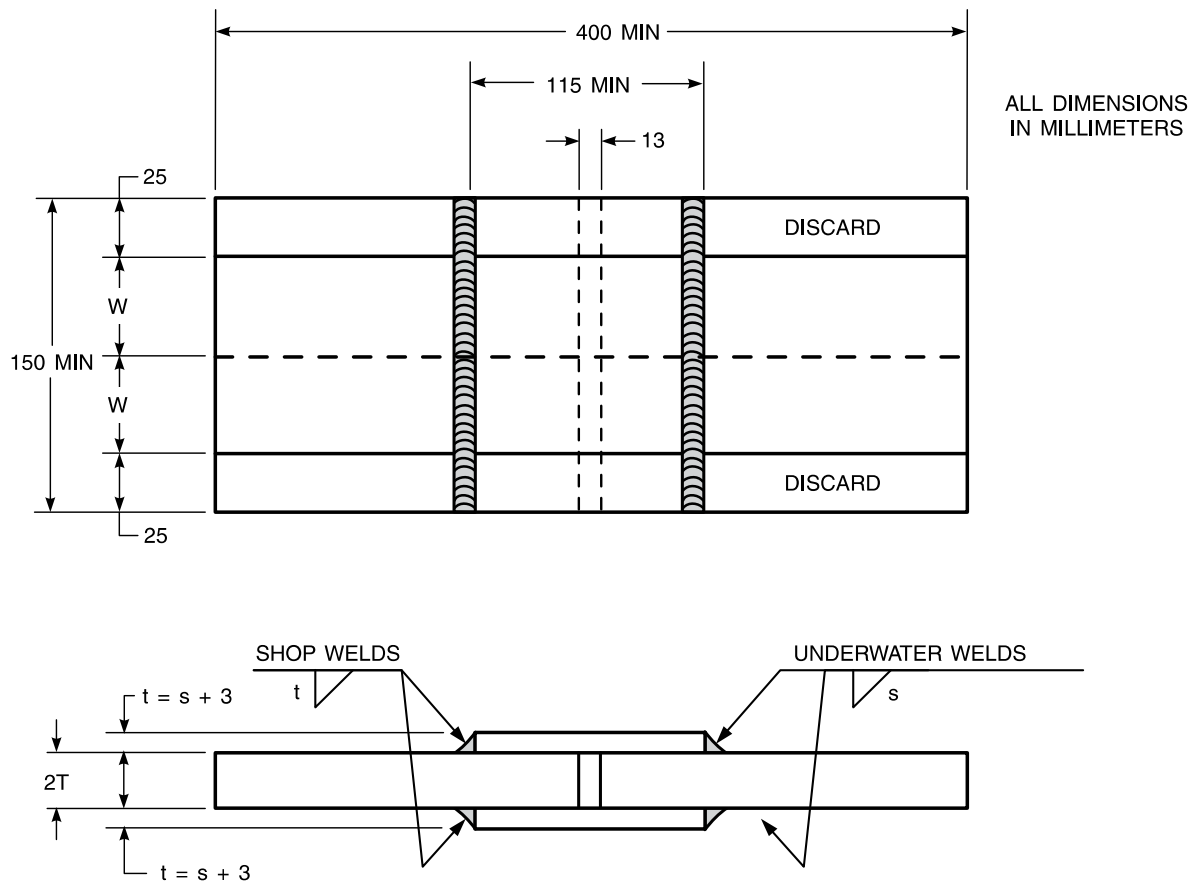
Figure 5.16—Fillet Weld Shear Strength Specimens—Longitudinal from Plate



Notes:

1. Test fillet weld size $s = 3/8$ in, except for single-pass fillet welds.
2. Other plate thicknesses and fillet weld sizes may be used by agreement.
3. Total length of fillet weld tested in shear shall not exceed the total length of the shop fillet weld. The test length is determined by the distance between the machined slots. Minimum length of underwater fillet weld to be tested is 8 in.
4. Prior to testing, the average throat and total test length of the test fillet weld shall be measured. The throat of the weld is the minimum distance from the root of the joint to the face of the fillet weld. Root penetration is disregarded. The weld area in shear is calculated by multiplying the average throat by the total test length.
5. The specimen shall be tested in tension to failure, which shall be by shear through the test fillet welds. The maximum load is recorded.
6. The shear strength is determined by dividing the maximum load by the total weld area (throat times length) in shear.
7. Wider cover plates may be necessary to prevent tensile failure across the cover plates. Higher tensile strength plate may be used.
8. This specimen may also be used for procedure qualification of fillet welds on pipe.

**Figure 5.16A—Fillet Weld Shear Strength Specimens—Longitudinal from Plate
(U.S. Customary Units)**



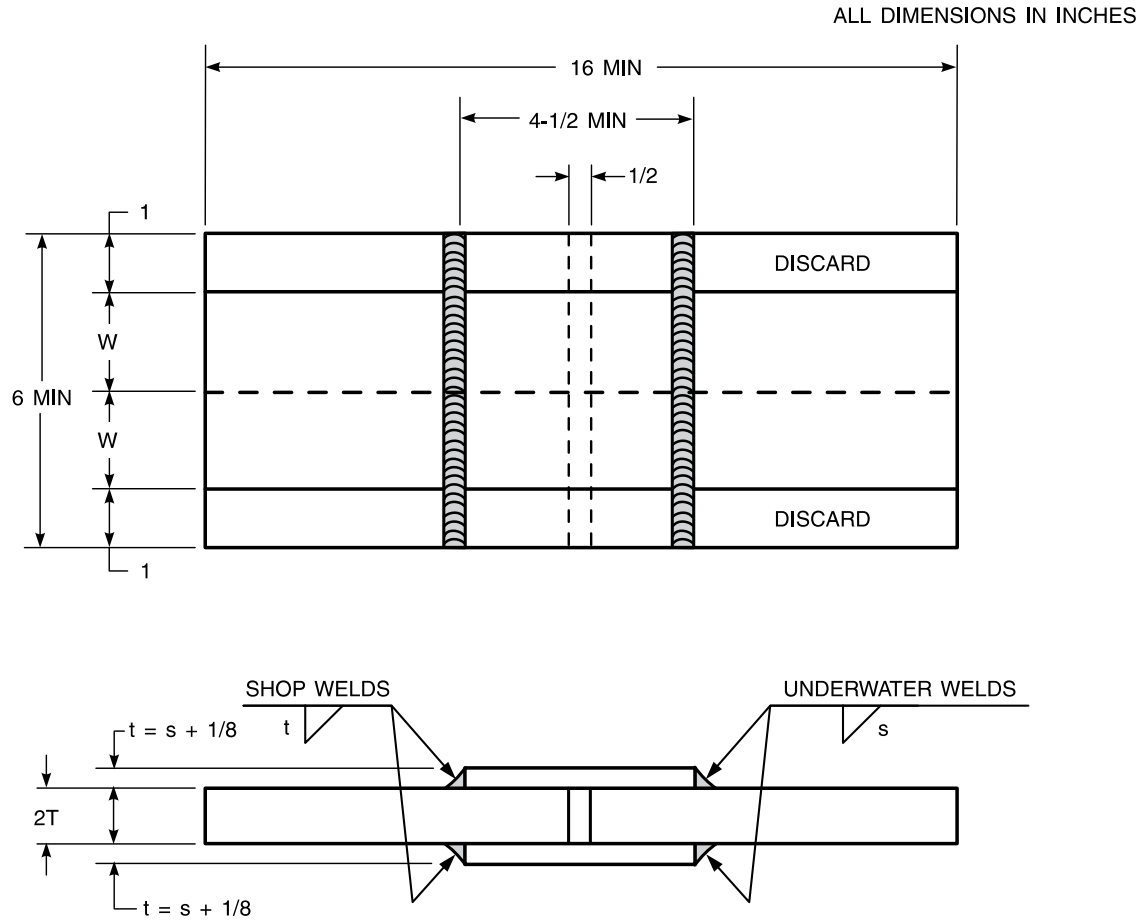
Notes:

1. Test fillet weld size $s = 10$ mm except for single-pass fillet welds.
2. Other plate thicknesses and fillet weld sizes may be used by agreement.
3. The number of specimens (straps) cut from the coupon, and their width, W , may be controlled by testing machine capacity. The minimum total length of underwater weld to be tested is 200 mm, i.e., 100 mm on top and 100 mm on bottom of the coupon as indicated.
4. Specimens shall be machine cut, with edges smooth and parallel.
5. Prior to testing, the average throat and total test length of each fillet weld test specimen shall be measured. The throat of the weld is the minimum distance from the root of the joint to the face of the fillet weld. Root penetration is disregarded. The weld area in shear is calculated by multiplying the average throat by the total test length.
6. Each specimen shall be tested in tension to failure, which shall be by shear through the test fillet welds. The maximum load is recorded.
7. The shear strength for each specimen is determined by dividing the maximum load by the total weld area (throat times length) in shear. The reported shear strength is the average of the shear strengths of all specimens from the transverse fillet weld test coupon.
8. This specimen may also be used for procedure qualification of fillet welds on pipe.

Figure 5.17—Fillet Weld Shear Strength Specimens—Transverse from Plate

and weld size shall be within the range qualified by the welding procedure qualification. The welder shall remain qualified if visual (for fillet welds) and radiographic (for groove welds) inspections meet the acceptance criteria for the class of weld. Macroetch tests may be substituted for radiographic examination as specified in 7.6.1 or 8.6.1.

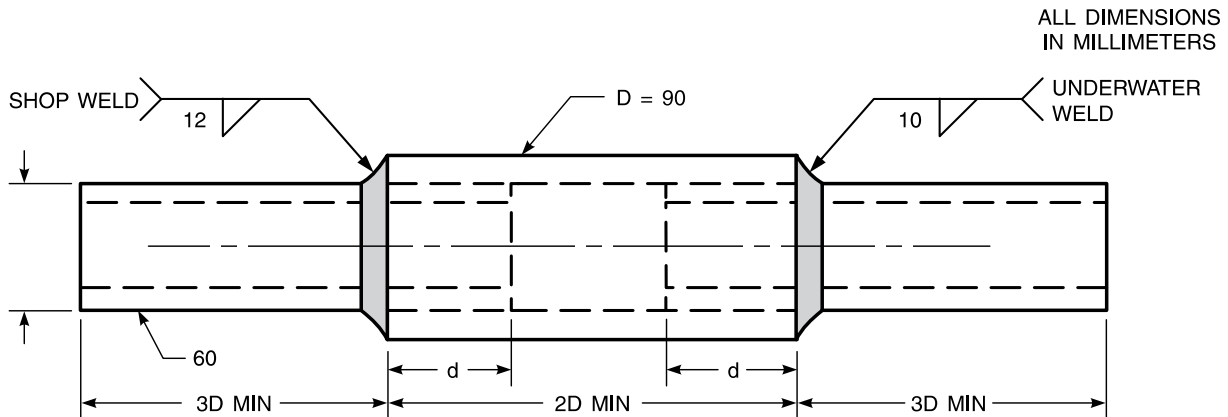
5.22 Records. Records of welder qualification test results shall be maintained by the Contractor and shall be available to those authorized to examine them.



Notes:

1. The number of specimens (straps) cut from the coupon, and their width, W , may be controlled by testing machine capacity. The minimum total length of underwater weld to be tested in 8 in, i.e., 4 in on top and 4 in on bottom of the coupon as indicated.
2. Test fillet weld size $s = 3/8$ in except for single-pass fillet welds.
3. Other plate thicknesses and fillet weld sizes may be used by agreement.
4. Specimens shall be machine cut, with edges smooth and parallel.
5. Prior to testing, the average throat and total test length of each fillet weld test specimen shall be measured. The throat of the weld is the minimum distance from the root of the joint to the face of the fillet weld. Root penetration is disregarded. The weld area in shear is calculated by multiplying the average throat by the total test length.
6. Each specimen shall be tested in tension to failure, which shall be by shear through the test fillet welds. The maximum load is recorded.
7. The shear strength for each specimen is determined by dividing the maximum load by the total weld area (throat times length) in shear. The reported shear strength is the average of the shear strengths of all specimens from the transverse fillet weld test coupon.
8. This specimen may also be used for procedure qualification of fillet welds on pipe.

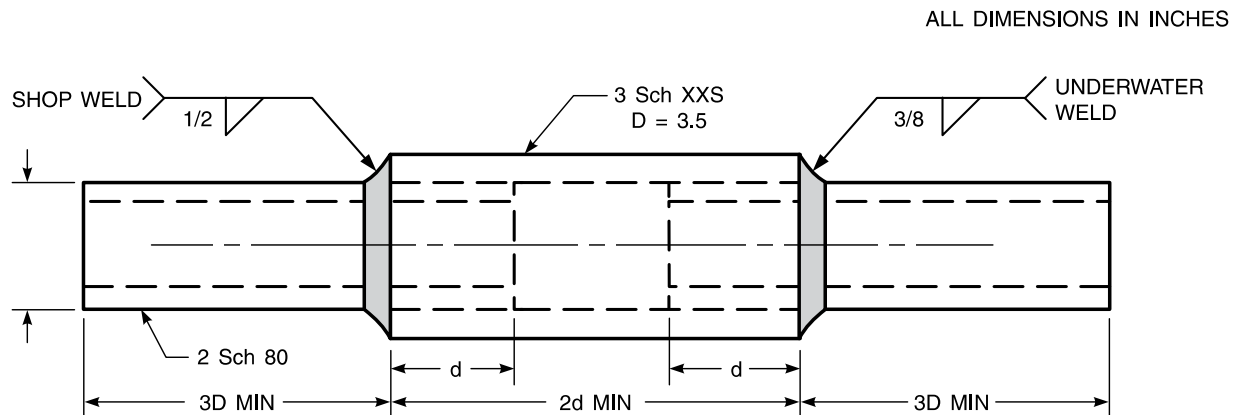
**Figure 5.17A—Fillet Weld Shear Strength Specimens—Transverse from Plate
(U.S. Customary Units)**



Notes:

1. $d = 60$ mm. Larger pipe sizes may result in breaking strengths exceeding usual testing machine capabilities.
2. Other pipe and fillet weld sizes may be used by agreement.
3. Pipe I.D. may be machined for joint fitup.
4. The coupon length shall be sufficient to accommodate the plug and testing machine jaws as shown in ASTM A370 or ANSVAWS B4.0.
5. Prior to testing, the average throat dimension and total fillet weld test length shall be measured. The throat of the weld is the minimum distance from the root of the joint to the face of the fillet weld. Root penetration is disregarded. The weld area in shear is calculated by multiplying the average throat by the total test length.
6. The specimen shall be tested in tension to failure, which shall be by shear through the test fillet welds. The maximum load is recorded.
7. The shear strength is determined by dividing the maximum load by the total weld area (throat times length) in shear.
8. The specimen may also be used for procedure qualification of fillet welds on plate.

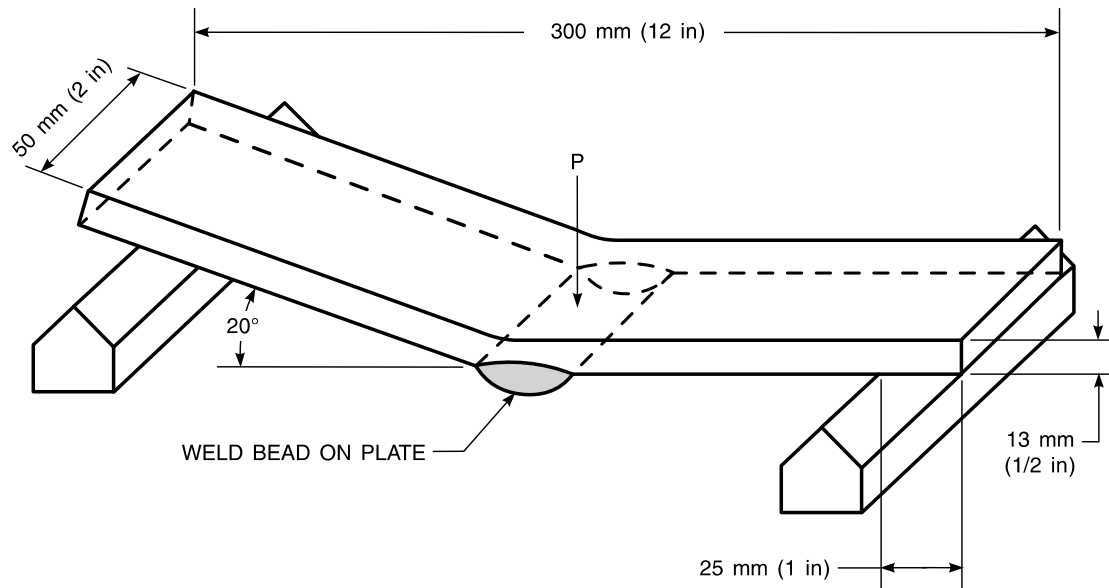
Figure 5.18—Transverse Weld Shear Strength Test Coupon for Pipe



Notes:

1. $d = 2.375$ in (or 2 in nominal pipe size). Larger pipe sizes may result in breaking strengths exceeding usual testing machine capabilities.
2. Other pipe and fillet weld sizes may be used by agreement.
3. Pipe I.D. may be machined for joint fitup.
4. The coupon length shall be sufficient to accommodate the plug and testing machine jaws as shown in ASTM A370 or ANSVAWS B4.0.
5. Prior to testing, the average throat dimension and total fillet weld test length (i.e., $3.14 \times [d + S/2]$) shall be measured. The throat of the weld is the minimum distance from the root of the joint to the face of the fillet weld. Root penetration is disregarded. The weld area in shear is calculated by multiplying the average throat by the total test length.
6. The specimen shall be tested in tension to failure, which shall be by shear through the test fillet welds. The maximum load is recorded.
7. The shear strength is determined by dividing the maximum load by the total weld area (throat times length) in shear.
8. The specimen may also be used for procedure qualification of fillet welds on plate.

**Figure 5.18A—Transverse Weld Shear Strength Test Coupon for Pipe
(U.S. Customary Units)**



Notes:

1. Test weld to be made with a single pass.
2. Sample to be bent with the face in tension.
3. Sample is to be supported at each end with a slowly applied force (P) applied of the center (three point bending).
4. Bending is to proceed until the sample has a permanent band angle of 20 degrees minimum.

Figure 5.19—Bridge Bend Test

Table 5.5
Positions for Welder Qualification

Qualification Test		Type of Weld and Position of Welding Qualified ^a			
		Plate		Pipe ^b	
Weld	Plate or Pipe Positions ^c	Groove	Fillet	Groove	Fillet
Plate—groove	PA (1G)	F	F, H	F	F, H
	PC (2G)	F, H	F, H	F, H	F, H
	PG (3G)	F, V down	F, H, V down		F, H, V down
	PF (3G)	F, V up	F, H, V up		F, H, V up
	PE (4G)	F, OH	F, H, OH		F, H, OH
	PG or PF, & PE (3G & 4G)	F, V, OH	All		All
Plate—fillet	PA (1F)		F		F
	PB (2F)		F, H		F, H
	PG (3F)		F, V down		F, V down
	PF (3F)		F, V up		F, V up
	PD (4F)		F, H, OH		F, H, OH
	PG or PF, & PD (3F & 4F)		F, V, H, OH		F, V, H, OH
Pipe—groove	PA (1G)	F	F, H	F	F, H
	PC (2G)	F, H	F, H	F, H	F, H
	PG (5G)	F, OH, V down	F, OH, V down	F, V, down, OH	F, V down, OH
	PF (5G)	F, OH, V up	F, OH, V up	F, V up, OH	F, V up, OH
	H-L045, J-L045 (6G)	All	All	All ^d	All
	PG or PF, & PC (2G & 5G) (6GR)	All	All	All ^d	All
Pipe—fillet	PA (1F)		F		F
	PB (2F or 2FR)		F, H		F, H
	PD (4F)		F, H, OH		OH
	PG (5F)		F, H, OH, V down		F, H, V down, OH
	PF (5F)		F, H, OH, V up		F, H, V up, OH

^a Position of welding: F-flat, H-horizontal, V-vertical, OH-overhead.

^b Plate qualifies pipe or tubing over 600 mm (24 in) in diameter.

^c Positions as defined in 5.8.

^d Except complete joint penetration groove welds in tubular T-, Y-, and K-connections.

Table 5.6
Pipe Diameter Groups for Welder Qualification

Test Pipe Diameter, D, mm (in)	Diameter of Production Pipe Qualified
100 (4) and under	0.7D to 2D
Over 100 (4) up to 300 (12)	0.50D to 2D
300 (12) and over	0.50D and above

Notes:

1. See Tables 5.1 and 5.2 for range of thickness qualified.
2. See clause 5.16 for other welder qualification variables.
3. See Figures 7.3 and 8.3 for required number of test specimens.

6. Inspection

Part I ***General Requirements***

6.1 General

6.1.1 The Contractor shall ensure that materials, fabrication, and examination procedures conform to this code. The Customer should verify this conformance.

6.1.2 All weld classes shall, as a minimum, receive visual examination in accordance with the requirements of Part II of this clause. Welds shall meet the inspection requirements and acceptance criteria specified in Part III of Clauses 7 through 9 for Class A through O welds, respectively.

6.1.3 Drawings or other documents shall show the size, type, class, and location of welds to be made and the method of examination required for each weld where other than visual examination is required. When supplemental nondestructive examination is required, the Customer shall designate the welds to be examined, extent of examination of each weld, method of examination, required resolution, and acceptance standards. When random or partial examinations are required, the Customer shall designate weld(s) to be inspected.

6.1.4 The Customer shall be notified prior to the start of welding operations.

6.2 Inspection of Materials. The Customer shall have the right to examine the materials, welding consumables, and supporting documentation to verify that they are qualified for use in production welding. The Customer may not have access to the worksite in some operations; therefore, special consideration for the collection and recording of data will generally be necessary.

6.3 Inspection of Equipment. The Customer shall have the right to examine the equipment to verify that it is suitable for use in production welding.

6.4 Verification of Procedure and Performance Qualification

6.4.1 The Contractor shall not proceed with production welding until the Customer has approved the procedure qualification records and has verified that the procedure qualification is appropriate for the materials to be welded.

6.4.2 The Contractor shall furnish the Customer with evidence that all welders are qualified in accordance with the requirements of Clause 5. Evidence of previous qualification may be accepted by the Customer if the qualification meets all applicable criteria of this code. The Contractor shall maintain a record at the job site of the qualifications of all welders, all procedure qualifications or other tests that are made, and such other information as required by the Customer.

6.4.3 The Contractor shall have sufficient evidence submitted to and approved by the Customer to verify that the confirmation weld meets the requirements of 3.4.

6.4.4 Where the Customer judges that a welder's work may not meet this code, the welder shall produce a requalification weld made in accordance with Clause 5, Part III. At the Customer's discretion, an alternate test suitable for the type of welding involved (e.g., fillet weld break test) may be performed.

6.5 Inspection of Work and Records

6.5.1 All welds, including repair welds, shall be examined. The examination procedures are described in Part II, *Visual Examination*, Part III, *Radiographic Examination*, Part IV, *Ultrasonic Examination*, Part V, *Magnetic Particle Examination*, and Part VI, *Eddy Current Examination*, all in this clause. Acceptance standards are described in Part III of

Clauses 7 through 9 for Class A through O welds, respectively. Satisfactory results for all required examinations shall be submitted to and approved by the Customer. Surface condition of the material shall be such that an adequate examination of the weld can be made with the pertinent examination method.

6.5.2 The Contractor shall provide sufficient evidence to the Customer to verify that the size, length, and location of all welds conform to the requirements of this standard and to the detail drawings, that no specified welds are omitted, and that no unspecified welds have been added without approval.

6.5.3 The Customer shall have the right of inspection of all welds by supplementary visual means (i.e., photographic, video, etc.), by radiographic or other nondestructive methods, and by destructive testing. Inspection may be made both during the welding operation and after the welding has been completed.

6.5.4 If nondestructive examination other than visual is not specified herein but is requested by the Customer, the Contractor shall perform such requested examination or permit the examination to be performed in accordance with 6.7 of this code.

6.5.5 Welds examined nondestructively that do not meet the requirements of this code shall be repaired by the methods permitted by Clause 3.

6.6 Obligations of Contractor

6.6.1 The Contractor shall be responsible for initial visual examination of all welds. The Contractor shall correct defective welds in accordance with the welding procedure specification and the requirements of this code.

6.6.2 In the event that faulty welding, or removal of faulty welding for repair, damages the base metal and, in the judgment of the Customer, retention of the base metal is not in accordance with the intent of the drawings and specifications, the Contractor shall remove and replace the damaged base metal or shall otherwise correct the deficiency in a manner approved by the Customer.

6.6.3 When nondestructive examination other than visual examination is specified in the contract, it shall be the Contractor's responsibility to ensure that all specified welds meet the acceptance criteria specified in Part III of Clauses 7 through 9 for Class A through O welds, respectively.

6.7 Inspection Methods

6.7.1 When visual or supplemental visual examination is used, the procedure and technique shall be in accordance with 6.10.

6.7.2 When radiographic examination is used, the procedure and technique shall be in accordance with 6.12.

6.7.3 When ultrasonic examination is used, the procedure and technique shall be in accordance with 6.14.

6.7.4 When magnetic particle examination is used, the procedure and technique shall be in accordance with 6.16.

6.7.5 For detecting discontinuities that are open to the surface, dye penetrant examination procedures suitable at hyperbaric pressures may be used for welds in a dry environment. The standard methods set forth in ISO 3452 or ASTM E 165 shall be used for dye penetrant examination. This method is not generally suitable for examination of welds in an underwater wet environment.

6.7.6 When eddy current examination is used, the procedure and techniques shall be in accordance with 6.18.

6.8 Inspection Personnel Qualification

6.8.1 When inspection is to be conducted in a wet environment, the nondestructive examination operators and technician/divers shall provide supplementary evidence of training and experience establishing their capability to operate the equipment and perform examinations in the underwater environment to the satisfaction of the Customer. Personnel interpreting nondestructive examination results shall be qualified as NDT Level II or III in accordance with the current edition of American Society for Nondestructive Testing, *Recommended Practice No. SNT-TC-1A*. Individuals qualified AWS "RI" qualified Inspector or AWS "CWI" as determined by the Customer, may also interpret nondestructive testing results.

6.8.2 Additional Ultrasonic Qualification Requirements. In addition to the requirements of 6.8.1, when ultrasonic examinations of T-, Y-, and K-connections are to be performed, the operator shall be required to demonstrate ability to apply the special techniques required for such examination. Practical tests for this purpose shall be performed as specified

in API RP2X, *Recommended Practice for Ultrasonic Examination of Offshore Structural Fabrication and Guidelines for Qualification of Ultrasonic Technicians* using mock-up welds similar to the welds to be inspected. The mock-up welds should contain a representative range of dihedral angles and thicknesses to be encountered in production. The inspection shall be qualified and approved for use.

Each mock-up shall contain natural or artificial discontinuities that yield ultrasonic indications above and below the reject criteria specified in the approved procedure to be used. Performance shall be judged based upon the ability of the operator to determine the size and classification of each discontinuity with an accuracy required to accept or reject each weldment and to locate accurately the rejectable discontinuities along the weld and within the cross-section of the weld.

6.8.3 Additional Eddy Current Qualification Requirements. For either the wet or dry environment, operators manipulating the probe coil shall be qualified to the minimum level outlined in SNT-TC-1A-ET1. Personnel interpreting the ET results shall be qualified to SNT-TC-1A-ET2 in either the wet or dry environment, as applicable.

Part II

Visual Examination

6.9 General

6.9.1 The procedure and standards described herein shall govern the visual examination of welds in both dry and wet environments.

6.9.2 Variation in procedure, equipment, or criteria may be used upon agreement with the Customer.

6.9.3 Welds that do not meet the visual acceptance criteria specified in Part III of Clauses 7 through 9, as applicable for the class of weld inspected, shall be corrected in accordance with Clause 3.

6.10 Procedure

6.10.1 The Customer may verify that the inspection meets the requirements of this clause, and that the weld meets the visual acceptance criteria of Part III of Clauses 7 through 9 for the class of weld inspected.

6.10.2 Visual examination techniques shall employ aids as necessary to provide adequate resolution. The method to be used shall be included in a written examination procedure. The procedure shall be qualified by the Contractor and approved by the Customer prior to examination of production welds.

6.10.3 Each weld shall be uniquely identified on all visual examination records.

6.10.4 All videotapes and photographs, and a report interpreting the inspection results, shall be submitted to the Customer. This data shall include documentation of unacceptable conditions prior to and subsequent to repair. Approval of the data by the Customer shall constitute acceptance of the weld. Retention or disposition of inspection data, or both, is the responsibility of the Customer.

Part III

Radiographic Examination

6.11 General

6.11.1 The requirements described herein shall govern radiographic examination of welds when such examination is required. These procedures shall be used for examining groove welds in both wet and dry environments.

6.11.2 Variations in examination procedure, equipment, and acceptance standards may be used upon agreement with the Customer. Variations may be necessary to accommodate location, application, or operator safety. Such variations include but are not limited to: (1) the radiographic examination of fillet, T-joint, or corner welds; (2) changes in source-to-film distances; (3) application of film for unusual geometries; (4) unusual penetrameter application; (5) film types or densities; and (6) film exposure or development variations. The Customer may require that the applicability of other procedures be demonstrated prior to use.

6.11.3 When spot radiographic examination is specified, the number of spots in each designated category of weld or the number required to be made in a stated length of weld shall be specified by the Customer. Each spot examined shall cover at least 100 mm (4 in) of the weld length. When spot examination reveals discontinuities that require repair, two additional spots selected by the Customer shall be radiographically examined. If discontinuities requiring repair are revealed in either of these, the entire length of the weld in that welded joint shall be radiographically examined.

6.11.4 When radiography is required, welds that do not meet the radiographic acceptance criteria of Part III in Clauses 7 through 9, as applicable for the class of weld inspected, shall be corrected in accordance with Clause 3.

6.12 Procedure

6.12.1 All radiographic examinations (RT) shall be in accordance with a procedure complying with the requirements of this code and which has been prepared or approved by an individual qualified to SNT-TC-1A Level III. A written procedure specifying equipment and operations required to radiograph the weld shall be submitted to the Customer for approval prior to its use on production welding.

6.12.2 The size of discontinuities, as a percent of the thickness of the weld, that must be resolved in the radiograph shall be 2 percent or less of the base metal thickness. A radiographic image quality indicator (IQI) shall be used to provide proof of resolution.

6.12.3 If, in the Customer's judgment, film processing defects may have obscured defects, the weld shall be reexamined.

6.12.4 If, in the Customer's judgment, weld surface irregularities may obscure defects, the surface shall be smoothed by a procedure submitted to and approved by the Customer.

6.12.5 Radiographs shall have an H & D (Hurter and Driffield) density of not less than 1.8 nor more than 4.0. Densities within the range of 2.5 to 3.5 are preferred.

6.12.6 The source of radiation shall be approximately centered with respect to the length being examined. An IQI shall be located within 25 mm (1 in) of each end of the applicable length of film, and it shall be placed on the side of the work nearer the source, where accessible. When a complete girth weld in pipe is radiographed in a single exposure using a source inside the pipe, a minimum of three image quality indicators equally spaced around the circumference shall be used. The perpendicular distance from the radiation source to the film shall be no less than seven times the maximum thickness of the weld under examination, and the rays shall not penetrate the weld at an angle greater than 26–1/2 degrees from a line perpendicular to the film surface. Where the source side is not accessible for locating the IQI, the procedure test shall establish the required IQI on the film side.

6.12.7 Each radiograph shall show the following:

- (1) The specified sensitivity of the IQI
- (2) An IQI identification number
- (3) A radiograph identification code
- (4) Weld sector identification

6.12.8 A radiographic procedure shall be resubmitted for approval when one or more of the following apply:

- (1) The IQI is transferred from the film side to the source side of the weld or vice versa.
- (2) Intensification or absorption screens are added or deleted.
- (3) The type of radiation source shall be changed (x-ray, gamma ray, etc.).
- (4) The type or grade of film shall be changed.

6.12.9 A viewer with suitable high-intensity and sufficient capacity to illuminate radiographs with an H & D density of 4.0 without difficulty shall be used.

6.12.10 Before a weld subject to radiographic examination is accepted, all radiographs, including any revealing unacceptable indications prior to repair, and a report interpreting the results shall be submitted to and approved by the Customer. Approval of the radiographs by the Customer shall constitute acceptance of the weld.

Part IV

Ultrasonic Examination

6.13 General. Procedure requirements described herein are conventional contact methods only.

6.14 Procedure. All ultrasonic examinations (UT) shall be in accordance with procedures written in compliance with the requirements of this code and which have been prepared or approved by a qualified individual experienced in UT

of welded structures. Prior to use on production welds, the procedure and acceptance criteria shall be approved by the Customer, and personnel shall have been successfully qualified per 6.8. When T-, Y-, and K-connections are to be examined, the UT specialist shall also be experienced in examination of those types of weldment.

6.14.1 Minimum Requirements. The written procedure shall contain as a minimum the following information regarding the UT method and techniques:

- (1) Type of weld joint configuration to be examined (i.e., the applicable range of thickness, diameter, and local dihedral angle⁸)
- (2) Acceptance criteria for each type and size of weld
- (3) Description of UT instrumentation (make and model)
- (4) Length of coaxial cable (connecting cable from UT instrument to search unit)
- (5) Transducer (search unit) frequency, size, and shape of active area, beam angle, and type of wedge on angle beam probes⁹
- (6) Functions to be performed by and information displays available to diver and topside technician
- (7) Surface preparation and couplant (where used)
- (8) Type of calibration test block and reference reflector
- (9) Method of calibration and required accuracy for distance (sweep), beam spread, vertical linearity, angle sensitivity, and resolution
- (10) Recalibration interval for each item
- (11) Method for determining acoustical continuity of base metal (see 6.14.3) and for establishing weld geometry as a function of local dihedral angle and thickness
- (12) Scanning pattern and sensitivity (see 6.14.4)
- (13) Adjustment for depth (pressure) effects
- (14) Transfer correction for surface curvature and roughness, where amplitude methods are used [see 6.14.2.2 (3)]
- (15) Methods for determining effective beam angle (in curved material), indexing root area, and flaw location
- (16) Method of determining discontinuity length and width
- (17) Method of defect verification during excavation and repair

6.14.2 Calibration. UT equipment qualifications and calibration methods shall be established in the approved procedure and shall meet the following requirements:

6.14.2.1 Range (Distance) Calibration. Calibration shall include, as a minimum, the entire sound-path distance to be used during the specified examination. This may be adjusted to represent either sound-path travel, surface distance, or equivalent depth below the contact surface, displaced along the instrument horizontal scale, as described in the approved procedure.

6.14.2.2 Sensitivity Calibration. Standard sensitivity ARL (Amplitude Reject Level) for examination of production welds using amplitude techniques shall be the sum of the basic sensitivity, the distance amplitude correction, and the transfer correction. This calibration shall be performed at least once for each joint to be tested.

- (1) Basic sensitivity—Reference level screen height shall be obtained using maximum reflection from the 1.5 mm (0.060 in) diameter hole of the IIW block (or other block which results in the same basic calibration sensitivity) as described in the approved procedure.

⁸ Conventional techniques are limited to diameters of 320 mm (12.75 in) and above, thicknesses of 13 mm (1/2 in) and above, and local dihedral angles of 30 degrees or greater. Special techniques for small sizes may be used, provided they are qualified as described herein, using the smallest size of application.

⁹ Procedures using transducers with frequency up to and including 6 MHz, size down to and including 6 mm (1/4 in), and various geometric shapes may be used, provided they are also used during the procedure qualification.

- (2) Distance amplitude correction—The sensitivity level shall be adjusted to provide for attenuation loss throughout the range of sound path to be used either by distance amplitude correction curves, by electronic means, or by other means as described in the approved procedure.
- (3) Transfer correction—Instrument sensitivity shall be adjusted to compensate for differences between the calibration standard contact surface curvature and roughness, versus those of the material being examined. This may be determined by noting the difference between responses received from the same reference reflector (e.g., a second search unit acting as a reflector) in both situations, after correcting for distance as described above.

6.14.2.3 Reference may be made to the ultrasonic examination requirements of Clause 6 of AWS D1.1/D1.1M, for establishing procedures regarding ultrasonic instrumentation and calibration requirements.

6.14.3 Base Metal Examination. The entire area subject to ultrasonic scanning shall be examined by the longitudinal wave technique to detect laminar reflectors that could interfere with the intended, directed sound wave propagation. All areas containing laminar reflectors shall be marked for identification prior to weld examination. Welds in that area shall be examined using an alternate weld scanning procedure, if applicable. Base material discontinuities that exceed the limits of applicable base material specifications or other established requirements shall be brought to the attention of the Customer.

6.14.4 Weld Scanning. Scanning of normal groove welds shall be in accordance with the requirements of Figure 6.1, or as established in the approved procedure. Scanning of T-, Y-, and K-connections shall be performed from the attachment surface (see Figure 6.1), or as established in the approved procedure. All examinations shall be made in leg I and II where possible. For initial scanning, the sensitivity shall be increased by 12 dB above the ARL established in 6.14.2.2 at the maximum sound path. Indication evaluation shall be performed with reference to the standard sensitivity.

6.14.5 Optimum Angle. Indications found in the root areas of groove welds in butt joints, and along fusion faces of all welds, shall be further evaluated with a 70, 60, or 45 degree search unit angle, whichever is nearest to being perpendicular to the expected fusion face.

6.14.6 Discontinuity Evaluation. Discontinuities shall be evaluated using a combination of beam boundary and amplitude techniques. Sizes shall be given as length, and height (depth dimension) or amplitude, as applicable. Amplitude shall be related to “standard calibration.” In addition, discontinuities shall be classified as linear or planar, versus spherical, by noting changes in amplitude as the transducer is swung in an arc centered on the reflector. The location (position) of discontinuities within the weld cross-section, as well as from an established reference point along the weld axis, shall be determined. See Figure 6.2 for additional evaluation requirements.

6.14.7 Acceptance Criteria. Refer to 7.12.

6.14.8 Reporting

6.14.8.1 A report clearly defining the environment (depth, etc.) and identifying the part and the area of inspection shall be completed by the ultrasonic technician at the time of inspection. A detailed report including a sketch showing the location along the weld axis, location within the weld cross-section, size, extent, orientation, and classification for each discontinuity shall be completed for each weld in which significant indications are found. A recommended form is included in Annex A. Report forms shall be submitted to the Customer upon completion of the work.

6.14.8.2 When specified, discontinuities approaching rejectable size, particularly those about which there is some question in their evaluation, shall also be reported.

6.14.8.3 Areas of any part for which complete inspection was not practicable shall also be explained in the report.

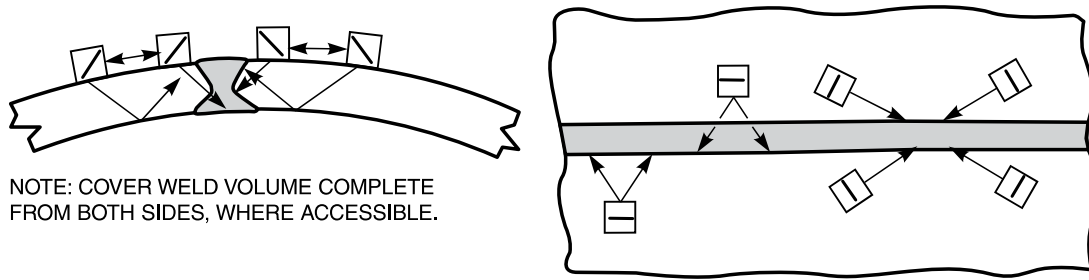
6.14.8.4 Unless otherwise specified, the reference position and the location and extent of rejectable flaws shall also be marked physically on the workpiece.

Part V

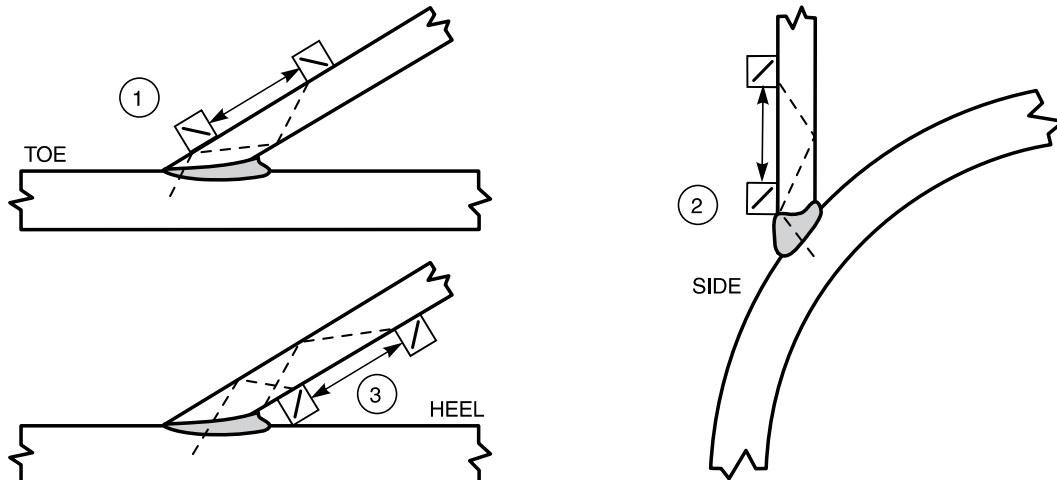
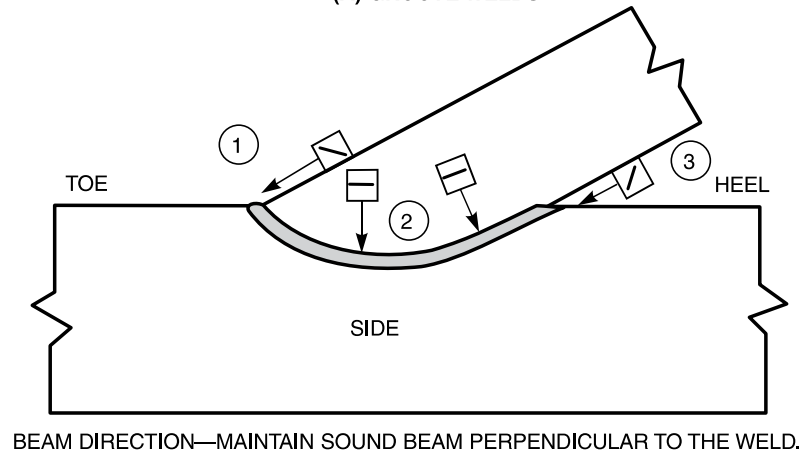
Magnetic Particle Examination

6.15 General

6.15.1 The procedure and standards described herein shall govern magnetic particle examination, when such an examination is required. This method is used for detecting linear discontinuities at or very near the surface of welds in magnetic materials.



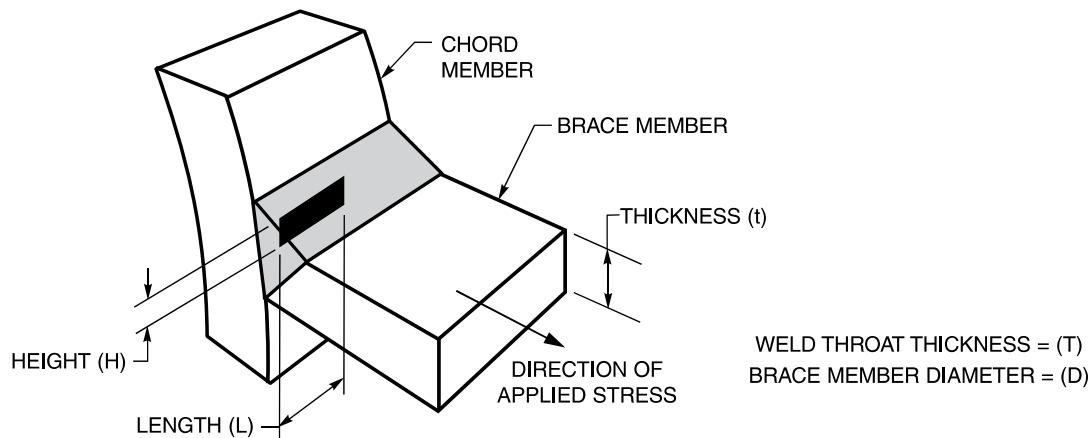
(A) GROOVE WELDS



V-PATHS—USE SINGLE AND MULTIPLE LEGS AND VARIOUS ANGLES, AS REQUIRED, TO COVER THE COMPLETE WELD INCLUDING THE ROOT AREA.

(B) T-, Y-, AND K-CONNECTIONS

Figure 6.1—Ultrasonic Scanning Techniques



Evaluation Requirements:

1. Use combination of beam boundary and amplitude.
2. Give size as length (L) and height (H).
3. Determine "class": Linear/Planar versus Spherical.
4. Length (L) and height (H) shall be based upon a rectangle that totally encloses the indicated discontinuity.
5. Aligned discontinuities separated by less than $(L_1 + L_2)/2$ and parallel discontinuities separated by less than $(H_1 + H_2)/2$ shall be evaluated as being continuous.
6. Accumulative flaws shall be evaluated over a 150 mm (6 in) or $D/2$ length of weld, whichever is less.
7. Root area shall be defined as that lying within 6 mm (1/4 in) or $T/4$, whichever is greater, of the root of the theoretical weld.
8. Record the position (location) of discontinuities within the weld cross section as well as from an established reference point along the weld axis.

Figure 6.2—Discontinuity Evaluation

6.15.2 Variations in the examination procedure, equipment, and acceptance criteria may be used with approval of the Customer. Such variations may include means used to magnetize the weld or to apply magnetic particles.

6.15.3 When magnetic particle examination is required, welds that do not meet the surface acceptance criteria of Part III in Clauses 7 through 9, as applicable for the class of welds inspected, shall be corrected in accordance with Clause 3. Light grinding may be employed to determine relevancy of indications.

6.16 Procedure

6.16.1 Technique. When magnetic particle examination is to be used in a wet or dry environment, the procedure and technique shall be in accordance with ASTM E 709 (Dry and Wet Powder).

6.16.2 Magnetization. Alternating current, direct current, or permanent magnets may be used to magnetize the weld. The magnetizing current or ampere turns used shall be specified in accordance with ASTM E 709. The examination procedure shall state whether the magnetizing current shall be maintained during the readout of indications.

6.16.3 Particles. The ferromagnetic particles shall be of a color contrasting to the surface. Fluorescent magnetic particles may be used with a black light.

6.16.4 Preparation and Disposition of Reports

6.16.4.1 A report clearly identifying the work and the area of examination shall be completed by the magnetic particle interpreter at the time of examination. Reports for acceptable welds need only contain sufficient information to identify the weld, the segment inspected, the interpreter (signature), examination variables, and the acceptability of the weld. When specified by the Customer, indication of defects shall be documented by photography. Reports shall be submitted to the Customer upon completion of the work.

6.16.4.2 Before a weld subject to magnetic particle examination is accepted, all reports pertaining to the weld, including any identifying unacceptable indications prior to repair, shall be submitted to and approved by the Customer. Approval of the reports by the Customer shall constitute acceptance of the weld.

Part VI

Eddy Current Examination

6.17 General

6.17.1 The procedure and standards described herein shall govern eddy current (electromagnetic test, or ET) examination when such examination is required. This method shall be used for detecting linear discontinuities at or very near the surface of welds in ferritic and austenitic materials.

6.17.2 Variation in the examination procedure, equipment, or acceptance criteria may be used with approval of the Customer.

6.17.3 When eddy current examination is required, welds or other materials which do not meet the surface acceptance criteria of Part III in Clauses 7 through 9, as applicable for the class of weld inspected, shall be corrected in accordance with Clause 3. Light grinding may be employed to determine relevancy of indications.

6.18 Procedure

6.18.1 Technique. When using ET examination in wet or dry environment, the procedure and technique shall be in accordance with ISO 9304 (ASTM E 309 or E 426). References in this code to ISO 9304, ASTM E 309, and E 426 which refer to tubular material, may also apply to nontubular materials.

6.18.2 Supplemental Examination. When indications of defects are found in magnetic materials using ET examination, those areas may also be examined with the magnetic particle method, in accordance with Part V of this clause, for purposes of verification.

6.18.3 Communications. During examinations in the wet or dry environment, communications between the probe manipulator and the interpreter (see 6.8.3) shall be continuous and clear in nature, utilizing a dedicated system.

6.18.4 Preparation and Disposition of Reports

6.18.4.1 A report clearly identifying the work and the area of examination shall be completed by the ET interpreter at the time of the examination. Reports for acceptable welds need only contain sufficient information to identify the weld, the segment inspected, the interpreter (signature), examination variables, and the acceptability of the weld. When specified by the Customer, indications of defects shall be documented by photography. Reports shall be submitted to the Customer upon completion of the work.

6.18.4.2 Before a weld subject to ET examination is accepted, all reports pertaining to the weld, including any identifying unacceptable indications prior to repair, shall be submitted to and approved by the Customer. Approval of the reports by the Customer shall constitute acceptance of the weld.

7. Class A Welds

7.1 Application. The requirements of this clause apply to Class A welds. Class A defines a set of requirements for underwater welds that are intended to be suitable for structural applications involving design stresses comparable to similar above-water applications. This class of weld will meet the Customer's requirements for a particular structure and shall satisfy the requirements of this code for Class A welds.

7.1.1 Welding procedure specifications for Class A welds shall be qualified in accordance with the general requirements of Clause 5, Parts I and II, and the specific requirements of Part I of this clause.

7.1.2 All welders, including tack welders, making Class A welds shall be qualified prior to production welding in accordance with the general requirements of Clause 5, Parts I and III, and with the specific requirements of Part II of this clause.

7.1.3 Minimum examination requirements for all Class A production welds and acceptance criteria for all inspection and examination of Class A welds, including that performed during procedure and performance qualification, are defined in Part III of this clause.

Part I Procedure Qualification

7.2 Testing Requirements. The number and type of test specimens required for procedure qualification to test the first position and additional positions for Class A welds are summarized in Table 7.1. The specimen type and welding position shall be specified by the Customer. Position of welding may have a significant effect on the properties of the weld, and the Customer should take this into consideration in design and in selection of the first and other positions during procedure qualification.

7.3 Groove Welds

7.3.1 Test Specimens. Test specimens for Class A groove welds shall be located in accordance with Figures 7.1 and 7.2. All-weld-metal specimens shall be prepared and located in accordance with 5.11.4 and Figures 5.13 and 5.14. As an option, the length of the procedure qualification test assembly (Figure 7.1) may be increased, and the all-weld-metal tension specimen may be removed from the procedure qualification test assembly.

7.3.2 Test Results. Procedure qualification test results for Class A groove welds shall meet the following requirements:

7.3.2.1 Visual Examination. The welds shall meet the visual acceptance criteria of 7.9.

7.3.2.2 Radiographic Examination. The welds shall meet the acceptance criteria of 7.10.1.

7.3.2.3 Reduced-Section Tension Test. The tensile strength shall equal or exceed the specified minimum tensile strength of the base metal for each sample.

7.3.2.4 All-Weld-Metal Tension Tests. The yield strength and tensile strength shall exceed the minimums specified for the base metal. The minimum acceptable elongation shall be dependent on the base metal-specified minimum yield strength as indicated in Table 7.2.

7.3.2.5 Bend Tests. The bending fixture shall conform to Figure 5.12 of Clause 5, Part II. Bend radius (B) for testing shall be in accordance with Table 7.2. Four samples shall be tested, and they shall not reveal tears or other defects exceeding 3 mm (1/8 in) in the weld metal or fusion zone after bending. Tears which originate at the corner of the specimen and are less than 6 mm (1/4 in) long shall not be cause for rejection unless they are associated with a defect.

Table 7.1
Weld Procedure Qualification—Number and Type of Test Specimens for Class A Welds^a

Coupon	Joint Type	Thickness Tested mm (in)	Visual (See 6.10)	Radio-graphed (See 6.12) ^c	Reduced Section Tension (See 5.11.1)	Fillet Weld Shear (See 5.11.8)	All-Weld-Metal Tension (See 5.11.4)	Bends ^b (See 5.11.3)		Macroetch Test (See 5.11.2)	Vickers Hardness (See 5.11.6) ^d	Charpy Impact (See 5.11.5) ^d	Fillet Weld Break (See 5.11.7)
								Root and Face	Side				
Plate	Groove	T ≤ 10 (3/8)	Yes	Yes	2	0	1	2 each	0	1	1	WM and HAZ	0
		10 (3/8) < T < 20 (3/4)	Yes	Yes	2	0	1	2 each or 0	4	1	1	WM and HAZ	0
		T ≥ 20 (3/4)	Yes	Yes	2	0	1	0	4	1	1	WM and HAZ	0
Pipe	Groove	T ≤ 10 (3/8)	Yes	Yes	2	0	1	2 each	0	1	1	WM and HAZ	0
		10 (3/8) < T < 20 (3/4)	Yes	Yes	2	0	1	2 each or 0	4	1	1	WM and HAZ	0
		T ≥ 20 (3/4)	Yes	Yes	2	0	1	0	4	1	1	WM and HAZ	0
Plate	Fillet	All ^e	Yes	No	0	1	1	0	0	2 ^f	1	WM	1 ^f
Pipe	Fillet	All ^e	Yes	No	0	1	1	0	0	4 ^f	1	WM	4 ^f

^a First position only. Qualification for additional positions will omit groove weld tension, macroetch, hardness, Charpy tests, fillet weld shear strength tests, and all-weld-metal tension tests. Whenever qualification is required for vertical-up welding, that position/coupon shall be the one from which impacts are taken.

^b For plate or pipe between 10 mm (3/8 in) and 20 mm (3/4 in) thick, the Customer may specify either two root and two face bend tests or four side bend tests.

^c Groove welds only are radiographed.

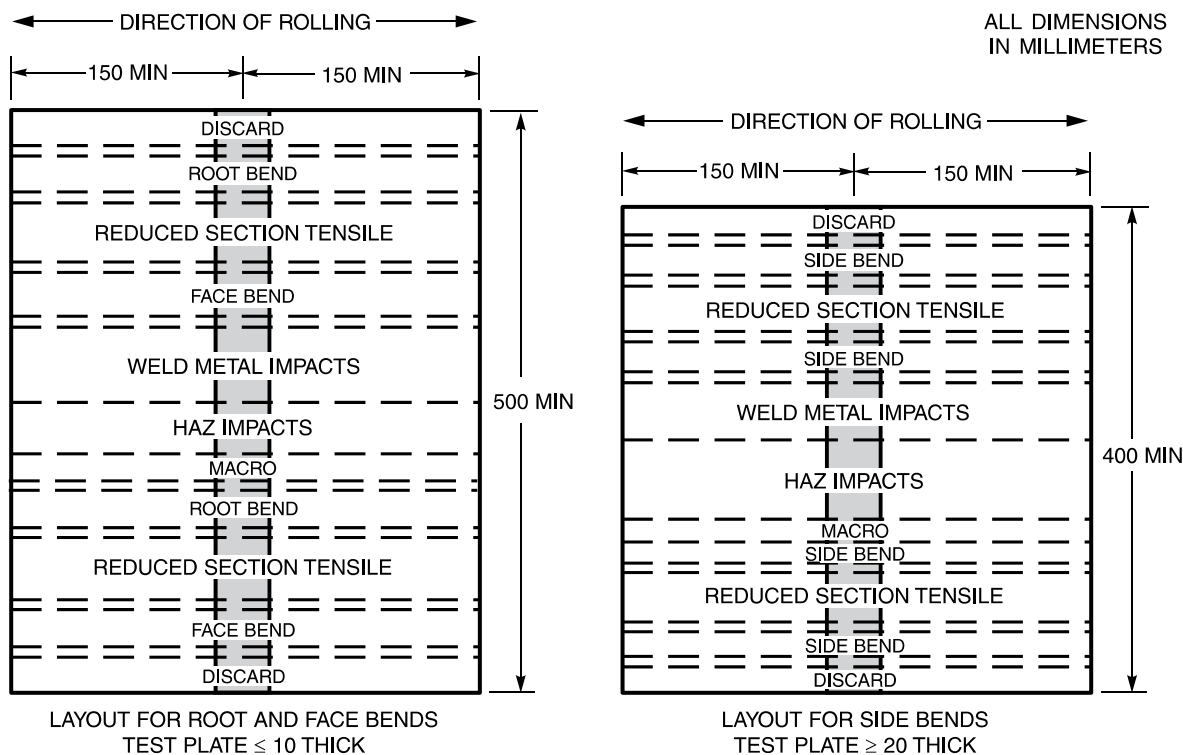
^d Vickers Hardness and Charpy impact tests not applicable for austenitic stainless steel base metals.

^e Multiple pass fillet welds are considered qualified by groove weld qualification. (5.9.2).

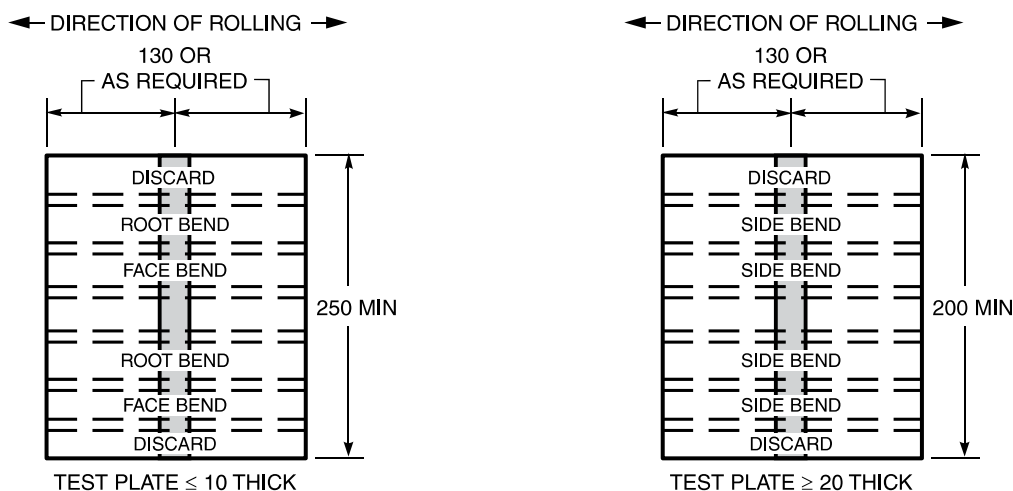
^f For single pass welds the qualification weld size shall be the maximum size to be performed in production. For multipass welds, the qualification weld size shall be the minimum size to be welded in production.

Note:

1. WM = Weld Metal; HAZ = Heat-Affected-Zone.



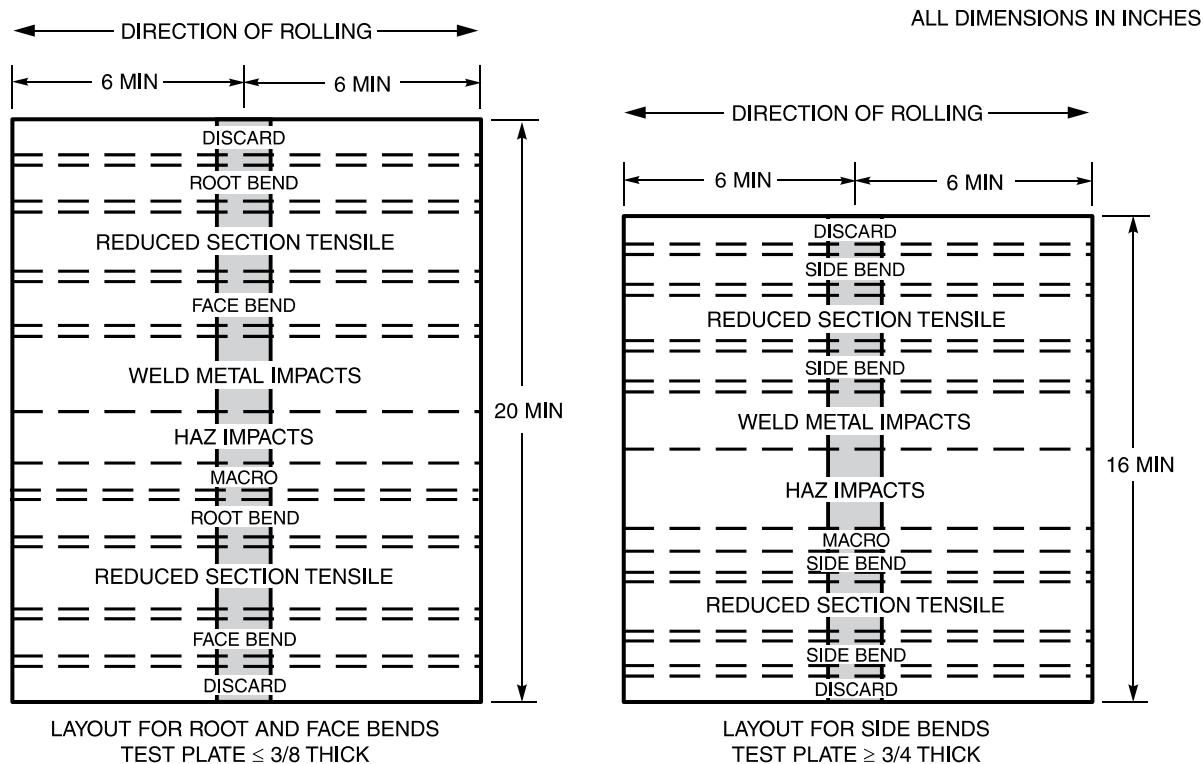
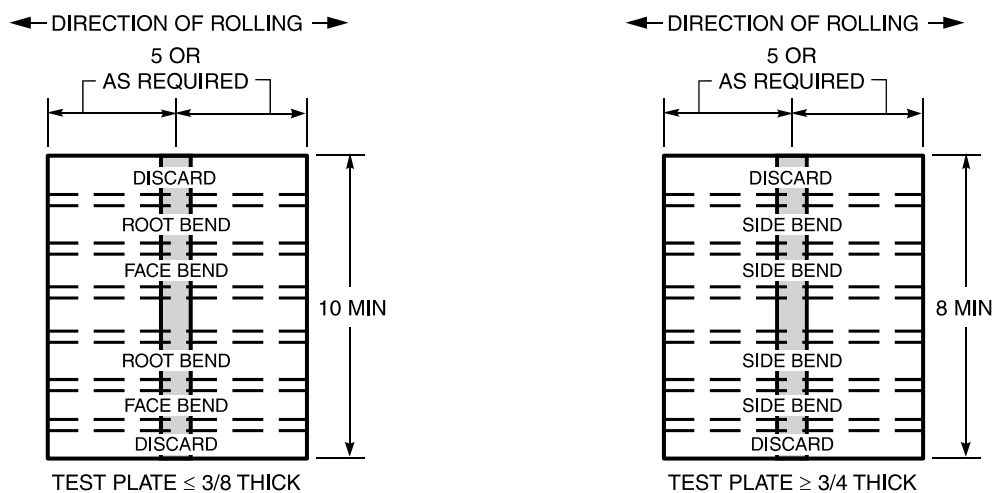
(A) FIRST POSITION PLATES



(B) ADDITIONAL POSITION PLATES

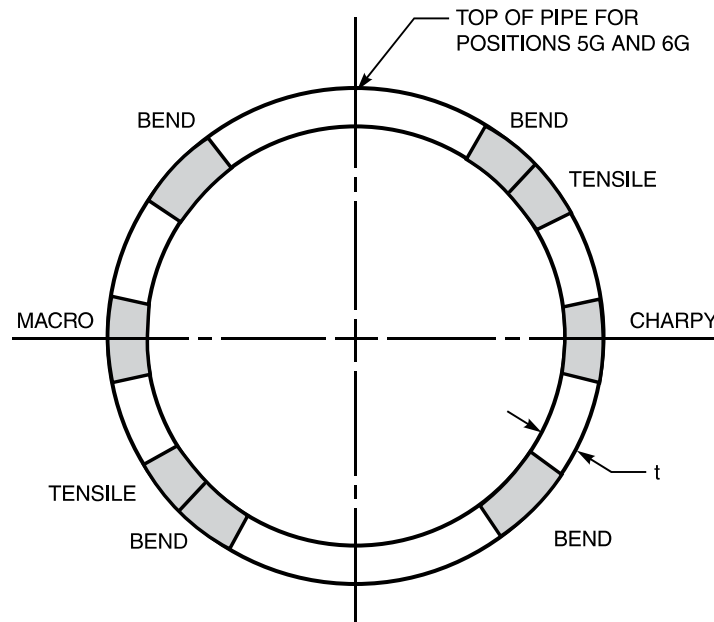
Note: As an option, the length of the test plate may be increased to provide for the all-weld-metal tensile test specimen in accordance with 7.3.1 when the plate thickness is ≥ 20 mm. For plates between 10 and 20 mm, customer may specify root and face bends or side bends for first and additional position plates.

Figure 7.1—Location and Type of Test Specimens on Welded Plate Test Procedure Qualification Assembly, Class A Groove Welds

**(A) FIRST POSITION PLATES****(B) ADDITIONAL POSITION PLATES**

Note: As an option, the length of the test plate may be increased to provide for the all-weld-metal tensile test specimen in accordance with 7.3.1 when the plate thickness is $\geq 3/4$ in. For plates between $3/8$ and $3/4$ in, customer may specify root and face bends or side bends for first and additional position plates.

Figure 7.1A—Location and Type of Test Specimens on Welded Plate Test Procedure Qualification Assembly, Class A Groove Welds (U.S. Customary Units)



Notes:

1. If the pipe diameter is too small to permit all specimens to be machined from a single weld, additional welds shall be made to provide sufficient material for test.
2. First position weld, test all specimens shown. Additional position welds, test bend specimens only.
 - a. $t \leq 10$ mm (3/8 in)—Two root and two face bends.
 - b. $t \leq 20$ mm (3/4 in)—Four side bends.
 - c. t between 10 mm (3/8 in) and 20 mm (3/4 in), customer may specify root and face or side bends.
 - d. Specimen geometry as described in Figures 5.7, 5.10, and 5.11.

Figure 7.2—Location and Types of Test Specimens on Welded Pipe Test Procedure Qualification Assembly, Class A Groove Welds in Pipe

7.3.2.6 Macroetch. Macroetch test specimens shall reveal no cracks at 5 × magnification and shall meet the requirements of 7.10. Microhardness measurements shall not exceed 325 HV 10 (see 5.11.6).

7.3.2.7 Charpy Impact Test. The average and minimum Charpy energy values of the three specimens shall satisfy the requirements of Table 7.2B when tested at a minimum design service temperature (see 5.11.5) unless other requirements are specified by the Customer.

7.4 Fillet Welds

7.4.1 Test Specimens. A groove weld for the all-weld-metal tension specimen and Charpy V-notch impact specimens shall be produced in accordance with 5.11.4 and 5.11.5. Fillet weld shear specimens shall be produced in accordance with the requirements of 5.11.8 (refer to Figures 5.16 or 5.17 for plate qualification and Figure 5.18 for pipe qualification). Fillet weld break test coupons shall be produced in accordance with the requirements of 5.11.7 (refer to Figure 5.8 for plate and pipe qualification). As an option, the Contractor may choose to qualify a multiple-pass fillet weld procedure on the basis of a groove weld qualification in accordance with the requirements of 5.9.2.

7.4.2 Test Results. Procedure qualification test results for Class A fillet welds shall meet the following requirements:

7.4.2.1 Visual Examination. All test welds shall meet the visual acceptance criteria of 7.9.

7.4.2.2 Radiographic Examination. The groove weld for the all-weld-metal tension and Charpy V-notch impact specimens shall meet the acceptance criteria of 7.10.1.

7.4.2.3 Fillet-Weld-Shear-Strength Test. The minimum acceptable shear strength of the weld shall be 60 percent of the minimum tensile strength of the weld metal measured in the all-weld-metal tension test.

Table 7.2
Weld Procedure Qualification—Mechanical Test Acceptance Criteria for Class A Welds

A. Tensile and Bend Test Acceptance Criteria ^a			
Base Metal Minimum Specified Yield Strength	All-Weld-Metal Tensile/Minimum Percent Elongation		Bend Specimen
	GL/D = 5 ^b (Figure 5.14)	GL/D = 4 ^b (Figure 5.14A)	Maximum Bend Test Bend Radius ^{c, d}
350 MPa (50 ksi) and below	18	20	2T
Over 350 MPa to but not including 600 MPa	14	16	2–2/3 T
600 MPa and Over (90 ksi)	As specified by Customer	As specified by Customer	3–1/3 T
B. Charpy V-Notch and Microhardness Acceptance Criteria ^e			
Base Metal Minimum Specified Tensile Strength	Weld-Metal and HAZ/Charpy V-Notch		Maximum
	Average Energy	Minimum Energy	Macro-Hardness
485 MPa (70 ksi) and below	26 J (15 ft-lb)	14 J (10 ft-lb)	325 HV 10
Over 485 MPa to 550 MPa	27 J (20 ft-lb)	19 J (14 ft-lb)	325 HV 10
Over 550 MPa (80 ksi)	34 J (25 ft-lb)	23 J (17 ft-lb)	325 HV 10

^a Values apply to carbon, low alloy, and austenitic stainless steel.

^b GL = Gage Length; D = Machined Diameter.

^c T is the specimen thickness, i.e., 10 mm (3/8 in) for side bends.

^d Use 2T for all grades of austenitic stainless steel.

^e Vickers hardness and Charpy impact test not applicable for austenitic stainless steel base metals.

7.4.2.4 All-Weld-Metal Tension Test. The test specimen machined from the groove weld, as described in 5.11.4, shall be tested in accordance with ISO 6892 or ASTM A 370. The yield strength and tensile strength shall exceed the minimum values specified for the base metal. The minimum elongation shall meet the requirements of Table 7.2.

7.4.2.5 Fillet-Weld-Break Test. The specimen shall pass if it bends flat upon itself. If the fillet weld fractures, it shall show fusion to the root of the joint but not necessarily beyond. The fracture surface shall exhibit no inclusion or porosity greater than 2.5 mm (3/32 in) in the greatest dimension. The sum of the greatest dimensions of all inclusions and porosity shall not exceed 10 mm (3/8 in) in any 150 mm (6 in) of weld.

7.4.2.6 Macroetch. Macroetch test specimens shall reveal no cracks at 5 × magnification and shall meet the requirements of 7.10.2. Hardness tests on the surfaces shall not exceed 325 HV 10 (see 5.11.6).

7.4.2.7 Charpy Impact Test. Charpy impact test specimens, as described in 5.11.5, shall be prepared and tested. They shall meet the impact requirements for Class A welds listed in 7.3.2.7.

Part II

Welder Qualification

7.5 Testing Requirements. The number and type of test specimens required for welder qualification for Class A welds are summarized in Table 7.3.

7.6 Groove Welds

7.6.1 Test Specimens. Test specimens for welder qualification shall be prepared and located in accordance with Figure 7.3 for groove welds, and Figures 7.4 for T-, Y-, and K-connections on pipe or tubing. Four bend specimens shall be removed from each weld coupon. In lieu of radiographic or ultrasonic inspection, three macroetch test specimens may be removed from the weld adjacent to the required bend specimens; such specimens shall be prepared and etched in accordance with 5.11.2 and shall meet the requirements of 7.6.

7.6.2 Test Results. Welder qualification test results for Class A groove welds shall meet the following requirements as applicable:

7.6.2.1 Visual Examination. The welds shall meet the visual acceptance criteria of 7.9.

Table 7.3
Welder Performance Qualification—Number and Type of Test Specimens for Class A Welds (Per Welder)

A. Tensile and Bend Test Acceptance Criteria ^a			
Base Metal Minimum Specified Yield Strength	All-Weld-Metal Tensile/Minimum Percent Elongation		Bend Specimen
	GL/D = 5 ^b (Figure 5.14)	GL/D = 4 ^b (Figure 5.14A)	Maximum Bend Test Bend Radius ^{c,d}
350 MPa (50 ksi) and below	18	20	2 T
Over 350 MPa to but not including 600 MPa	14	16	2–2/3 T
600 MPa and Overs (90 ksi)	As specified by Customer	As specified by Customer	3–1/3 T
B. Charpy V-Notch and Microhardness Acceptance Criteria ^e			
Maximum Minimum Specified Tensile Strength	Weld-Metal and HAZ/Charpy V-Notch		Base Metal
	Average Energy	Minimum Energy	Macro-Hardness
485 MPa (70 ksi) and below	20 J (15 ft-lb)	14 J (10 ft-lb)	325 HV 10
Over 485 MPa to 550 MPa	27 J (20 ft-lb)	19 J (14 ft-lb)	325 HV 10
Over 550 MPa (80 ksi)	34 J (25 ft-lb)	23 J (17 ft-lb)	325 HV 10

^a Values apply to carbon, low alloy, and austenitic stainless steel.

^b GL = Gage Length; D = Machined Diameter.

^c T is the specimen thickness, i.e., 10 mm (3/8 in) for side bends.

^d Use 2T for all grades of austenitic stainless steel.

^e Vickers hardness and Charpy impact test not applicable for austenitic stainless steel base metals.

7.6.2.2 Radiographic or Macroetch. The welds shall meet the acceptance criteria of 7.10.

7.6.2.3 Ultrasonic Examination. The welds shall meet the acceptance criteria of 7.12.

7.6.2.4 Bend Tests. The bending fixture shall conform to Figure 5.12 of Clause 5, Part II, with the bend radius as specified in 7.3.2.5. Four samples shall be tested, and they shall not reveal cracks or other defects exceeding 3 mm (1/8 in) in the weld metal or fusion zone after bending. Cracks which originate at the corner of the specimen and are less than 6 mm (1/4 in) long shall not be cause for rejection unless they are associated with a defect.

7.7 Fillet Welds

7.7.1 Test Specimen. The welder shall weld fillet-weld break and macroetch test assemblies as shown in Figure 5.8 in accordance with the requirements of variables and positions of 5.16 and Table 5.5. The number and type of specimens required to qualify from each assembly are shown in Table 7.3.

7.7.2 Test Results. Welder qualification test results for Class A fillet welds shall meet the following requirements:

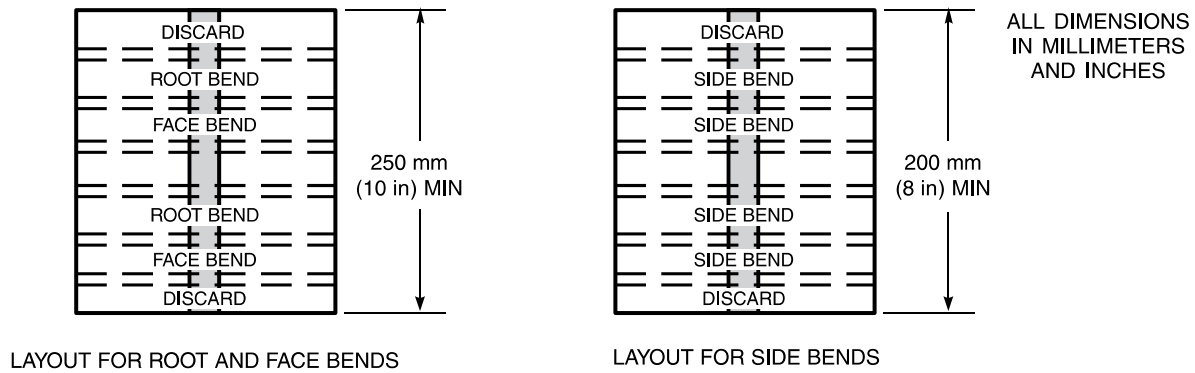
7.7.2.1 Visual Examination. All test welds shall meet the visual acceptance criteria of 7.9.

7.7.2.2 Macroetch. Macroetch test specimens shall reveal no cracks at 5 × magnification and shall meet the acceptance criteria of 7.10.2.

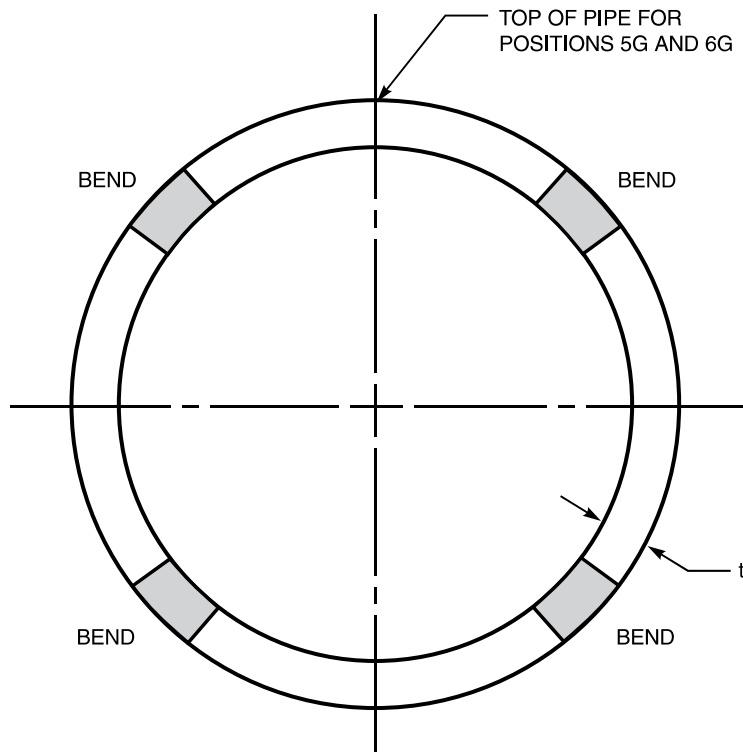
7.7.2.3 Fillet-Weld-Break Test. The specimen shall pass if it bends flat upon itself. If the fillet weld fractures, it shall show fusion to the root of the joint but not necessarily beyond. The fracture surface shall exhibit no inclusion or porosity greater than 2.5 mm (3/32 in) in the greatest dimension. The sum of the greatest dimensions of all inclusions and porosity shall not exceed 10 mm (3/8 in) in any 150 mm (6 in) of weld.

Part III Examination

7.8 Examination Requirements. All Class A production welds shall be visually examined in accordance with Clause 6, Part II. In addition, unless otherwise specified by the Customer, complete joint-penetration welds shall be either



(A) FOR PLATE



(B) FOR PIPE

Note: For plates between 10 mm (3/8 in) and 20 mm (3/4 in) thick, Customer may specify root and face bends or side bends (for pipe).

- $t \geq 10$ mm (3/8 in)—Two root and two face bends.
- $t \leq 20$ mm (3/4 in)—Four side bends.
- t between 10 mm (3/8 in) and 20 mm (3/4 in), customer may specify root and face or side bends.
- Specimen geometry as described in Figures 5.10 and 5.11.

Figure 7.3—Type and Location of Bend Test Specimens for Welder Qualification, Class A Groove Welds

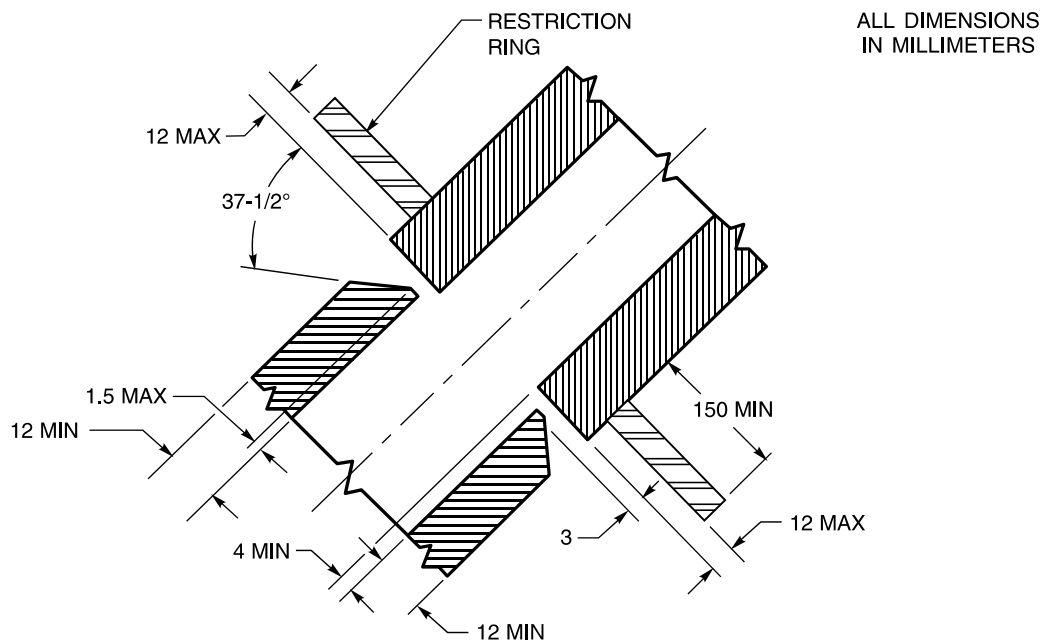


Figure 7.4—Test Assembly for T-, Y-, and K-Connections on Pipe or Square or Rectangular Tubing—Welding Procedure and Welder Performance Qualification, Class A Welds

radiographed (Clause 6, Part III) or ultrasonically examined (Clause 6, Part IV); partial penetration and fillet welds shall be examined by the magnetic particle method (Clause 6, Part V). Acceptance criteria shall be in accordance with the following.

7.9 Visual Acceptance Criteria. The following acceptance criteria, in accordance with the procedures and standards of Clause 6, Part II, shall apply to all **Class A** welds, during visual examination for surface defects:

- (1) The weld shall have no cracks, surface porosity, or entrapped slag as identified by the unaided eye.
- (2) Complete fusion shall exist between adjacent weld beads, and between weld metal and base metal.
- (3) All craters shall be filled.
- (4) Weld profiles shall be in accordance with Figure 7.5(A), (B), or (D).
- (5) Undercut shall be restricted for base metals of thickness t as follows:
 - (a) $t > 25$ mm (1 in): Undercut shall not exceed 1.5 mm (1/16 in) in depth, and the length of any undercut is not restricted.
 - (b) 6 mm (1/4 in) $\leq t \leq 25$ mm (1 in): Undercut shall not exceed 0.8 mm (1/32 in) in depth, and the length of any undercut exceeding 0.4 mm (1/64 in) in depth shall not exceed 50 mm (2 in) in length in any continuous 300 mm (12 in) of weld.
 - (c) $t < 6$ mm (1/4 in): Undercut shall not exceed 0.4 mm (1/64 in) in depth, and the length of any undercut shall not be restricted.
- (6) The root surface of single-welded groove welds without backing that require complete joint penetration shall be inspected, where accessible, and there shall be no incomplete fusion or incomplete joint penetration.
- (7) The maximum root surface underfill shall be 1.5 mm (1/16 in), and the maximum melt-through shall be 3 mm (1/8 in). The weld thickness shall be equal to or greater than that of the base metal.

7.10 Radiographic and Macroetch Test Acceptance Criteria

7.10.1 Radiographic Acceptance Criteria. The following acceptance criteria for Class A production and qualification welds, as applicable, shall be satisfied:

ALL DIMENSIONS IN INCHES

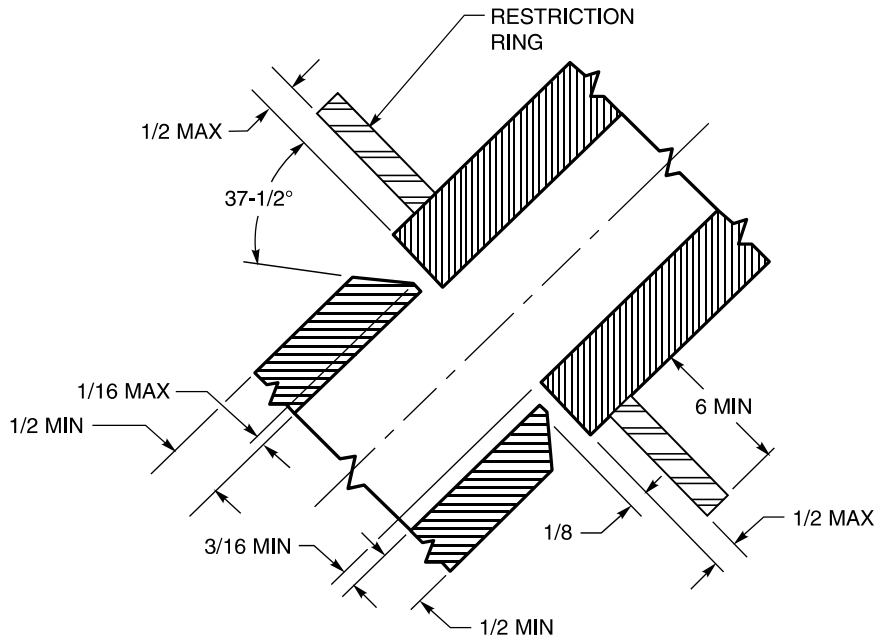
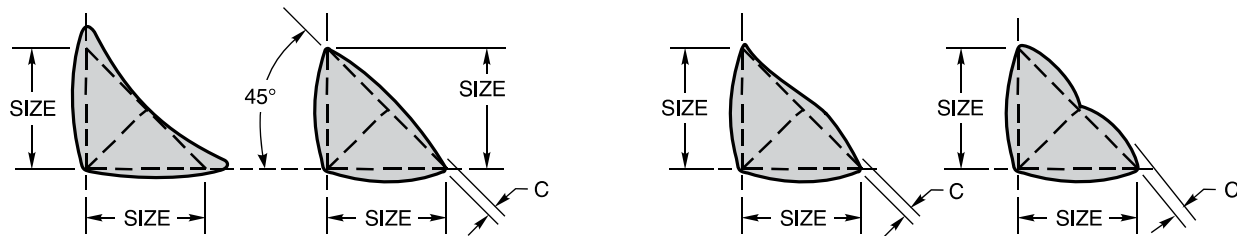


Figure 7.4A—Test Assembly for T-, Y-, and K-Connections on Pipe or Square or Rectangular Tubing—Welding Procedure and Welder Performance Qualification, Class A Welds (U.S. Customary Units)

- (1) The welds shall be free of cracks.
- (2) If the base metal thickness t is 6 mm (1/4 in) or less, the greatest dimension of any individual discontinuity shall be less than 3 mm (1/8 in). If t is more than 6 mm (1/4 in) but less than or equal to 30 mm (1-3/32 in), the greatest dimension of any individual discontinuity shall not exceed two-thirds of the effective throat or two-thirds of the weld size. If t is greater than 30 mm (1-3/32 in), the greatest dimension of any discontinuity shall not exceed 20 mm (3/4 in).
- (3) No discontinuity shall be closer than three times its greatest dimension to the end of a groove weld subject to primary tensile stress.
- (4) For a group of discontinuities in line, the sum of the greatest dimensions of all discontinuities in any portion of the weld equal in length to six times the effective throat or weld size, shall be less than the effective throat or weld size. When the length of the weld being examined is less than six times the effective throat or weld size, the permissible sum of the greatest dimensions shall be directly proportionate (i.e., $1/6 \times$ effective throat or weld size).
- (5) The space between two adjacent linear discontinuities shall be at least three times the greatest dimension of the larger of the discontinuities in the pair being considered.
- (6) Independent of the requirements of 7.10.1(2) through 7.10.1(5), the sum of the greatest dimensions of all discontinuities with a greatest dimension of less than 3 mm (1/8 in) shall not exceed 10 mm (3/8 in) in any continuous 25 mm (1 in) of weld.

7.10.2 Macroetch Test Acceptance Criteria. Weld shall be free of cracks. Slag, porosity, or other defects exceeding 1.5 mm (1/16 in) or 10% of the throat thickness in height or width shall be cause for rejection. However, linear indications associated with the root of partial penetration joints and groove welds with backing bars are acceptable, provided such linear indications do not exceed 1.0 mm (1/32 in), and provided such adjacent linear indications are separated by at least 3 mm (1/8 in).

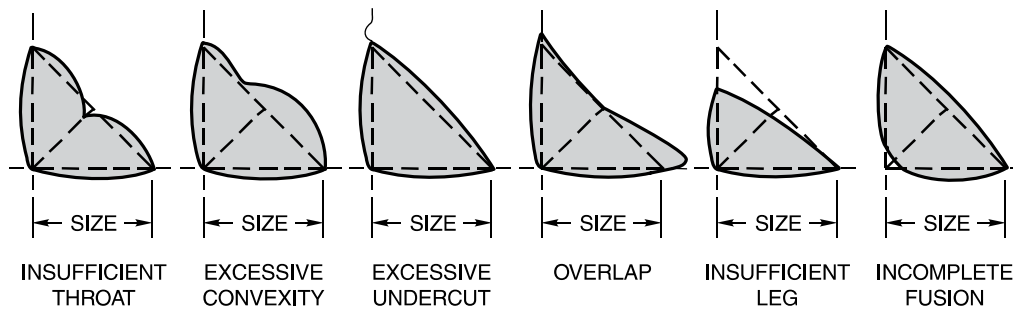
7.11 Surface Examination Acceptance Criteria. The acceptance criteria of 7.9 and 7.10 shall apply to nondestructive surface examination (magnetic particle, liquid penetrant, or eddy current) performed on Class A welds.



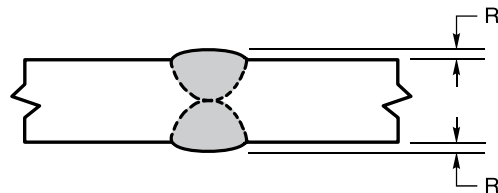
NOTE: CONVEXITY C SHALL NOT EXCEED 0.1 TIMES ACTUAL LEG SIZE, OR THE LONGER LEG IN THE CASE OF AN UNEQUAL LEG FILLET WELD, PLUS 1.5 mm (1/16 in).

(A) DESIRABLE FILLET WELD PROFILES

(B) ACCEPTABLE FILLET WELD PROFILES

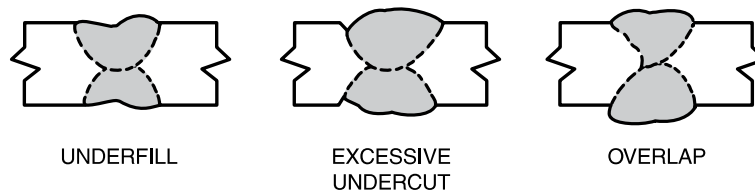


(C) UNACCEPTABLE FILLET WELD PROFILES



NOTE: REINFORCEMENT R SHALL NOT EXCEED 3 mm (1/8 in)

(D) ACCEPTABLE GROOVE WELD PROFILE



(E) UNACCEPTABLE GROOVE WELD PROFILES

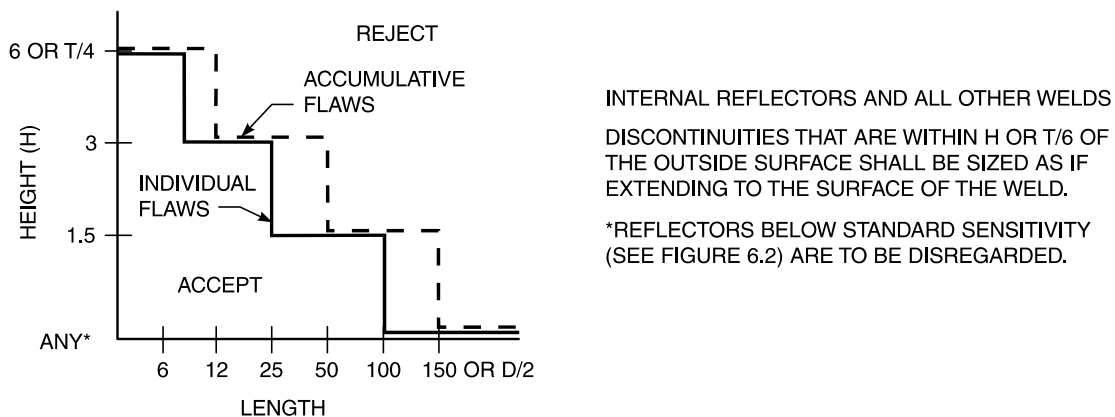
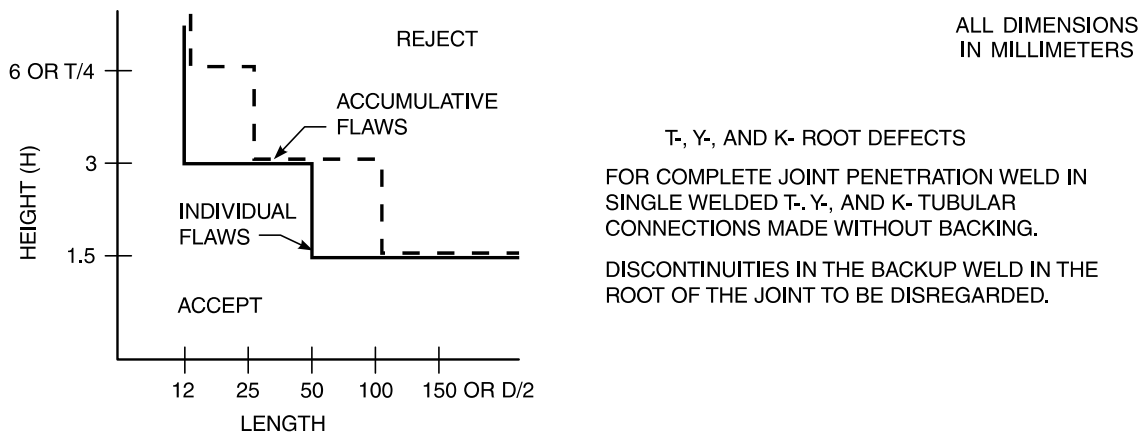
Figure 7.5—Acceptable and Unacceptable Weld Profiles for Class A Welds

7.12 Ultrasonic Examination Acceptance Criteria. The Customer shall designate the Class, X or R, which applies to all welds to be examined.

7.12.1 Disregard all DRL (Disregard Level) indications having half (6 dB) or less amplitude compared to the standard sensitivity level (with due regard for 6.14.6).

7.12.2 Indications exceeding the DRL shall be evaluated as follows:

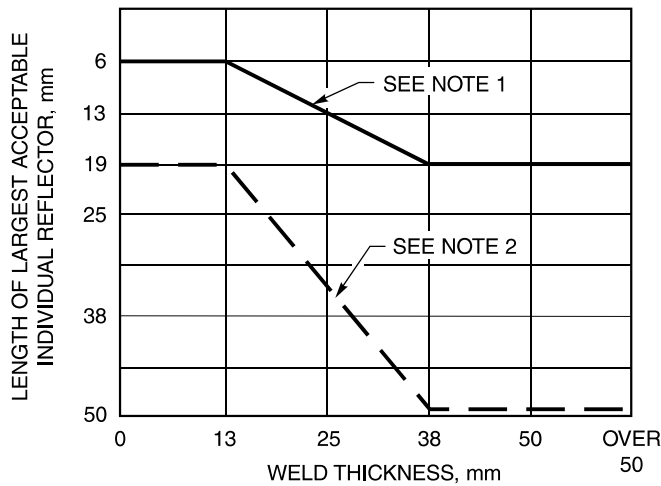
- (1) Class X (applicable to T-, Y-, and K-connections in redundant structures of notch-tough steels)
 - (a) Spherical reflectors shall be evaluated as described in Class R, except that any indications within the limits of Figure 7.6 for linear or planar reflectors shall be acceptable.
 - (b) Linear or planar reflectors shall be evaluated using beam boundary techniques, and those that have dimensions exceeding the limits of Figure 7.6 shall be retested. Discontinuities in the backup weld¹⁰ shall be disregarded.
- (2) Class R (applicable when UT is used as an alternative to radiography and for T-, Y-, and K-connections of steels without controlled notch toughness and with nonredundant design)
 - (a) Isolated, random spherical reflectors, with 25 mm (1 in) minimum separation, shall be accepted up to the standard sensitivity level. Larger reflectors shall be evaluated as linear or planar.
 - (b) Aligned spherical reflectors shall be evaluated as linear reflectors.
 - (c) Clustered spherical reflectors having a density of more than one per 650 mm² (one per square inch) with indications above the disregard level [projected area normal to the direction of applied stress, averaged over a 150 mm (6 in) length of weld] shall be rejected.
 - (d) Linear or planar reflectors, whose lengths (extent) exceed the limits of Figure 7.6 or 7.9 shall be rejected.



(A) CLASS X INDICATIONS

Figure 7.6—Ultrasonic Inspection Acceptance Criteria

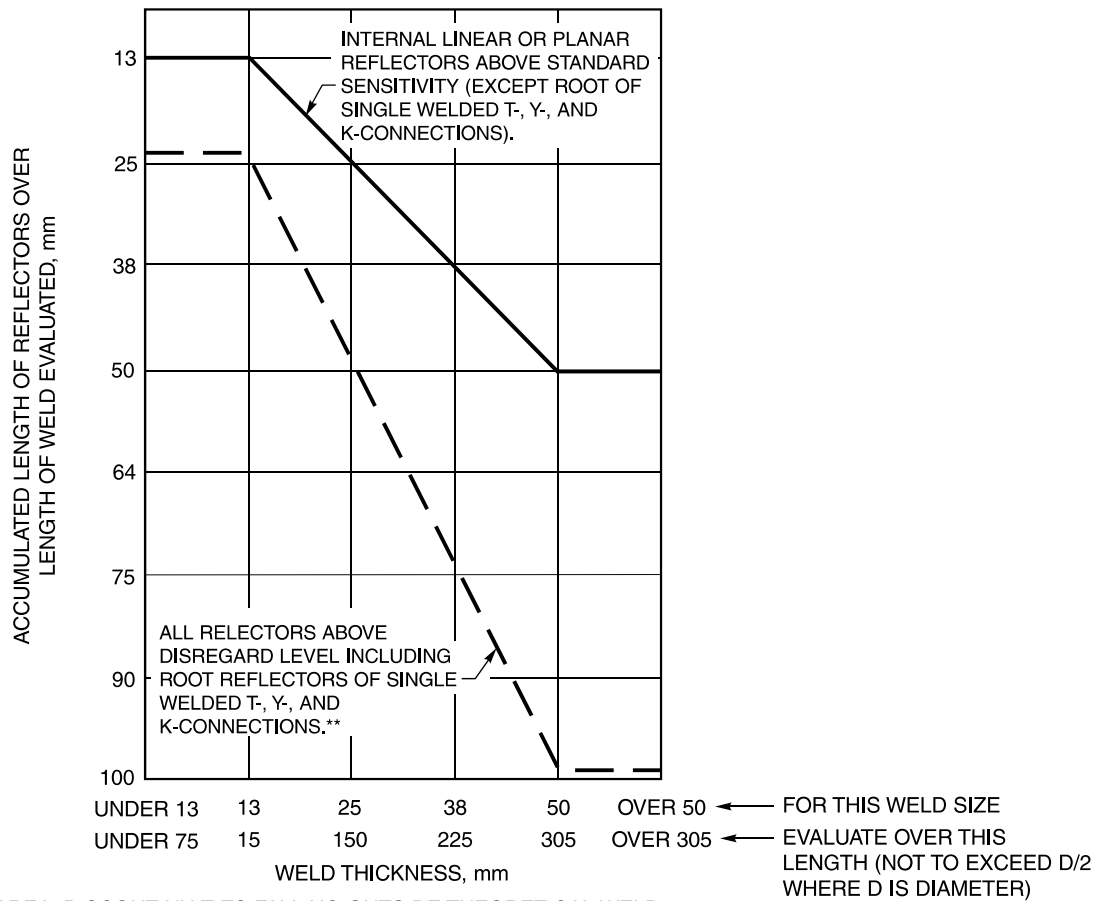
¹⁰ As defined for tubular T-, Y-, and K-connections in AWS D1.1.



ALL DIMENSIONS
IN MILLIMETERS

NOTES:

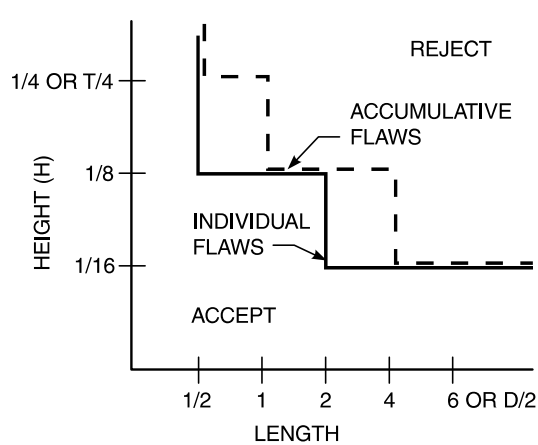
1. INTERNAL LINEAR OR PLANAR REFLECTORS ABOVE STANDARD SENSITIVITY (EXCEPT ROOT OF SINGLE WELDED T-, Y-, AND K-CONNECTIONS).
 2. MINOR REFLECTORS* (ABOVE DISREGARD LEVEL UP TO AND INCLUDING STANDARD SENSITIVITY).
- *ADJACENT REFLECTORS SEPARATED BY LESS THAN THEIR AVERAGE LENGTH SHALL BE TREATED AS CONTINUOUS.



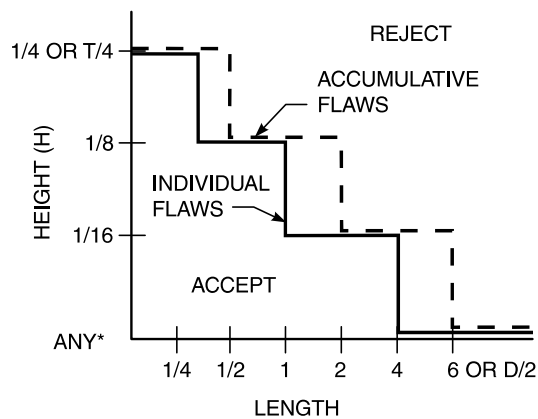
**ROOT AREA DISCONTINUITIES FALLING OUTSIDE THEORETICAL WELD

(B) CLASS R INDICATIONS

Figure 7.6 (Continued)—Ultrasonic Inspection Acceptance Criteria



T-, Y-, AND K- ROOT DEFECTS
FOR COMPLETE JOINT PENETRATION WELD IN
SINGLE WELDED T-, Y-, AND K- TUBULAR
CONNECTIONS MADE WITHOUT BACKING.
DISCONTINUITIES IN THE BACKUP WELD IN THE
ROOT OF THE JOINT TO BE DISREGARDED.



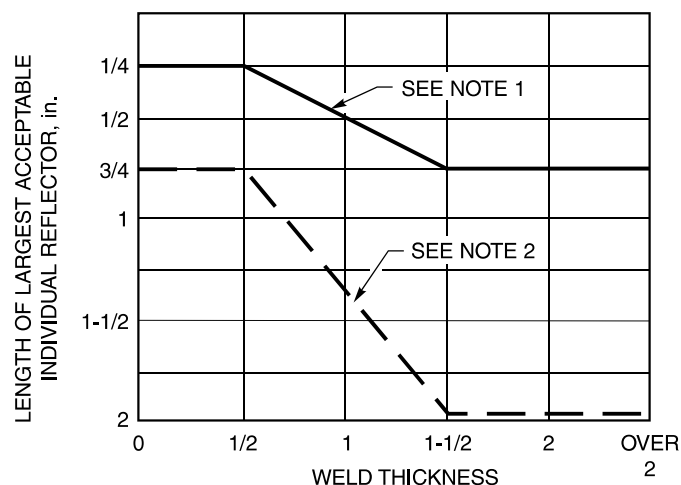
INTERNAL REFLECTORS AND ALL OTHER WELDS
DISCONTINUITIES THAT ARE WITHIN H OR T/6 OF
THE OUTSIDE SURFACE SHALL BE SIZED AS IF
EXTENDING TO THE SURFACE OF THE WELD.

*REFLECTORS BELOW STANDARD SENSITIVITY
(SEE FIGURE 6.2) ARE TO BE DISREGARDED.

(A) CLASS X INDICATIONS

Figure 7.6A—Ultrasonic Inspection Acceptance Criteria (U.S. Customary Units)

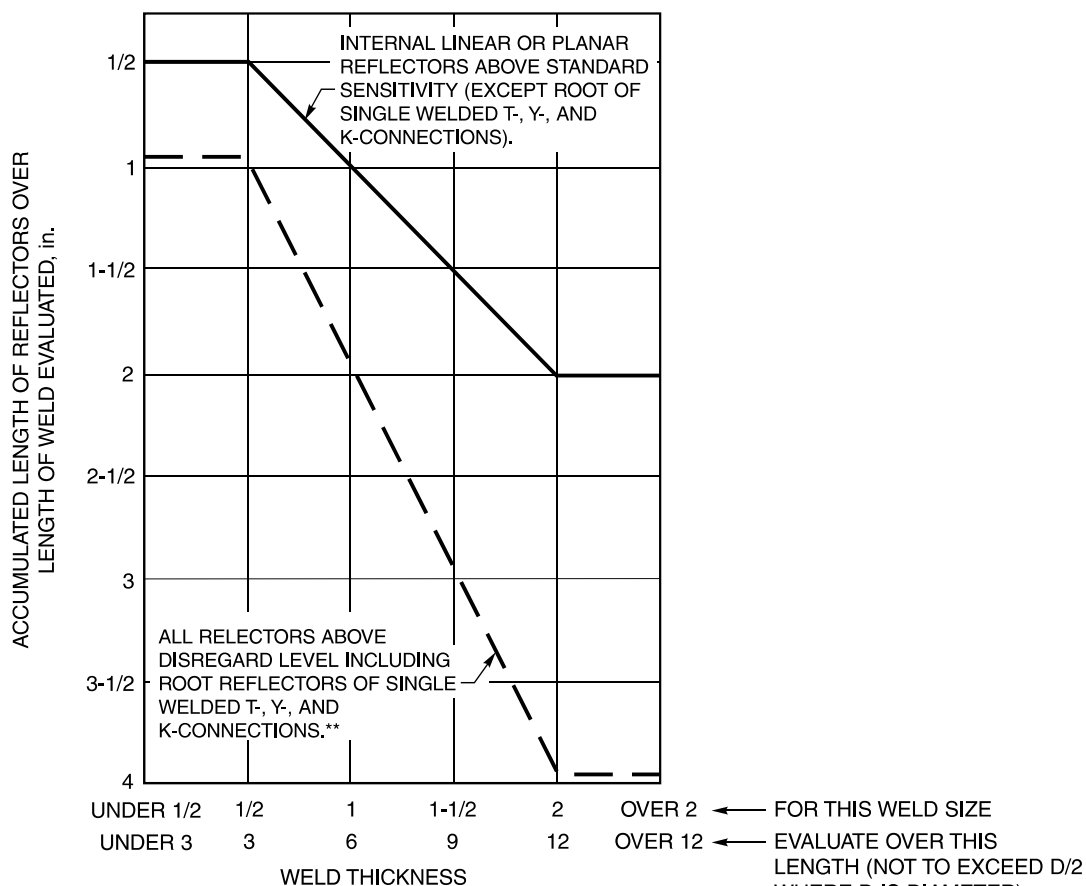
ALL DIMENSIONS IN INCHES



NOTES:

1. INTERNAL LINEAR OR PLANAR REFLECTORS ABOVE STANDARD SENSITIVITY (EXCEPT ROOT OF SINGLE WELDED T-, Y-, AND K-CONNECTIONS).
2. MINOR REFLECTORS* (ABOVE DISREGARD LEVEL UP TO AND INCLUDING STANDARD SENSITIVITY).

*ADJACENT REFLECTORS SEPARATED BY LESS THAN THEIR AVERAGE LENGTH SHALL BE TREATED AS CONTINUOUS.



**ROOT AREA DISCONTINUITIES FALLING OUTSIDE THEORETICAL WELD

(B) CLASS R INDICATIONS

Figure 7.6A (Continued)—Ultrasonic Inspection Acceptance Criteria (U.S. Customary Units)

8. Class B Welds

8.1 Application. The requirements of this clause apply to Class B welds. Class B underwater welds are intended for less critical applications where lower ductility, moderate porosity and other larger discontinuities can be tolerated. This class of weld shall meet the requirements of this code for Class B welds, and shall satisfy the Customer's requirements for a particular application.

8.1.1 Welding procedure specifications for Class B welds shall be qualified in accordance with the general requirements of Clause 5, Parts I and II, and the specific requirements of Part I of this clause.

8.1.2 All welders, including tack welders, making Class B welds shall be qualified prior to production welding in accordance with the general requirements of Clause 5, Part I and III, and the specific requirements of Part II of this clause.

8.1.3 Minimum examination requirements for all Class B production welds and acceptance criteria for all inspection and examination of Class B welds, including that performed during procedure and performance qualification, are outlined in Part III of this clause.

Part I *Procedure Qualification*

8.2 Testing Requirements. The number and type of test specimens required for procedure qualification to test the first position and additional positions for Class B welds are summarized in Table 8.1. The specimen type and welding position shall be specified by the Customer. Position of welding may have a significant effect on the properties of the weld, and the Customer should take this into consideration in design and in selection of the first and other positions during procedure qualification.

8.3 Groove Welds

8.3.1 Test Specimens. Test specimens for Class B welds shall be located in accordance with Figures 8.1 or 8.2.

8.3.2 Test Results. Procedure Qualification test results for Class B groove welds shall meet the following requirements:

8.3.2.1 Visual Examination. The weld shall meet the visual acceptance criteria of 8.9.

8.3.2.2 Radiographic Examination. The weld shall meet the radiographic acceptance criteria of 8.10.

8.3.2.3 Reduced-Section Tension Tests. The tensile strength shall equal or exceed the specified minimum tensile strength of the base metal for each sample.

8.3.2.4 Bend Tests. The bending fixture shall conform to Figure 5.12 of clause 5, Part II. Maximum bend radius for testing shall be 6T unless a smaller radius is specified by the customer. Four samples shall be tested, and none shall reveal tears or other defects exceeding 3 mm (1/8 in) in the weld metal or fusion zone after the bending. Tears which originate at the corner of the specimen and are less than 6 mm (1/4 in) long shall not be cause for rejection unless they are associated with a defect.

8.3.2.5 Macroetch. Macroetch test specimens shall contain no cracks at 5× magnification and shall meet the requirements of 8.10. Microhardness measurements shall not exceed 375 HV10 (see 5.11.6) unless otherwise specified by the Customer.

8.3.2.6 Charpy Impact Test. The average and minimum Charpy energy values shall satisfy the requirements of Table 8.2, unless other requirements are specified by the customer.

Table 8.1
Weld Procedure Qualification—Number and Type of Test Specimens for Class B Welds^a

Coupon	Joint Type	Coupon Thickness mm (in)	Visual (See 6.9)	Radio graphic ^c (See 6.12)	Reduced Section Tension (See 5.11.1)	Fillet Weld Shear (See 5.11.8)	Bends ^b (See 5.11.3)		Macroetch Test (See 5.11.2)	Charpy Impact ^d (See 5.11.5)	Fillet Weld Break (See 5.11.7)
							Root and Face	Side			
Plate	Groove	T ≤ 10 (3/8)	Yes	Yes	2	0	2 each	0	1	WM and HAZ	0
		10 (3/8) < T < 20 (3/4)	Yes	Yes	2	0	2 each	or 4	1	WM and HAZ	0
		T ≥ 20 (3/4)	Yes	Yes	2	0	0	4	1	WM and HAZ	0
Pipe	Groove	T ≤ 10 (3/8)	Yes	Yes	2	0	2 each	0	1	WM and HAZ	0
		10 (3/8) < T < 20 (3/4)	Yes	Yes	2	0	2 each	or 4	1	WM and HAZ	0
		T ≥ 20 (3/4)	Yes	Yes	2	0	0	4	1	WM and HAZ	0
Plate	Fillet	All ^e	Yes	No	0	1	0	0	2 ^f	WM	1 ^f
Pipe	Fillet	All ^e	Yes	No	0	1	0	0	4 ^f	WM	4 ^f

^a First position only. Qualification for additional positions will omit groove weld tension, macroetch, and fillet weld shear strength tests.

^b For plate or pipe between 10 mm (3/8 in) and 20 mm (3/4 in) thick, the Customer may specify either two root and two face bend tests or four side bend tests.

^c Groove welds only are radiographed.

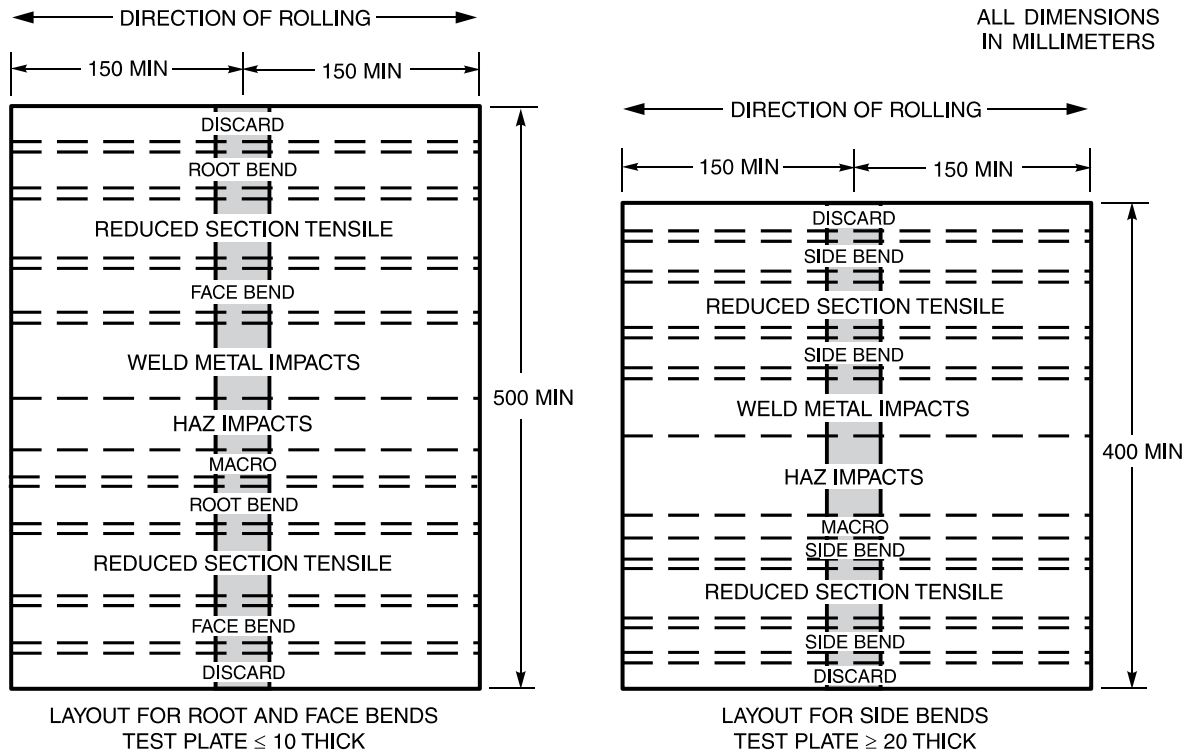
^d Vickers Hardness and Charpy Impact test not applicable to austenitic stainless steel base metal.

^e Multiple-pass fillet welds are considered qualified by groove weld qualification (5.9.2).

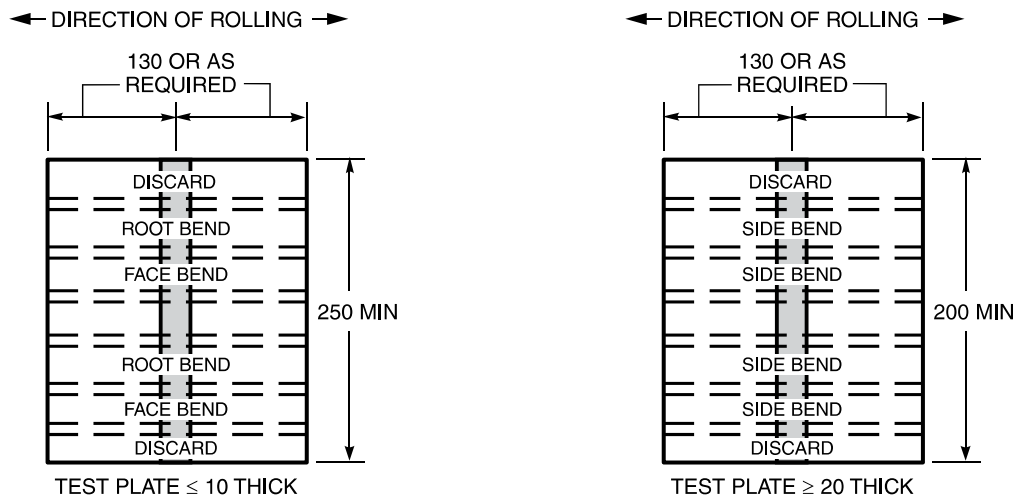
^f For single-pass welds the qualification weld size shall be the maximum size to be performed in production. For multiple-pass welds, the qualification shall be the minimum to be welded in production.

Note:

1. WM – Weld Metal; HAZ = Heat-Affected-Zone.



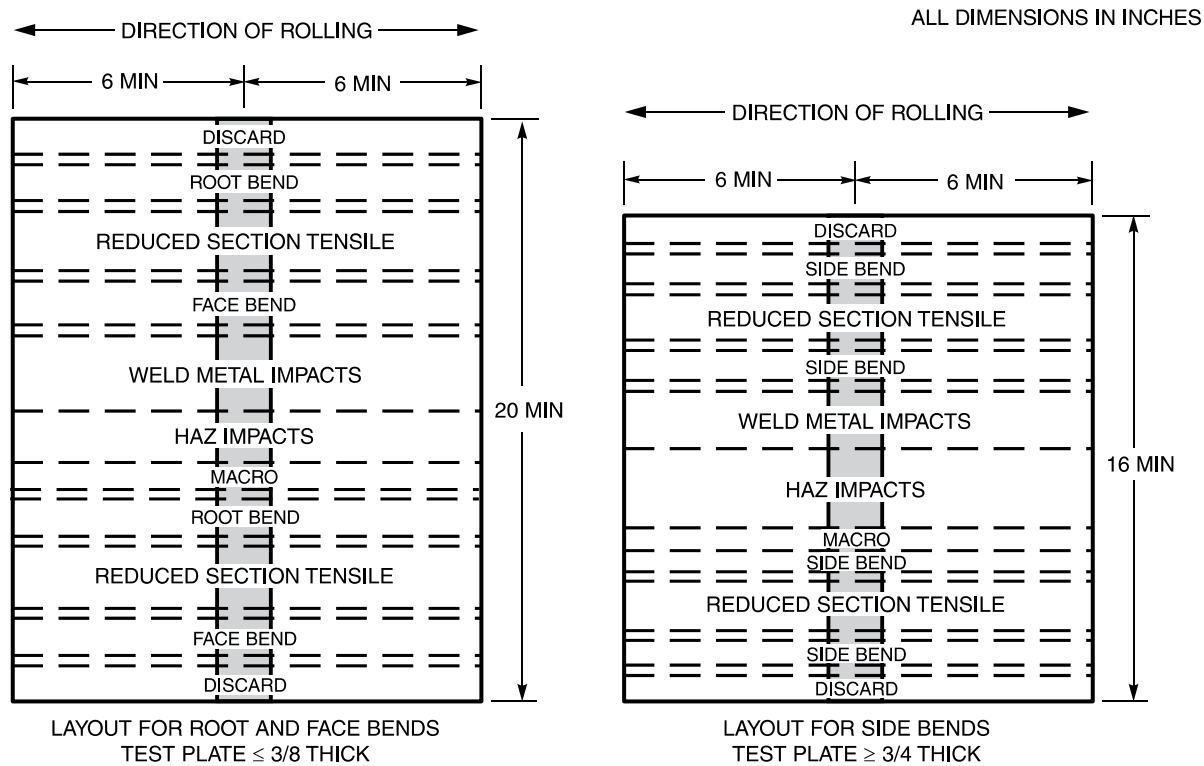
(A) FIRST POSITION PLATES



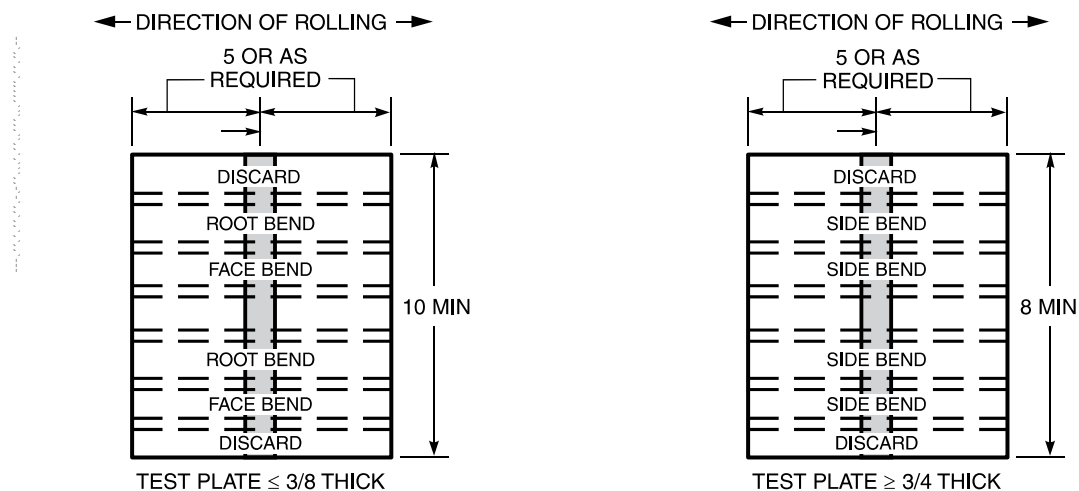
(B) ADDITIONAL POSITION PLATES

NOTE: FOR PLATES BETWEEN 10 mm AND 20 mm THICK, THE CUSTOMER MAY SPECIFY ROOT AND FACE BENDS OR SIDE BENDS.

Figure 8.1—Location and Types of Test Specimens on Welded Plate Test Procedure Qualification Assembly, Class B Groove Welds



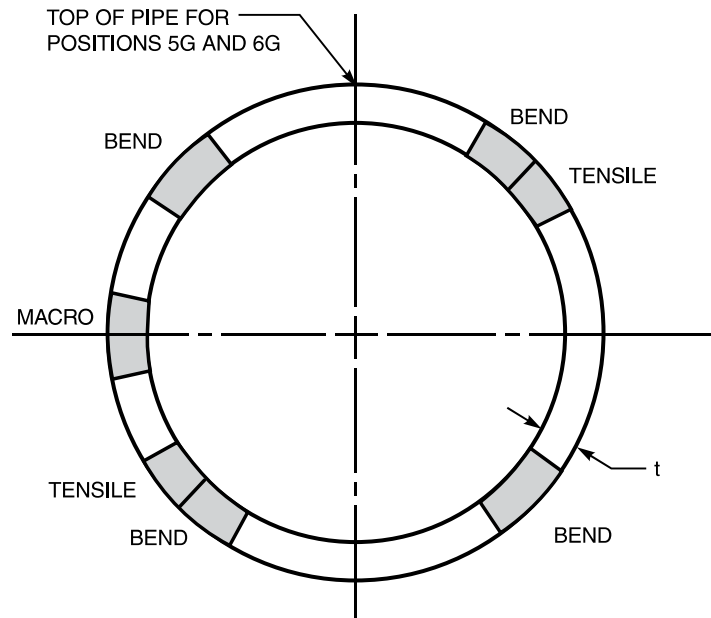
(A) FIRST POSITION PLATES



(B) ADDITIONAL POSITION PLATES

NOTE: FOR PLATES BETWEEN $3/8$ in AND $3/4$ in THICK, THE CUSTOMER MAY SPECIFY ROOT AND FACE BENDS OR SIDE BENDS.

Figure 8.1A—Location and Types of Test Specimens on Welded Plate Test Procedure Qualification Assembly, Class B Groove Welds (U.S. Customary Units)



Notes:

1. If the pipe diameter is too small to permit all specimens to be machined from a single weld, additional welds shall be made to provide sufficient material for test.
2. First position weld: test all specimens shown. Additional position welds: use bend specimens only.
3. Type of bend specimens to be used:
 - a. $t \leq 10$ mm (3/8 in)—Two root and two face bends.
 - b. $t \leq 20$ mm (3/4 in)—Four side bends.
 - c. t between 10 mm (3/8 in) and 20 mm (3/4 in), customer may specify root and face or side bends.
 - d. Specimen geometry as described in Figures 5.7, 5.10, and 5.11.

Figure 8.2—Location and Types of Test Specimens on Welded Pipe Test Procedure Qualification Assembly, Class B Groove Welds in Pipe

Table 8.2
Weld Procedure Qualification—Mechanical Test Acceptance Criteria for Class B Welds

Base Metal Minimum Specified Tensile Strength	Bend Specimen Maximum Bend Radius ^a	Weld Metal and HAZ Charpy V-Notch Impact Test ^b		Maximum Microhardness ^c
	Figure 5.12	Average Energy	Minimum Energy	
485 MPA (70 ksi) and below	6T	20J (15 ft-lb)	14J (10 ft-lb)	375 HV10
Over 485 MPA to 550 MPA	6T	27J (20 ft-lb)	19J (14 ft-lb)	375 HV10
Over 550 MPA (80 ksi)	6T	34J (25 ft-lb)	23J (17 ft-lb)	375 HV10

^a See also 8.3.2.4.

^b See 5.11.5 and Table 8.1, Note 5.

^c See 8.3.2.5.

8.4 Fillet Welds

8.4.1 Test Specimens. Fillet weld shear strength specimens shall be produced in accordance with the requirements of 5.11.8 (refer to Figures 5.16 or 5.17 for plate qualification and Figure 5.18 for pipe qualification). Fillet weld break test coupons shall be produced in accordance with the requirements of 5.11.7 (refer to Figure 5.8 for plate and pipe qualification). As an option, the contractor may choose to qualify a multiple-pass fillet weld procedure on the basis of a groove weld qualification in accordance with the requirements of 5.9.2.

8.4.2 Test Results. Procedure qualification test results for Class B fillet welds shall meet the following requirements:

8.4.2.1 Visual Examination. All test welds shall meet the visual acceptance criteria of 8.9.

8.4.2.2 Fillet Weld Shear Test. The minimum acceptable shear strength of the weld shall be 60 percent of the specified minimum tensile strength of the base metal to be welded in production.

8.4.2.3 Fillet Weld Break Tests. A fillet weld break test shall pass the test if it bends flat upon itself. If the fillet weld fractures, it shall show fusion to the root of the joint, but not necessarily beyond for at least 90 percent of the joint length. The fractured surface shall not exhibit porosity (including piping porosity) or inclusions exceeding 5 mm (3/16 in) in the greatest dimension; the total number of these discontinuities up to 5 mm (3/16 in) in the greatest dimension, shall not exceed two (2) per 25 mm (1 in) of weld length nor eight (8) per 150 mm (6 in). Discontinuities less than 1.5 mm (1/16 in) shall be ignored.

8.4.2.4 Macro. Macroetch test sections transverse to the weld shall reveal no cracks at 5× magnification and shall meet the requirements of 8.10.

Part II

Welder Qualification

8.5 Testing Requirements. The number and type of test specimens required for welder qualification for Class B welds are summarized in Table 8.3.

8.6 Groove Welds

8.6.1 Test Specimens. Test specimens for welder qualification shall be located in accordance with Figure 8.3 for groove welds and Figure 8.4 for T-, Y-, and K-connections on pipe or tubing. Four bend specimens shall be removed from each weld coupon. In lieu of radiographic inspection, three macroetch test specimens may be removed from the weld adjacent to the required bend specimens; such specimens shall be prepared and etched in accordance with 5.11, and meet the requirements of 8.6.

8.6.2 Test Results. Welder qualification test results for Class B groove welds shall meet the following requirements:

8.6.2.1 Visual Examination. The weld shall meet the visual acceptance criteria of 8.9.

8.6.2.2 Radiographic (or Macroetch Test Specimens) Examination. The weld shall meet the acceptance criteria of 8.10.

8.6.2.3 Bend Tests. The bending fixture shall conform to Figure 5.12 of Clause 5, Part B. Maximum bend radius for testing shall be 6T. Four samples shall be tested, and none shall reveal tears or other defects exceeding 3 mm (1/8 in) in the weld metal or fusion zone after the bending. Tears which originate at the corner of the specimen and are less than 6 mm (1/4 in) long shall not be cause for rejection unless they are associated with a defect.

8.7 Fillet Welds

8.7.1 Test Specimens. The welder shall weld fillet-weld-break and macroetch test assemblies as shown in Figure 5.8 in accordance with the requirements of variables and positions of 5.16 and Table 5.5. The number and type of specimens required to qualify from each assembly are shown in Table 8.3.

8.7.2 Test Results. Welder qualification test results for Class B fillet welds shall meet the following requirements:

8.7.2.1 Visual Examination. All test welds shall meet the visual acceptance criteria of 8.9.

8.7.2.2 Macroetch Test. Macroetch test sections shall reveal no cracks at 5 × magnification and shall meet the acceptance criteria of 8.10.

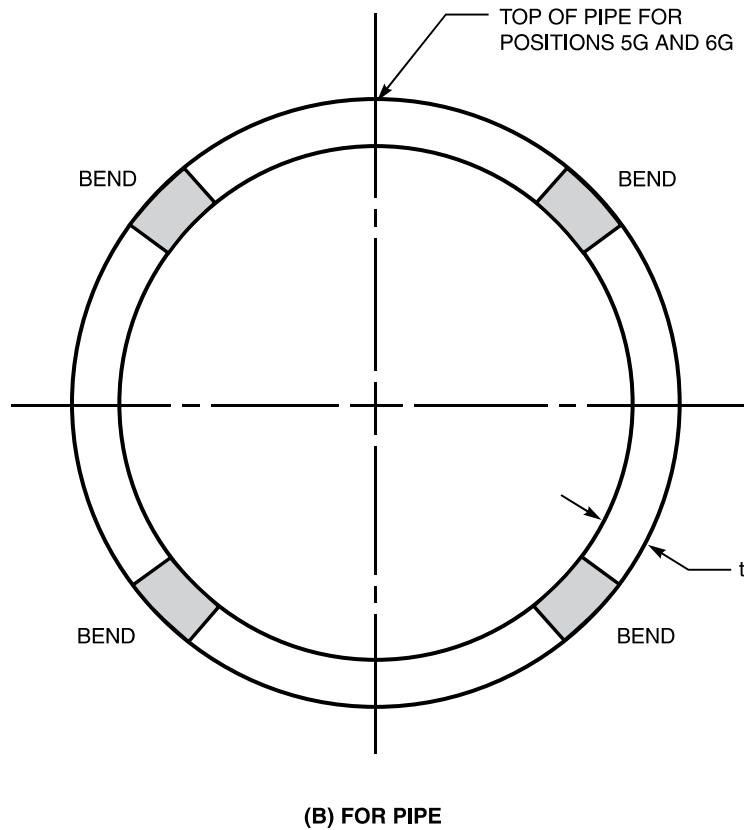
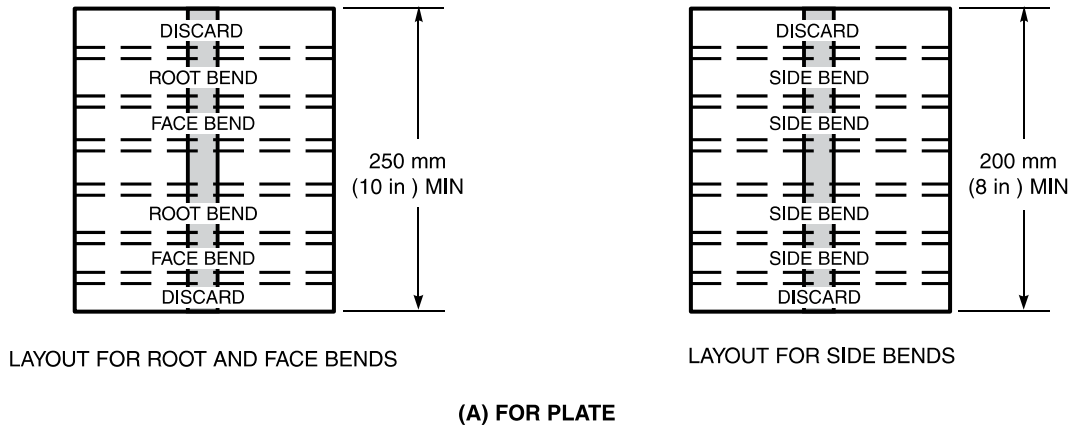
8.7.2.3 Fillet-Weld-Break Tests. A fillet weld break test shall pass the test if it bends flat upon itself. If the fillet weld fractures, porosity or slag shall not exceed the limitation of 8.10.1.

Part III

Examination

8.8 Examination Requirements. All Class B production welds shall, as a minimum, be visually examined in accordance with Clause 6, Part II. Any additional examination shall be as specified by the Customer, and performed in

ALL DIMENSIONS IN
MILLIMETERS AND INCHES



Notes: For plates between 10 mm (3/8 in) and 20 mm (3/4 in) thick, Customer may specify root and face bends or side bends (for pipe).

- $t \leq 10$ mm (3/8 in)—Two root and two face bends.
- $t \leq 20$ mm (3/4 in)—Four side bends.
- t between 10 mm (3/8 in) and 20 mm (3/4 in), customer may specify root and face or side bends.
- Specimen geometry as described in Figures 5.7, 5.10, and 5.11.
- For rectangular tubing, rotate bend and tensile specimens approximately 45 degrees counter clockwise from indicated location.

**Figure 8.3—Type and Location of Bend Test Specimens for Welder Qualification,
Class B Groove Welds**

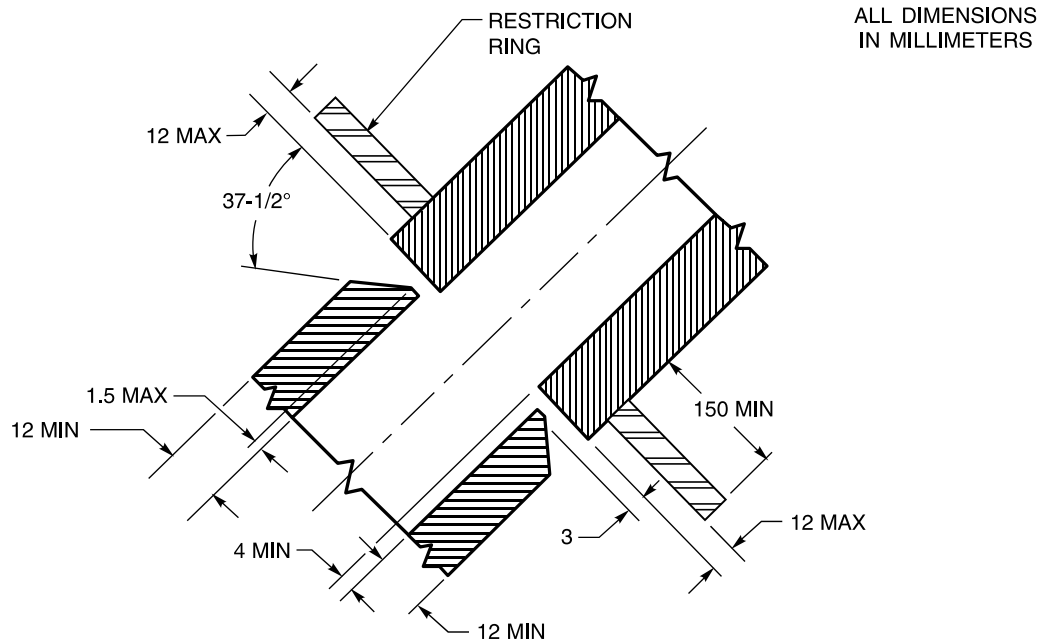


Figure 8.4—Test Assembly for T-, Y-, and K-Connections on Pipe or Square or Rectangular Tubing—Welding Procedure and Welder Performance Qualification, Class B Welds

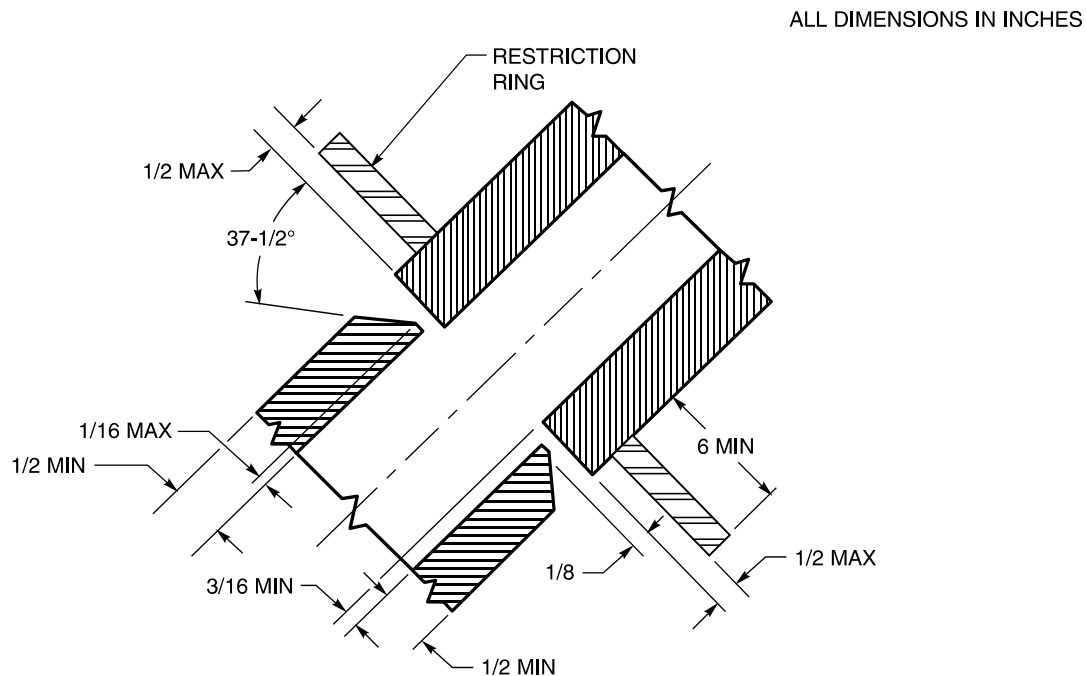


Figure 8.4A—Test Assembly for T-, Y-, and K-Connections on Pipe or Square or Rectangular Tubing—Welding Procedure and Welder Performance Qualification, Class B Welds (U.S. Customary Units)

Table 8.3
Welder Performance Qualification—Number and Type of Test Specimens for
Class B Welds (Per Welder)

Coupon	Joint Type	Thickness Tested mm (in)	Visual (See 6.9)	Radiographic (See 6.11)	Bends ^a (See 5.11.3)			Fillet Weld Break (See Figure 5.9)
					Root and Face	Side	Macro ^b	
Plate	Groove	$T \leq 10$ (3/8)	Yes	Yes ^c	2 each			
		10 (3/8) $< T < 20$ (3/4)	Yes	Yes ^c	2 each	or	4	
		$T \geq 20$ (3/4)	Yes	Yes ^c			4	
Pipe	Groove	$T \leq 10$ (3/8)	Yes	Yes ^c	2 each			
		10 (3/8) $< T < 20$ (3/4)	Yes	Yes ^c	2 each	or	4	
		$T \geq 20$ (3/4)	Yes	Yes ^c			4	
Plate	Fillet	All	Yes				2	1
Plate	Fillet	All	Yes				4	4

^a For plate and pipe between 10 mm (3/8 in) and 20 mm (3/4 in) thick, Customer may specify either root and face bends or side bends.

^b See 5.11.2, 8.7 and Figure 5.8, 8.1, or 8.2. Hardness tests not required.

^c Ultrasonic or three Macros may be substituted (see 8.6.1).

accordance with the requirements of clause 6, as applicable. Acceptance criteria shall be in accordance with the following.

8.9 Visual Acceptance Criteria. The following acceptance criteria, in accordance with the procedures and standards of Clause 6, Part II, shall apply to all Class B welds during visual examination for surface defects.

8.9.1 The weld shall have no cracks.

8.9.2 Complete fusion shall exist between adjacent weld beads and full penetration shall exist between weld metal and base metal.

8.9.3 All craters shall be filled.

8.9.4 Weld profiles shall be in accordance with Figure 8.5(A), (B), or (D).

8.9.5 The sum of the diameters of porosity which exceeds 1.5 mm (1/16 in) in diameter shall not exceed 10 mm (3/8 in) in any linear 25 mm (1 in) of weld.

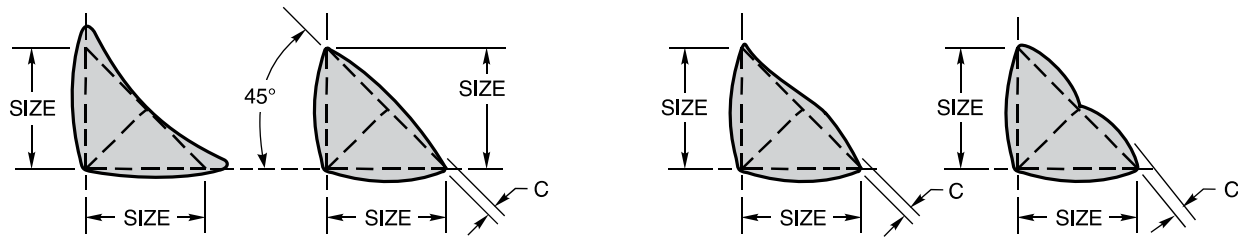
8.9.6 Undercut shall not exceed 1.5 mm (1/16 in) in depth with the following exception. Isolated undercut over 1.5 mm (1/16 in) but not more than 3 mm (1/8 in) or 20 percent of the base metal thickness in depth, whichever is less, shall be permitted, provided it does not exceed 10 mm (3/8 in) in length and it shall be separated by a minimum of 150 mm (6 in) from adjacent undercut that is deeper than 1.5 mm (1/16 in). The maximum length of undercut between 0.8 mm (1/32 in) and 1.5 mm (1/16 in) in depth shall not exceed 100 mm (4 in) in any continuous 300 mm (12 in) of weld. Undercut less than 0.8 mm (1/32 in) in depth shall be acceptable without restrictions.

8.9.7 When root surfaces are present and accessible, drop-through is not limited. Incomplete joint penetration or melt-through shall be limited to 3 mm (1/8 in) maximum depth and 100 mm (4 in) maximum length in any 300 mm (12 in) of weld length. Class B welds are frequently fillet or groove welds with a backing strip and, therefore, root surfaces may not be visible.

8.10 Radiographic and Macroetch Test Acceptance Criteria

8.10.1 Radiographic Acceptance Criteria. The following acceptance criteria for Class B production and qualification welds, as applicable, shall be satisfied. Discontinuities found by radiographic examination shall not exceed the dimensions specified.

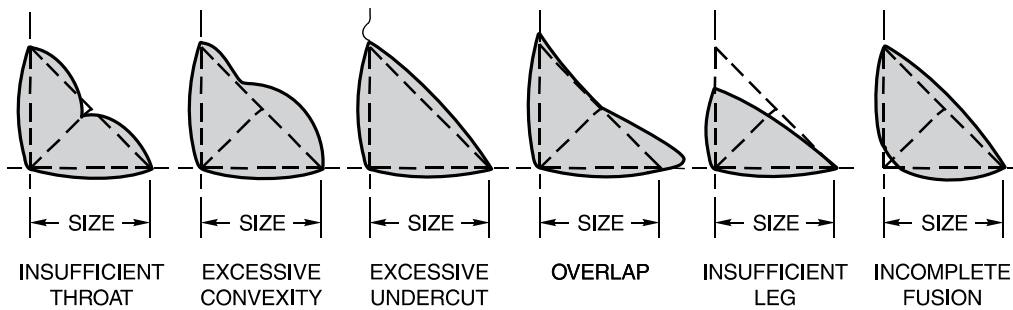
8.10.1.1 Cracks. The welds shall have no cracks.



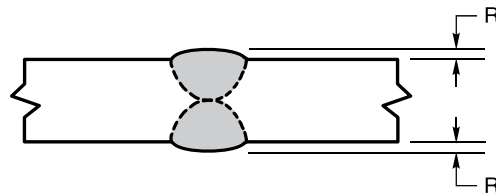
NOTE: CONVEXITY C SHALL NOT EXCEED 0.1 TIMES ACTUAL LEG SIZE, OR THE LONGER LEG IN THE CASE OF AN UNEQUAL LEG FILLET WELD, PLUS 1 mm (3/64 in).

(A) DESIRABLE FILLET WELD PROFILES

(B) ACCEPTABLE FILLET WELD PROFILES

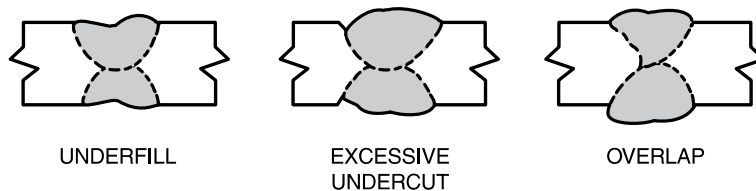


(C) UNACCEPTABLE FILLET WELD PROFILES



NOTE: REINFORCEMENT R SHALL NOT EXCEED 5 mm (3/16 in)

(D) ACCEPTABLE GROOVE WELD PROFILE



(E) UNACCEPTABLE GROOVE WELD PROFILES

Figure 8.5—Acceptable and Unacceptable Weld Profiles for Class B Welds

8.10.1.2 Porosity. Dispersed pores in a size range of from 1.5 mm (1/16 in) diameter to 5 mm (3/16 in) diameter shall not exceed 7 per linear 25 mm (1 in) of weld per 25 mm (1 in) of weld thickness. The maximum pore size shall not exceed 5 mm (3/16 in). Pores smaller than 1.5 mm (1/16 in) in diameter shall not be restricted in number.

8.10.1.3 Slag. The maximum width of isolated slag inclusions shall not exceed 3 mm (1/8 in). The maximum length of any slag inclusions shall not exceed 50 mm (2 in). The total length of slag inclusions between 0.8 mm (1/32 in) and 3 mm (1/8 in) in width shall not exceed 100 mm (4 in) in any continuous 300 mm (12 in) of weld. Adjacent slag inclusions greater than 0.8 mm (1/32 in) wide shall be separated by 5 mm (3/16 in) minimum.

8.10.1.4 Inadequate Joint Penetration. Image areas indicating inadequate joint penetration shall not have a radiographic density greater than that of the base metal, and for this purpose, the maximum height of face reinforcement shall not exceed 3 mm (1/8 in), unless specifically approved by the Customer.

8.10.1.5 Incomplete Fusion. The maximum continuous length of any single defect shall not exceed the base metal thickness, and the maximum cumulative total length of all defects shall not exceed 100 mm (4 in) in any 300 mm (12 in) of weld. Incomplete fusion defects that appear to be continuous from one bead or layer to the next shall be unacceptable regardless of length.

8.10.1.6 Root Underfill. Image areas indicating root underfill shall not have a radiographic density greater than that of the base metal. For the purpose of this measurement, the maximum face reinforcement shall not exceed 3 mm (1/8 in), unless specifically approved by the Customer.

8.10.1.7 Melt-Through. The length of any unrepaired excessive melt-through shall not exceed the base metal thickness.

8.10.1.8 Accumulation of Discontinuities. The total accumulative length of all discontinuities shall not exceed 100 mm (4 in) in 300 mm (12 in) of weld length.

8.10.2 Macroetch Test Acceptance Criteria. Slag and porosity shall not exceed 5 percent of the surface area, and the maximum dimension of any discontinuity shall not exceed 2 mm (3/32 in). Linear indications of 1.5 mm (1/16 in) and less shall be acceptable when associated with the root of partial penetration and backing bar groove welds, provided such adjacent linear indications are separated by at least 3 mm (1/8 in).

8.11 Surface Examination Acceptance Criteria. The acceptance criteria of 8.9 and 8.10 shall apply to nondestructive surface examination (magnetic particle, liquid penetrant, or eddy current) performed on **Class B** welds.

9. Class O Welds

9.1 Application. The requirements of this clause apply to Class O welds. Class O underwater welds are intended to meet the requirements of some other code or specification designated by the Customer. Class O welds shall also meet the requirements identified in this clause.

9.1.1 Welding procedure specifications for Class O welds shall be qualified in accordance with the general requirements of Clause 5, Parts I and II, and the specific requirements of Part I of this clause.

9.1.2 All welders, including tack welders, making Class O welds shall be qualified prior to production welding in accordance with the general requirements of Clause 5, Parts I and III, and the specific requirements of Part II of this clause.

9.1.3 Minimum examination requirements for all Class O production welds and acceptance criteria for all inspection and examination of Class O welds, including that performed during procedure and performance qualification, are defined in Part III of this clause.

Part I Procedure Qualification

9.2 Testing Requirements. The number and type of test specimens required for procedure qualification to test the first position and additional positions, for Class O welds are summarized in Table 9.1. (Refer also to 5.6.)

9.3 Groove Welds

9.3.1 Test Specimens. Welded test assemblies shall satisfy the dimensional requirements of the standard designated by the Customer. Provision should be made to remove a macroetch test specimen from the procedure qualification test coupon. If the base metal on both sides of the weld is required to be impact tested, the weld metal and heat-affected zone in the procedure qualification test coupon shall also be impact tested. When an all-weld-metal tension test is specified, a second welded test assembly should be prepared as shown in Figures 5.13 and 5.14. (This should not be mandatory for dry Class O welds unless specifically required by the Customer or referenced standard.) As an option, the length of the procedure qualification test assembly may be increased, and the all-weld-metal tension specimen may be removed from the procedure qualification test assembly. When specified by the Customer, a bridge bend test shall be required for nonstructural welds or weld overlays. Refer to 5.11.9 and Figure 5.19.

9.3.2 Test Results. Procedure qualification test results for Class O groove welds shall meet the following requirements:

9.3.2.1 The visual and nondestructive examination acceptance criteria and mechanical property requirements shall satisfy the standard designated by the Customer.

9.3.2.2 Radiography. Radiographic examination is to be required for groove welds and shall satisfy the designated standard for production welds.

9.3.2.3 All-Weld-Metal Tension Tests. The yield and tensile strength shall not be less than the specified minimum required of the base metal. When no all-weld-metal elongation requirement is specified by the governing standard, the minimum elongation requirement for Class A shall apply.

9.3.2.4 Macroetch Test. Macroetch test specimen transverse to the weld shall reveal no cracks at 5× magnification. Slag, porosity, and other defects, as well as hardness exceeding limits specified by the designated standard, shall be cause for rejection (see Part III of this clause).

Table 9.1
Weld Procedure Qualification—Number and Type of Test Specimens for Class O Welds^a

Coupon	Thickness mm (in)		Visual (See 6.9)	Radiograph (See 6.11)	Reduced Section Tension (See 5.11.1)	Fillet Weld Shear ^b (See 5.11.8)	All-Weld- Metal Tension (See 5.11.4)	Root, Face, and Side Bends	Macroetch Test (See 5.11.2)	Vickers Hardness ^c (See 5.11.6)	Charpy ^e (See 5.11.5)	Fillet Weld Break ^b (5.11.7)
	Yes	Yes			Note ^d	0	1	Note ^e	1	1	Note ^e	Note ^e
All					Note ^e		1	Note ^e	1	1	Note ^e	Note ^e

^a First position only. Qualification for additional positions will omit groove weld tensile, fillet weld shear strength tests, and all-weld-metal tension tests.
^b Multiple-pass fillet welds are considered qualified by groove weld qualification. (See 5.9.2.)
^c Vickers Hardness and Charpy Impact tests not applicable to austenitic stainless steel.
^d Groove welds only are radiographed.
^e Mechanical test requirements shall satisfy the specific code referenced by the Customer. Weld metal and HAZ Charpy toughness testing is required only if Charpy toughness is required of the base metal on both sides of the weld.

9.3.2.5 Charpy Impact Tests. If Charpy notch toughness testing is required in the referenced standard, the qualification weld shall be tested and shall satisfy those requirements. The weld metal shall also be impact tested if the base material on both sides of the weld must meet impact test requirements. The minimum absorbed energy values and testing temperatures shall be as specified by the referenced standard or by the Customer.

9.3.2.6 Bridge Bend Test. If a bridge bend test is required, the test shall pass if no cracks open up in either the weld- or heat-affected zone. The specimen shall be unacceptable if a crack is detected.

9.4 Fillet Welds

9.4.1 Test Specimens. The coupons required for fillet weld qualification in the standard referenced by the Customer shall be produced. Allowance should be included to permit removal of a weld macroetch test specimen. A groove weld shall be produced in accordance with Figure 5.13 for the all-weld-metal tensile and the Charpy V-notch weld-metal tests.

9.4.2 Test Results. The provisions of 9.3.2.1 and 9.3.2.3 through 9.3.2.5 shall apply to fillet weld test results.

Part II Welder Qualification

9.5 Requirements. The number and type of test specimens and the required test results for welder qualification for Class O groove and fillet welds shall be in accordance with the requirements of the standards specified by the Customer. Refer also to 5.15.

Part III Examination

9.6 Examination Requirements. All Class O welds shall, as a minimum, be visually examined in accordance with Clause 6, Part II. Unless otherwise specified by the Customer, all Class O production welds shall also be examined in accordance with the requirements of the standard specified.

9.7 Acceptance Criteria. Acceptance criteria for inspection and examination of Class O welds shall be in accordance with the requirements of the standard specified by the Customer.

Annex A (Informative) Sample Welding Forms

This annex is not part of AWS D3.6M:2010, *Underwater Welding Code*, but is included for informational purposes only.

This annex contains eight (8) forms that the Underwater Welding Subcommittee has approved for the recording of procedure qualification, welder qualification, welding operator qualification data required by this Code. References in parentheses identify applicable clause or tables of D3.6M concerning the variables. Also included are laboratory report forms for recording the results of ultrasonic examination of welds.

It is suggested that qualification and NDT information required by this Code be recorded on these forms, available from AWS, or similar forms which have been prepared by the user. A variation of these forms to suit the user's needs are permissible.

- A-1 Welding Procedure Specification—Wet Welding and Dry Hyperbaric Welding
- A-2 Procedure Qualification Record (PQR)—Wet Welding Variables
- A-3 Procedure Qualification Record (PQR)—Wet Underwater Welding
- A-4 Welder or Welding Operator Performance Qualification Test Record—Wet Welding Processes
- A-5 Procedure Qualification Record (PQR)—Dry Hyperbaric Welding Variables
- A-6 Welder or Welding Operator Performance Qualification Test Record—Dry Welding Processes
- A-7 Ultrasonic Examination Report Form
- A-7A Ultrasonic Examination Report Form (U.S. Customary Units)

Customer		Job No.
Procedure No.	Date	
Revision No.	Date	
Welding Process(es)		
Contract No.		

**Form A-1—Welding Procedure Specification—Wet Welding and
Dry Hyperbaric Welding**

GENERAL DATA	
Client	
Location	
Certifying Authority	
Welding Code	
Weld Class	

ENVIRONMENTAL DATA	
Water Depth	
D.W.C. Gas	
D.W.C. Pressure	
D.W.C. Temp. (est)	
D.W.C. Humidity	

JOINT DETAILS	
Configuration	
Backing	
Position	
Alignment Clamp	

JOINT CONFIGURATION SKETCH

JOINT DETAILS	
Material Spec.	
Wall Thickness	
Carbon Equiv.	

WELDING CONSUMABLES		
Process	Type	Size
F.C.A.W.		
T.I.G.		
M.M.A.		

DOUBLER PLATE MATERIAL	
Material Spec.	
Wall Thickness	
Carbon Equiv.	

PRE-HEAT		
Temp. °C (Min)	Interpass Temp. (Max)	Heater Type

TECHNIQUE

**Form A-1(Continued)—Welding Procedure Specification—Wet Welding
and Dry Hyperbaric Welding**

OTHER PROCESS DATA			
Item	F.C.A.W.	T.I.G.	M.M.A.
Torch			
Gas Shroud			
Electrode			
Arc Length			

WELD PASS SEQUENCE						
Pass	Progress	DC Polarity	Volts	Amps	Speed	Oscillation

TESTING/INSPECTION REQUIREMENT		
Procedure Qual.	Welder Qual.	Operational

Form A-1 (Continued)—Welding Procedure Specification—Wet Welding and Dry Hyperbaric Welding

ANY OTHER RELEVANT SPECIAL DATA	

[illegible]

Form A-1 (Continued)—Welding Procedure Specification—Wet Welding and Dry Hyperbaric Welding

CONTRACTOR _____ Page _____ of _____

WPS NO. _____ POTR NO. _____

DEPTH _____ PROCESS _____ WELD CLASS (2.1) _____

Manual _____ Machine _____ Auto _____ Acceptance Code (Class O Only) _____

BASE METAL

Thickness [Table 5.2–A.2(a)] _____ Specification [Table 5.2–A.2.(b)] _____

Minimum Tensile Strength [Table 5.2–A.2.(c)] _____ Grade [Table 5.2–A.2.(d)] _____

Carbon Equvalent [Table 5.2–A.2.(d)] _____ Carbon Content (5.6.1.3) _____

FILLER MATERIAL

Manufacturer [Table 5.2–A.3.(a)] _____ Manufacturer's Type [Table 5.2–A.3.(b)] _____

AWS Specification _____ AWS Classification _____

Electrode Size [Table 5.2–A.3.(c)] _____ U/W Transport Method [Table 5.1–A.3.(d)] _____

Supplementary Coaling or Waterproofing Modifications [Table 5.2–A.3.(e)] ☐ YES ☐ NO

Max Exposure Time to Ambient Conditions @ Depth [Table 5.2–A.3.(f)] _____

(EXAMPLES OF TRANSPORT METHOD; PRESSURE, VACUUM, OR ONE ATMOSPHERE CONTAINER)

POSITION

Position [Table 5.2–A.4.(a)] _____

ELECTRICAL

Type of Welding Current [Table 5.2–A.6.(a)] _____ Type of Power Source [Table 5.2–A.6.(b)] _____

TECHNIQUE

Stringer/Weave [Table 5.2–A.7.(a)] _____ Progression Up/Down (Table 5.2–A.7.(b)) _____

Temper Beads [Table 5.2–A.7.(c)(h)] ☐ YES ☐ NO Water Barrier [Table 5.2–A.7.(g)] ☐ YES ☐ NO

ENVIRONMENT

Depth of Test [Table 5.2–A.8.(3)] _____ Backside Wet/Dry [Table 5.2–A.8.(b)(c)] _____

Pressure Differential [Table 5.2–A.8.(d)] _____

COMMENTS

Form A–2—Procedure Qualification Record (PQR)—Wet Welding Variables

PQR NO. _____ Page _____ of _____

Joint Detail

Include: Joint Type [Table 5.2–A.1.(a)], No. Passes [Table 5.2–A.1.(b)], Backing [Table 5.2–A.1.(c)], Dimensions [Table 5.2–A.1.(e)], Thicknesses [Table 5.2–A.2.(a)], Weld Bead Sequence [Table 5.2–A.7.(d)]

Measured Variables (Ranges)

Pass No.	Electrode Size/Type [Table 5.2– A.3.(b)(c)].	Welding Current		Travel Speed [Table 5.2– A.7.(e)]	Remarks
		Amps [Table 5.2– A.6.(c)]	Volts [Table 5.2– A.6.(d)]		

Specimen Nos. _____ Welder's Name _____
 Date of Testing _____ Witnessed By _____

Form A–2 (continued)—Procedure Qualification Record (PQR)—Wet Welding Variables

WELDER'S NAME _____ I.D. NUMBER _____
 PQR NO. _____ WPS NO. (5.15) _____ WELD CLASS (2.1) _____
 Process [5.16(2)] _____ Acceptance Code (Class O Only) _____

ESSENTIAL VARIABLES

BASE METAL

Thickness [5.16(4)] _____ Diameter (Pipe) [5.16(4)] _____
 Material Specification _____

FILLER METAL

AWS Classification [5.16(5)] _____ Waterproof Coating Modifications [5.16(6)] _____
 Supplementary Coating Modifications [5.16(5)] _____

POSITION

Position [5.16(7)] _____ Progression Up/On [5.16(11)] _____

ENVIRONMENT

Depth [5.16 (8)] _____ Diving Dress [5.16(1)] _____
 Visibility [5.16(13)] _____ Time and Temperature of Exposure [5.16(1)] _____

TEST RESULTS

Visual Examination _____ Radiographic _____
 Ultrasonic _____ Macroetch Examination _____

GUIDED BEND, TENSILE, OR NICK-BREAK TEST

Type	Results	Type	Results
Fillet Weld Break Specimens			

Fillet Size _____ Fracture Test and Root Penetration _____

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of AWS D3.6M:2010, *Underwater Welding Code*, 5.16.

Inspection Co. _____ Inspector _____
 Test Lab _____ Conducted By _____
 Contractor _____ Authorized By _____
 Date of Welder Test _____ Lab Report No. _____

FORM A-3—Welder or Welding Operator Performance Qualification Record— Wet Welding Processes

CONTRACTOR _____ Page _____ of _____

WPS NO. _____ PQR NO. _____

DEPTH _____ PROCESS _____ WELD CLASS _____

Manual _____ Machine _____ Auto _____ Acceptance Code (Class O Only) _____

BASE METAL

Specification _____ Grade _____

Thickness [Table 5.1–A.2 (a)] _____ Carbon Content (5.6.1.3) _____

Minimum Tensile Strength [Table 5.1–A.2.(c)] _____

FILLER MATERIAL

Manufacturer [Table 5.1–B.3] _____ AWS Filter Metal Type [Table 5.1–A.3.(a)] _____

U/W Transport Method [Table 5.1–A.3.(b)] _____ Supplementary Coating [Table 5.1–A.3.(c)] ☐ YES ☐ NO

Max Exposure Time To Ambient Atmosphere @ Depth [Table 5.1–A.3.(d)] _____

Electrode Size (SMAW) [Table 5.1–B.3.(c)] Root _____ Hot _____ Fill _____ Cap _____

Filler Wire Diameter [GMAW, Table 5.1–C.3.(d)] [FCAW, Table 5.1–D.3. (c)] [GTAW & PAW, Table 5.1–E.3.(c)] _____

(EXAMPLES OF TRANSPORT METHOD; PRESSURE, VACUUM, OR ONE ATMOSPHERE CONTAINER)

POSITION

Position [Table 5.1–A.4.(a)] _____

WELDMENT TEMPERATURE

Interpass/Preheat [Table 5.1–A.5.(a)] _____ Postheat Treatment [Table 5.1–A.5.(b)] _____

ELECTRICAL

Type of Welding Current [Table 5.1–A.6.(a)] _____ Type of Power Source [Table 5.1–6.(b)] _____

TECHNIQUE

Stringer/Weave [Table 5.1–A.7.(a)] _____ Progression Up/Down [Table 5.1–A.7.(b)] _____

Temper Beads [Table 5.1–A.7.(c)] ☐ YES ☐ NOPeening [Table 5.1–A.7.(h)] ☐ YES ☐ NO**ENVIRONMENT**Backside Wet/Dry [Table 5.1–A.8.(b)(d)] _____ Breathing Gas/PPO₂ [Table 6.1–A.8.(c)] _____**SHIELDING GAS**

Nominal % Composition [Table 6.1–C.9.(a)] _____ Flow Rate [Table 5.1–C.9.(b)] _____

Nozzle Orifice Diameter [Table 5.1–C.9.(c)] _____

(See Table 5.1–D.9. and Table 5.1–E.9. for Flux Core and GTA welding)

Form A–4—Procedure Qualification Record (PQR)—Dry Hyperbaric Welding Variables

Joint Detail

Include: Joint Type [Table 5.1–A.1.(a)]. No. Passes [Table 5.1–A.1.(b)], Backing [Table 5.1–A.1(c)], Dimensions [Table 5.1–A.1.(e)]. Thicknesses [Table 5.1–A.2.(a)], Weld Bead Sequence [Table 5.1–A.7(all)]

Measured Variables (Ranges)

Pass No.	Electrode Size/Type [Table 5.1–B.(c)(d)]	Welding Current		Travel Speed [Table 5.1–A.7.(e)]	Remarks
		Amps [Table 5.1–B.6.(c)]	Volts [Table 5.1–B.6.(b)]		

Specimen Nos. _____ Welder's Name _____
Date of Testing _____ Witnessed By _____

**FORM A-4 (Continued)—Procedure Qualification Record (PQR)—Dry Hyperbaric
Welding Variables**

WELDER'S NAME _____ I.D. NUMBER _____
 PQR NO. _____ WPS NO. (5.15) _____ WELD CLASS (2.1) _____
 Process [5.16(2)] _____ Acceptance Code (Class O Only) _____

ESSENTIAL VARIABLES

BASE METAL

Thickness [5.16(4)] _____ Diameter (Pipe) [5.16(4)] _____

FILLER METAL

AWS Classification [5.16(5)] _____

Supplementary Coating Modifications [5.16(5)] _____

POSITION

Position [5.16(7)] _____ Progression Up/On [5.16(11)] _____

ENVIRONMENT

Depth [5.16 (8)] _____ Shielding Gas [5.16(10)] _____

Breathing Gas [5.16(9)] _____

Time and Temperature of Exposure [5.16(1)] _____

TEST RESULTS

Visual Examination _____ Radiographic _____

Ultrasonic _____ Macroetch Examination _____

GUIDED BEND, TENSILE, OR NICK-BREAK TEST

Type	Results	Type	Results

FILLET WELD BREAK SPECIMENS

Fillet Size _____ Fracture Test and Root Penetration _____

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of AWS D3.6M:2010, *Underwater Welding Code*, 5.16.

Inspection Co. _____ Inspector _____

Test Lab _____ Conducted By _____

Contractor _____ Authorized By _____

Date of Welder Test _____ Lab Report No. _____

FORM A-5—Welder or Welding Operator Performance Qualification Test Record—Dry Welding Processes

ALL DIMENSIONS
IN MILLIMETERS

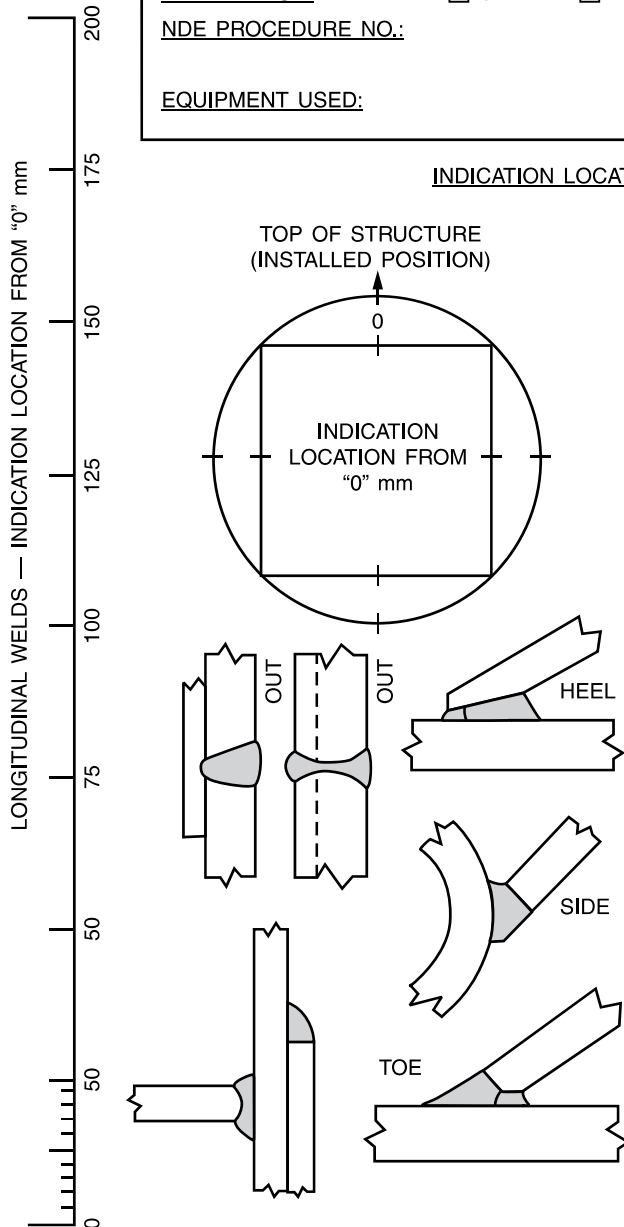
NDT COMPANY NAME

JOB NO.

NONDESTRUCTIVE EXAMINATION REPORT

WELD NO.

DATE

PART IDENTIFICATIONENVIRONMENTNDE METHOD:☐ UT☐ MT☐ PT☐ RT☐ _____NDE PROCEDURE NO.:TECHNIQUE:EQUIPMENT USED:INDICATION LOCATION AND EVALUATION

INDICATION NO.	LENGTH	UT ONLY		LOCATION FROM "0"	ACCEPT	REJECT	COMMENTS
		HEIGHT	AMP CAT.				
UT AMPLITUDE CATEGORY					2 DRL-ARL	3 OVER ARL	
NDE TECH. _____							
NDE CO. _____							
_____ INSPECTOR							

FORM A-6—Ultrasonic Examination Report Form

NDT COMPANY NAME

JOB NO.

NONDESTRUCTIVE EXAMINATION REPORT

WELD NO.

DATE _____

PART IDENTIFICATION

ENVIRONMENT

NDE METHOD:

☐ UT

☐ MT

☐ PT

□ RT

9

NDE PROCEDURE NO.:

TECHNIQUE:

EQUIPMENT USED:

LONGITUDINAL WELDS — INDICATION LOCATION FROM "0" in.

INDICATION LOCATION AND EVALUATION

TOP OF STRUCTURE
(INSTALLED POSITION)

INDICATION
LOCATION FROM
"0" in

no

no

HEEL

SIDE

TOE

INDICATION NO.	LENGTH	UT ONLY		LOCATION FROM "0"	ACCEPT	REJECT	COMMENTS
		HEIGHT	AMP CAT.				
UT AMPLITUDE CATEGORY				2 DRL-ARL		3 OVER ARL	
NDE TECH. _____							
NDE CO. _____							
INSPECTOR							

FORM A-6A—Ultrasonic Examination Report Form (U.S. Customary Units)

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Annex B (Informative)

Terms and Definitions

This annex is not part of AWS D3.6M:2010, *Underwater Welding Code*, but is included for informational purposes only.

The terms and definitions in this glossary are unique to underwater welding and applicable to this Code.

ambient pressure. Pressure of the environment surrounding the welding arc.

arc-dry. A condition in which the welding arc and any shielding gas are separated from the aqueous environment by a mechanical barrier.

arc-wet. A condition in which no mechanical barrier exists between the welding arc and the aqueous environment.

background gas. Gas which serves to displace water, but is not necessarily intended to shield the arc. It may or may not be breathable.

bottom time. Time normally used in diving to calculate decompression. In this Code, it is taken to be the total elapsed time measured in minutes, from the time when the diver leaves the surface in descent, to the time that the diver begins ascent.

caisson. A watertight chamber used underwater in construction work or as a foundation.

carbon equivalent. Carbon equivalent (CE) is an empirical guide relating the chemical composition of steel with hydrogen-induced cracking tendencies. Carbon Equivalent is calculated in accordance with 5.6.1.3.

cofferdam. A watertight barrier that surrounds the weld site. When the water is evacuated, the weld site is at atmospheric pressure.

cofferdam welding. Welding below the water surface inside a cofferdam. Both the welder and the arc are in a dry environment.

confirmation weld. A test weld made at the underwater work site prior to production welding. The confirmation weld is intended to demonstrate proper functioning of the welding system (e.g., power supply and welding leads) under actual conditions (e.g., wave action, visibility, current). It is not intended to be used as requalification of the welding procedure, welder, or both.

controlled rolling. A thermomechanical treatment for forming steel plate. The final thickness reduction is made near the critical temperature, producing a fine-grained steel of improved toughness.

crack. A fracture-type discontinuity characterized by a sharp tip and high ratio of length and width to opening displacement.

customer. The party contracting for the work or the authorized representative.

depth. Distance below the water surface at which underwater welding is executed.

direct visual examination. Examination performed at the weld site of the surface appearance of a weld. (See also *indirect visual examination*.)

dive team. Divers and support personnel involved in a diving operation, including the designated person-in-charge.

diving mode. A type of diving requiring specific equipment, procedures, and techniques (SCUBA, surface-supplied air, mixed gas saturation diving, etc.).

dry-backed weld joint. The condition in which all water is excluded from contact with any part of the weld joint for a distance of 150 mm (6 in) or greater.

dry chamber welding. A hyperbaric underwater welding method in which the weldment is in a dry environment provided by a chamber fitted over the joint to be welded. Water is displaced from the chamber by gas at ambient pressure. The chamber may be of any size, and is such that diving dress is required.

dry-spot welding. An underwater welding method in which only the arc is in a dry environment, and where the protective welding gases are maintained at the arc by a mechanical barrier.

dry welding. Any welding in which water is excluded from the immediate vicinity of the arc by a mechanical barrier.

essential variable. Essential variables are those for which a change may affect the mechanical properties of the weldment or the operating characteristics of the procedure.

faying surface. The mating surface of a member that is in contact with or in close proximity to another member to which it is to be joined.

gas diving. Use of gases other than air for the breathing gas.

habitat welding. A hyperbaric underwater welding method in which the weldment and the welder are in a dry environment, provided by a chamber of sufficient size to contain the welder and to permit free movement by the welder inside of it. Water is displaced from the chamber by gas at ambient pressure. The chamber is such that diving dress is not required during welding.

heavy gear. Diver-worn deep sea dress including helmet, breastplate, dry suit, and weighted shoes.

hyperbaric conditions. Pressure conditions in excess of surface pressure.

image quality indicator (IQI). A device whose image in a radiograph is used to determine radiographic quality level. It is not intended for use in judging the size nor for establishing acceptance limits of discontinuities. It is commonly referred to as a *penetrameter*.

indirect visual examination. Examination of the surface appearance of a weld by methods that do not require that the inspector be at the weld site. Methods may include photographic, video, or other means approved by the Customer. (See also direct visual examination.)

inspector. A duly designated person acting for and in behalf of the Customer on matters within the scope of this specification. See 1.4.1.

inspector/diver. A person capable of conducting an investigation, such as visual or radiographic, at an underwater site.

mixed-gas diving. A diving mode in which the diver is supplied in the water with a breathing gas other than air.

one-atmosphere welding. Welding underwater in a pressure vessel in which the pressure is maintained at approximately one atmosphere independent of depth.

saturation diving. A diving mode which does not impose limits on exposure time, nor require decompression until the diver's work is completed. This mode is used when pressure at working depths makes surface diving impractical, due to limited exposure time and extended decompression after each dive.

scuba diving. A diving mode, independent of surface supply, in which the diver uses open-circuit self-contained underwater breathing apparatus.

surface diving. Diving mode in which the diver returns to atmospheric conditions after each dive. The breathing mixture, air or mixed gas, is supplied to the diver from the surface.

T-, Y-, and K-connections. A truss joint or node in tubular structures formed by members whose axes intersect in T-, Y-, K-, and other configurations.

temper bead. An overlapping weld bead applied adjacent to, but not in contact with, the base metal with the intent to minimize hardness, and—when applied within defined time constraints—to promote hydrogen release in the base metal heat-affected zone.

underwater stage. A suspended underwater platform which supports a diver in the water.

underwater welding. Any welding performed below the water surface.

underwater work site. The location underwater where work is performed.

visual examination. A general term which includes both indirect and direct examination of the surface of a weld.

welder/diver. A person who is qualified in accordance with this Code to perform underwater welding.

welding system. All welding equipment and supplies used for making a weld.

weld type. A group of groove or fillet welds having similar mechanical properties, similar surface appearance requirements and quality, and capable of withstanding similar operating conditions.

wet-backed weld joint. A weld joint contained in a dry chamber when a water-wet surface is less than 150 mm (6 in) from the joint.

wet welding. Welding at ambient pressure with the welder/diver in the water and with no mechanical barrier around the arc.

Annex C (Informative)

Commentary on AWS D3.6M:2010, *Underwater Welding Code*

This annex is not part of AWS D3.6M:2010, *Underwater Welding Code*, but is included for informational purposes only.

Foreword

This commentary on AWS D3.6M:2010, *Underwater Welding Code*, is primarily intended to provide clarification of its provisions, requirements, and intended applications. In addition, the Commentary provides background information, where appropriate, to explain the rationale behind its unique requirements—especially those which differ from the common codes and specifications dealing with conventional surface, or “in-air” welding. In so doing, an attempt is made to reflect the bases for the requirements as discussed in D3B Subcommittee meetings and as substantiated by related research and development or practical application of the Code.

This Commentary is not intended to supplement the requirements of AWS D3.6M, but rather to provide an informative document for explanation, interpretation, and application of the Code; as such, none of its provisions are binding. Comments or inquiries pertaining to this Commentary are welcome and should be addressed to the Secretary, D3B Subcommittee, as indicated in the Foreword to this Code.

Preface

It is the intention of the D3B Subcommittee on Underwater Welding to revise this Commentary with each revision of the Code. In this manner, the bases for all substantive changes will be provided concurrent with the changes.

C1. General Provisions

C1.4 Application

C1.4.1 The early editions of the Code contained various references to “Owner,” “Customer,” and “Inspector.” These terms were intended to (respectively) relate to: (1) contractual, (2) engineering, design and approval, and (3) inspection aspects of the work. The subcommittee decided that all responsibilities should be under the auspices of one party—termed the Customer—who is responsible for formally delegating defined scopes of responsibility to those whom the Customer selects. To assist the user of this Code in identifying the nature and scope of individual responsibilities assigned to the Customer, a detailed listing of reference paragraphs has been provided in the Index under the heading “Customer.”

C1.6 Welding Process

C1.6.1 The five welding processes covered by this Code are all suitable (under certain conditions) for dry underwater welding; however, only two have had substantial success in wet underwater applications—shielded metal arc welding (SMAW) and flux cored arc welding (FCAW).

C1.10 Standard Units of Measure

In this Code, a “soft” conversion between United States Customary and SI Units is generally reflected in the text—as well as in figures which do not have an ISO counterpart—in order to make the document more user-friendly. The soft conversion utilizes metric or U.S. integers and sizes wherever exact conversion is not technically necessary.

The metric figures incorporate, where applicable, equivalent standard metric coupon/specimen shapes and dimensions when provided by applicable ISO Standards. In such cases, related test acceptance criteria have been adjusted to reflect disproportionate differences. Where a more appropriate metric standard detail exists, the customer is at liberty to utilize it—provided, of course, the test data is properly reconciled with the results stipulated in the Code. In such cases, the Subcommittee requests that the more appropriate metric standard be brought to its attention for future incorporation into the Code.

C2. Classification and Design of Welded Connections

C2.1 Classification of Welds

The categorization of welds for underwater welding posed several questions for the D3B Subcommittee on Underwater Welding, including whether to categorize welding by the different processes or procedures used to produce the weld or to establish levels of quality reflecting the mechanical and physical properties achievable with underwater welding processes. The subcommittee ultimately chose the latter criterion as having the most meaning to the user community.

For the majority of underwater welding, it was decided to specify three two types of welds representing three two levels of quality: Type A, Type B, and Type CB welds. It was also decided to provide the user with all of the qualification, installation, and examination requirements pertinent to these three types of welds in one stand-alone set of requirements, or Code. In addition, it was recognized that in some situations the user would require a weld that met all of the obligatory codes and standards applicable to a weld made on the surface. Type O was created for these welds and was intended to imply that “other” requirements applied in addition to the unique requirements pertinent to the underwater environment. Since these four categories generally reflected levels of quality, the term was changed, in the 1993 Edition of AWS D3.6, from *type* to *class*.

C2.1.4 Class A Welds. Class A defines a stand-alone set of requirements for underwater welds intended to be comparable to welds produced above water in accordance with AWS D1.1 or ASME Section IX. This class of groove weld is qualified on the basis of visual and radiographic examination, reduced-section tension, all-weld-metal tension, 2T to 3–1/3T bends, macroetch, hardness and impact tests. Testing for fillet welds include fillet-weld-break and fillet-weld-shear tests. The acceptance criteria for all qualification testing, nondestructive examination, and inspection is very similar to the codes covering above-water welding.

Class A welding procedures are generally specified for most dry hyperbaric welding of ferritic and austenitic base metals (routinely for depths to 500 ft/150 m and in some cases to 2000 ft/600 m) and for shallow (less than 50 ft/15 m) *wet* shielded metal arc or flux-cored arc welding of austenitic stainless steels. However, some success has been achieved in qualifying *wet* flux cored arc welding for ferritic steel base metals to the requirements of Class A, and there has been limited success in *wet* SMAW welding of mild steel base metals meeting the Class A bend test criteria.

C2.1.5 Class B Welds. Class B defines an intermediate set of mechanical and examination requirements representing a slightly lower level of quality, but still resulting in a weld of predictable strength. Class B welds are intended for less critical applications where reduced ductility and increased porosity can be tolerated. The suitability of Class B welds for a particular application is intended to be evaluated on a fitness-for-purpose basis. Class B welds are qualified similarly to Class A, except that a larger bend radius (typically 6t) is used for qualification testing, and the acceptance limits of porosity for visual and radiographic tests are expanded. Class B requirements are generally applied for most *wet* welding of ferritic steel base metals at depths of from 0 to 50 m (150 ft), with occasional applications to depths of 100 m (325 ft). Class B is also used for welding of austenitic stainless steels at depths to about 25 m (75 ft).

C2.1.6 Class C Welds. The Foreword of ANSI/AWS D3.6:1999 starts with the statement, “In 1975, the AWS Committee on Marine Construction requested the Subcommittee on Underwater Welding to establish a standard reflecting state-of-the-art technology relative to underwater welding.” When the first AWS D3.6 draft was prepared in the late 1970s, it included four types of welds. Included was Type C, which on the low end of the scale, did reflect at that time, the state-of-the-art of wet welding. Today, Type or Class C welds are no longer related to the state-of-the-art of wet welding and have therefore been removed from the scope of ANSI/AWS D3.6.

C2.1.7 Class O Welds. Class O invokes the qualification, installation, and examination requirements, including acceptance criteria, of some “other” code or standard applicable to above-water welding such as API-1104, as specified by the Customer. However, since the essential variables that must be incorporated into an underwater welding procedure are much more extensive than for a surface weld, this Code takes precedence relative to essential variables for procedure and performance qualification.

Class O welding procedures are generally applicable to the same underwater welding conditions as noted above for Class A welds.

C3. Workmanship

C3.3 Assembly

C3.3.1 Dry Welding. The standard tolerances for joint preparation and fit-up provided in Figure 3.1 may be applied to dry welding. Alternatively, during development of dry welding procedures, the most restrictive groove angle, root opening, and root face may be tested [see A.1.(f) of Table 5.1]. In either case, the WPS must identify the tolerances to be applied.

C3.3.2 Wet Welding. Joint designs typically utilized in the performance of underwater wet welding are generally more restrictive in nature, due to the limitations of the process. Position, steaming, bubbling effects, arc pressure, electrode diameter, deposition rates, and many other variables significantly affect the ability to make sound weldments in this environment. Consequently, joint designs should be as simple as possible, minimizing use of the overhead position. For wet welding, joint assembly and fit-up tolerances are critical and must be established during qualification testing. This Code does not require that the extremes be tested, only that the most restrictive configuration be tested and qualified [see A.1.(e) of Table 5.2]. However, the range or limits must be specified in the WPS (see reference 5.9.4).

C3.4 Confirmation Weld

The purpose of the confirmation weld is to confirm that the welding system to be utilized at the underwater work site is functioning properly. It is not intended to be a retest of the procedure nor of welders who have already been qualified.

C3.5 Dimensional Tolerances

Minimum specified size and length of welds must be satisfied to ensure that required design strengths are achieved. Limitations are imposed on the size of fillet welds and lengths of all welds for purposes of avoiding excessive distortion of the welded members.

C3.7 Tack Welds and Temporary Welds

C3.7.1 Since it is difficult, especially in wet welding, to completely remelt tack welds, it is essential that all tack welds be made with a fully qualified procedure. Cracked tack welds should never be welded over since they can be generating points for faults and progressive cracking.

C3.8 Repairs

For weldments requiring repair underwater, it is essential that excavation and subsequent preparation for welding be accomplished properly and carefully. Excessive excavation for wet welded repairs can result in burnthrough which may be impossible to repair properly. In some cases, use of a mock-up sample may be necessary to pre-qualify a repair procedure. By using a properly developed and qualified repair procedure, most problems associated with the repair of weldments can be avoided, with the integrity of the finished product ensured.

C3.10 Arc Strikes

Arc strikes occurring outside of the weld area can result in untempered hardened and embrittled areas having a potential for micro-fissures which can cause crack-initiation and propagation. All arc strikes encountered during underwater welding must be removed with light grinding or filing.

C4. Technique

C4.1 Filler Metal

The two most popular electrodes for wet welding of carbon steel are the E6013 and E7014. For dry hyper-baric welding, some low-hydrogen electrodes such as E7018M, are produced with improved moisture-resistant flux coatings. However,

just meeting the AWS requirements for these classifications does not mean that a particular filler metal will be capable of producing the desired results underwater. Even a single manufacturer can produce several different types of filler metal fulfilling the requirements for a single AWS classification, and only one—or even none—may be suitable for underwater use.

Even for dry hyperbaric welding, moisture resistance of the flux coating can have a significant effect on the electrodes ability to resist humidity, such as that found in the underwater habitat. For these reasons, the Code requires any change in electrode (AWS classification, manufacturer, manufacturer's trade name) to be an essential variable (reference clause 3 of Tables 5.1 and 5.2).

C4.1.2 Waterproofing of electrodes, particularly for wet welding, is common practice. There are many different types and methods of waterproofing, and the different types or methods of coatings react in various ways on different electrodes. For example, one type of coating may work well on a mild steel electrode and not work at all on stainless steel. Even different coating thicknesses will cause a change in the way an electrode performs; a heavy coating will cause the arc to elongate, resulting in an increase in the arc voltage.

C4.1.3 Transporting of electrodes for dry underwater welding is an essential variable due to the fact that getting the electrode to the work site could adversely affect the quality of the rod. Also, when a pressurized container is used for transport in either wet or dry underwater welding, the media used to pressurize the container should be the same as used during qualification, including moisture content of the pressurizing media. Once the rod is at the work site, it is important that the storage of the electrodes be consistent with that utilized during qualification testing, since once an exposure and storage method has been established, any variation in that process creates unknown variables that can have adverse effects on the mechanical properties of the production welds.

Standard electrode coatings and supplemental coatings (particularly those used for waterproofing purposes) have been found to deteriorate after lengthy submergence in the wet environment or high-humidity atmospheres associated with dry underwater welding. Since such deterioration adversely impacts the weldability of the filler metal, the time of exposure underwater is also considered an essential variable and is required to be established during qualification testing and defined in the WPS.

Austenitic Stainless Filler Metal. Because of the influence of ferrite in preventing hot-cracking in austenitic materials, average delta ferrite content of austenitic filler metal is often considered an important factor in wet underwater welding of stainless steel, and even when stainless filler metal is used on carbon or alloy steel base metals. Use of austenitic filler metal with average ferrite content of 7FN or greater has proven to significantly reduce the potential for hot-cracking. The amount of undiluted delta ferrite, or Ferrite Number, can be determined from an analysis of the chemical composition of the weld metal using the latest WRC Constitution Diagrams or from direct ferrite measurement of weld metal in accordance with AWS A5.4/A5.4M, *Specification for Stainless Steel Electrodes for Shielded Metal Arc Welding*. In cases of welds involving dissimilar metals (e.g., carbon steel welded with austenitic stainless steel or nickel electrodes), the potential for galvanic corrosion should be considered.

C5. Qualification—Procedure and Performance

Part I

General Requirements

Underwater welding procedure and performance qualification requirements must take into consideration factors which are not applicable to surface welding qualification testing. Such factors as increased weldment cooling rate, arc constriction due to pressures at depth, and high-hydrogen arc atmospheres, among others, require some degree of additional qualification testing as compared with surface welding.

The qualification requirements of this Code consider the fact that the final welded fabrication will not be as accessible for subsequent inspection as a fabrication welded on the surface. Accordingly, these requirements are intended to provide a reasonable degree of confidence in the lifetime structural integrity of weldments produced using the procedures and personnel qualified in accordance with this Code.

C5.2 Previous Qualification

It is up to the Customer to ensure that all of the applicable essential variables (for both procedure and performance qualifications) are met. The review and approval of previous qualification documents should be carried out by someone who is familiar with reviewing welding documents and with the requirements of this Code.

C5.3 Performance Qualification

If a welder/diver qualifies to a class A procedure and all essential variables from Table 5.2 are the same the Welder/diver is also qualified to weld production welds that are designated Class B.

C5.5.2 Limitations on Essential and Nonessential Variables. The number and type of essential variables are quite different for underwater welding than for surface welding. This is necessary because of differences in welding in the underwater environment and the effects of changes (i.e., depth, diving mode) in the underwater environment. It will be noted that filler metal manufacturer is an essential variable; this is because filler metals from different manufacturers, although of the same AWS classification, may produce different results underwater (see Commentary, 4.1). It will also be noted that base metal chemical composition controls are generally tighter with respect to the essential variables; this is due to the higher propensity for base metal cracking as cooling rates are increased (see C5.6.1.3).

Almost every variable that can have an influence on heat input is essential for wet welding. Better welding quality is typically achieved using small diameter electrodes in a stringer-bead technique. Multi-layer beads—especially using promptly applied temper-bead techniques—are also very beneficial in wet ferritic applications, as are quickly applied postweld heat treatments. Such methods can reduce the amount of absorbed hydrogen, as well as reduce hardness in the heat-affected zones of the base metal.

C5.6 Procedure Qualification Variables

C5.6.1 Requirements for Base Metals

C5.6.1.3 Carbon steels preferred for general-purpose wet welding are those with a carbon content of less than 0.10% and a Carbon Equivalent (CE) of less than 0.37%. Steels with CE greater than 0.37% have a tendency for hydrogen-induced cold cracking (HICC), depending on the carbon content, and may require utilization of special materials and/or techniques. Carbon steels with a carbon equivalent approaching 0.40 have been successfully wet welded with ferritic electrodes where the carbon content was less than 0.10. Since the carbon is the strongest factor in influencing HICC in the carbon equivalent formula, a low carbon content can justify a higher carbon equivalent. Based on these observations, the importance of the use of qualification test base material, with a carbon content and carbon equivalent at least as high as that of the material to be welded in production, cannot be overemphasized.

The cracking effect due to hydrogen contamination can be reduced by application of the stringer bead technique or use of temper beads. In the latter case, it is essential that the tempering layer be applied very soon (typically less than one minute) after deposition of the previous bead. Another approach in the elimination of HICC is the use of nickel-based electrodes. The nickel can hold more hydrogen in solution than ferritic weld metal, greatly reducing the hydrogen in the heat-affected zone of the carbon steel base metal. Nickel-based electrodes have been successfully used on carbon steels and low alloy quenched and tempered steels with carbon equivalents over 0.50.

With respect to underwater dry chamber or dry habitat welding, preheating and/or postheat treatment can eliminate the potential effects of a high carbon equivalent. Again, qualification testing using a base material, with a carbon content and carbon equivalent at least as high as that of the material to be welded in production, is important.

C5.6.1.4 When the following elements are known to exist in the base metal in amounts exceeding the indicated weight percentages, consideration should be given to requiring similar percentages of those elements in the welding procedure qualification test plates:

- (1) cerium, 0.03%
- (2) chromium, 0.25%
- (3) copper, 0.40%
- (4) lead, 0.05%
- (5) molybdenum, 0.15%
- (6) nickel, 0.40%
- (7) niobium (columbium), 0.05%
- (8) phosphorous, 0.05%
- (9) sulfur, 0.05%

- (10) titanium, 0.05%
- (11) vanadium, 0.12%

The presence of elements above these percentages is generally indicative of a special alloy or nonferritic base metal.

C5.6.2 Depth Range

C5.6.2.1 The gas absorption of molten material is directly related to the surrounding pressure and the temperature of the molten material. The higher the surrounding pressure or temperature of the liquefied materials, the more the gas that can be absorbed. This is a reversible process. High cooling rates can therefore lead to entrapped gas due to a reduced solubility in solidified material. During solidification, the entrapped gas cannot evaporate from the warmer inner part through the rigid shell. This will then lead to a gas bubble (pore) in the cooled weldment. The deeper the operational depth in which the welding process is applied, the higher will be the pore formation.

Because different filler metals have different levels of sensitivity to water depth/pressure, Table 5.3 has different depth limitations for mild steel, austenitic stainless steel, and other filler metals. The limitations are based on the experience that wet welding procedures have been qualified with carbon and low alloy steel electrodes down to 325 ft (100 m).

The maximum qualification depth for nickel-based wet welding electrodes is yet to be established. All-position fillet welding has been qualified to a depth of 14 m (45 ft). All-position groove welding has been qualified to a depth of 10 m (33 ft). Testing to date indicates that 10 m (33 ft) will be the maximum qualification depth for overhead groove welding due to propensity for excess porosity. Maximum qualification depth for austenitic stainless steel filler metal is reported to be 30 m (90 ft).

C5.8 Position of Test Welds

The International Standard Organization (ISO) welding position designations (reference ISO 6947) are used in this document. There presently are no ISO designations for 6GR (for T-, Y-, K-connection full-penetration groove joints).

In wet welding, the flat and horizontal positions are usually the simplest with which to weld in the underwater environment. Vertical-down, because of the rapid cooling effects of water, is usually the preferred direction for wet underwater welding, resulting in good welder visibility and a bead with soft, smooth shape. Uphill welding typically results in increased undercut and rough bead transitions with a propensity for slag inclusions. Overhead is the most difficult position in wet welding, due to presence of gas bubbles which can obstruct the visibility of the arc and weld puddle, causing the welder to utilize an increased arc length.

C5.9 Joint Configuration

Table 5.1 (dry welding) and Table 5.2 (wet welding) include joint configurations as essential variables. Joints that may be welded underwater can vary from simple to complex. Joint design is included as an essential variable due to the effects of groove shape on the quality of the weld that is produced.

C5.11 Preparation and Testing of Specimens

C5.11.1 Reduced-Section Tension Specimens. Reduced-section tension specimens are used to confirm the tensile strength suitability of the underwater weldment for the intended application. The dimensions of the reduced-section tensile specimens are identical to those required by ANSI/AWS D1.1. To comply with the requirements of ISO 4136, the width of the tensile specimens for metric plate tests was increased to 25 mm (1 in).

C5.11.2 Macroetch Test. Macroscopic examinations ensure, in addition to overall weld quality, the absence of cracking in the weld metal and adjacent base metal. Hydrogen-induced underbead cracking can be a problem, especially when wet welding the higher carbon equivalent base metals.

Suitable etchants may include those described by ASTM E 340, *Standard Test Method for Macroetching Metals and Alloys*, ISO 4969, *Macroscopic Examination by Etching With Strong Mineral Acids*, ANSI/AWS B2.1 *Specification for Welding Procedure and Performance Qualification—Annex F*, or ASME Boiler and Pressure Vessel Code, Section IX QW-470.

When Macroetch specimens are to be used for hardness testing, the two machined surfaces must be parallel to produce meaningful results.

C5.11.3 Root-, Face-, and Side-Bend Specimens. Transverse bend tests are performed to verify the soundness and ductility of the weld metal, weld/base metal interface, and heat-affected zones (HAZ) of the underwater weldment. Since even minute surface impressions can drastically influence bend test results, consideration should be given to the final finish of the tested surface. Also, the direction of any surface finishing or polishing should be aligned along the longitudinal axis of the specimen.

C5.11.3.2 The wraparound jig has been found to be particularly beneficial when the test assembly consists of two different plate or pipe materials having significantly different yield strengths, or when the deposited weld metal has significantly different as-deposited yield strength from the base metal being welded.

C5.11.4 All-Weld-Metal Tension Test. All-weld-metal tension tests are specified for Class A and Class O welds to evaluate potential hydrogen damage, and to ensure that a particular filler metal meets the ultimate tensile strength, yield strength, and elongation requirements specified at the depths and in the environment applicable to the actual welding.

If the all-weld-metal specimen is machined from a procedure qualification test weld, it may be necessary to prepare a smaller specimen proportional to the specified size. In this case, the diameter, D, should be the largest able to be machined from the test weld, and the L/D ratio must meet that specified.

C5.11.5 Charpy Impact Tests. The orientation of the Charpy Impact specimen relative to plate rolling direction can have a pronounced effect on the measured impact toughness of the HAZ. Maximum toughness is generally obtained when the fracture plane is perpendicular to the rolling direction. Some material specifications and codes give different minimum toughness requirements for transversely and longitudinally oriented specimens.

C5.11.6 Hardness Test. In underwater welding, high hardness is most likely to be found in the HAZ of the base metal; as carbon content and carbon equivalent increase so does HAZ hardness. Developmental work has demonstrated that with special temper bead welding techniques, Class B wet welds can be made on high carbon (0.20%)/high carbon equivalent (0.46%) base metal that meets AWS D3.6 specified maximum hardness of 325HV10 for Class A welds.

C5.11.7 Fillet Weld Break Test. The fillet weld break test is a simple method for evaluating the soundness of fillet welds. If it fractures through the weld, visual examination of the fracture surfaces provides information on the amount and size of porosity, slag inclusions, and root penetration.

C5.11.8 Fillet Weld Shear Strength Test. Fillet weld shear strength tests are required for fillet weld procedure qualification in order to ensure that the extent of any weld discontinuities and the influence of the underwater environment do not result in a strength level failing to meet the specified requirements. Position of welding may have a significant effect on the properties of the weld, and the Customer should take this into consideration in design and in selection of the first and other positions during procedure qualification.

C5.11.9 Bridge Bend Test. An optional base metal evaluation test for temporary welds or welds of no structural significance intended to demonstrate that a weld will not act as a fracture initiation site. It may also be used to verify soundness of heat-affected zones for weld overlays. The Code requires the carbon content and carbon equivalent of the test plate to be not less than the carbon content and carbon equivalent of the material to be welded in production. In addition, the test plate should be of the same material type and grade, as well as heat-treated condition (normalized vs. as-rolled) as that to be welded in production.

C5.13 Supplemental Requirements

Supplemental requirements are sometimes specified in the contract to verify conformance with specific design criteria applicable to unique situations. The most common supplemental testing requirements imposed on procedure qualification are Hardness Testing (specifically identified as to type, quantity, and location of measurement points), Charpy Impact (including specific quantity, and location of specimens and notches) and special fracture toughness tests such as CTOD (Crack Tip Opening Displacement).

C5.16 Limitations of Variables

The mandatory variables identified in the Code have been revised to include only those related to skill and ability of the welder/diver and to exclude those which relate more to physical stamina. Variables which have been excluded include working environment (wet, dry chamber, dry habitat), change in diving suit protection, thermal environment and length of exposure time, and reduction support provided to the welder/diver.

Although these conditions can have a significant impact on a person's ability under certain circumstances, they are not always applicable and are no longer classified as essential. They should, however, be considered as potential supplemental essential variables whenever more severe production conditions exist.

(1) A welder who needs to utilize GTAW welding on a job and is only currently qualified for the SMAW process cannot use the GTAW process until he/she qualifies on that additional process.

(2) Direction of vertical travel applies only to the PF and PG (3G, 3F, 6G, and 5F positions where the vertical weld orientation may be encountered), and H-L045 and J-L045 (6G) positions. A welder who only qualifies welding vertical downhill is not qualified to weld vertical uphill, or vice versa.

C5.21 Period of Effectiveness

The Code requires that for qualified welder/divers to remain qualified, they must produce at least one inspected and accepted fillet weld (to retain fillet weld qualification) or groove weld (to retain fillet and groove weld qualification) with each procedure at least once every 90 days. Application of a bead-on-plate or similar "process use" applications are not acceptable for purposes of retaining performance qualifications for underwater welding.

C6. Inspection

Part I

General Requirements

C6.8 Personnel Qualification

Underwater ultrasonic examination is often accomplished as a team effort, requiring considerable skill on the part of a topside ultrasonic inspector employing clear, effective communication with a diver. In this case, a qualified, certified ultrasonic inspector performs the testing with a diver serving to position the transducer at the required locations on the tested component. The diver also provides comments and input on conditions such as pitting, biofouling, or coating failures. All data interpretation, equipment adjustment, etc., is performed topside by the inspector whose qualification should include demonstration of ability to effectively communicate with and provide direction to a relatively inexperienced diver manipulating the transducer.

Part II

Visual Examination

C6.9 General

The logistics and expense associated with diving support for third party inspection personnel often necessitate that remote video examination methods be employed for inspection of underwater welding. Recent technological improvements, such as solid-state video pickups and enhanced white light sources, permit continuous viewing of the welding operation, which can be advantageous to the experienced inspector in confirming the overall acceptability of an underwater weldment. Such video methods, combined with audio communication with and assistance from the welder/diver, may also be employed by a topside inspector to verify dimensions, weld sizes, and weld locations.

C6.10 Procedure

Remote video inspection procedures for critical applications often require in-situ calibration by demonstrating ability to detect a fine object, such as a one-mil wire positioned on the surface of the weld to be examined. When magnified video is used in cases where surface examination techniques would normally be used (such as for wet underwater stainless steel weldments) the inspection procedure and visual inspectors should be qualified by demonstrating ability to detect sample discontinuities rejectable by the surface examination acceptance criteria.

Part III

Radiographic Examination

C6.12 Procedure

It is important that radiographic equipment identified in the procedure be designed and constructed for underwater (wet or hyperbarically pressurized) environments. Improperly contained radiation sources can become flooded, resulting in contaminated spill hazards. Cathode ray tubes, on the other hand, usually necessitate very stable mounting. Lengthy

exposure time and even thin films of water can adversely affect the results. In all cases, there is a potential for film anomalies caused by static-electric charging of film during transport between the surface and the underwater work site.

Part IV

Ultrasonic Examination

C6.13 General

Other ultrasonic methods which may be approved by the Customer include ANSI/AWS D1. 1, *Structural Welding Code—Steel*, paragraph 6.15, Ultrasonic Equipment.

C6.14 Procedure

Ultrasonic examination procedures should consider routine maintenance necessitated by use in the underwater environment. In particular, attention should be paid to the fact that coax cables will deteriorate after several weeks exposure to salt water, and may require frequent testing to establish need for replacement.

C6.14.1 Minimum Requirements. Procedures must address required surface preparation, which can be dependent upon the type of examination used. For example, use of shear wave for flaw detection could require more extensive surface cleaning. Also, the procedure must consider the fact that certain geometries utilized for underwater wet welds may not be conducive to ultrasonic examination techniques.

The following should be considered in the selection of equipment for use in the underwater environment: Suitability for use with long cable lengths, watertightness of transducer bodies, waterproof sealing of transducer connections (e.g., use of self-vulcanizing rubber tape) and use of a local ultrasonic CRT screen to help the transducer direction. In some cases it may be beneficial to utilize a superimposed video image of transducer manipulation with the ultrasonic CRT screen.

Part V

Magnetic Particle Examination

C6.16 Procedure

Since the apparent weight of magnetic particles is less in water than in air, the particles are more mobile in the water and “find” cracks or other unacceptable indications more readily. Additionally, since magnetic forces are unaffected by water and gravitational forces are reduced, leakage fields are more effective in holding particles at the site of a discontinuity. Underwater magnetic particle equipment typically consists of permanent magnet or waterproofed alternating current (ac) yokes with articulating legs, utilized with a slurry of magnetic particles and water. A white or ultraviolet light source is normally required to provide adequate lighting of the inspected areas. Magnetic particle examination procedures used in underwater applications require prior verification testing of field strengths using metallic field strength indicators. In addition, it is essential that ac circuits be totally isolated to avoid the possibility of electrocution in the underwater environment.

Part VI

Eddy Current Examination

C6.17 General

Eddy current testing can be effective in detecting the presence of cracks open to the surface, but may require supplemental magnetic particle examination, where feasible, to provide visual indication of the discontinuity for removal purposes. Eddy current examination can be particularly advantageous for inspecting through coatings, in poor visibility conditions, and at locations affected by wave action or sea currents.

Geometric shape and surface finish of the weldment must be considered in selection of equipment for performance of eddy current examination in the underwater environment. In addition, the following should be considered.

Use of a phase display for differentiation of surface conditions, durability and compatibility of the probe, waterproofing of the probe, suitability of equipment for driving the signals over long cable lengths. The probe should be capable of examining the toes of welds, and the probe-coil arrangement should be of a proven design (e.g., reflection coil). In some cases, it may be worthwhile to superimpose a video image of the probe manipulation with the eddy current CRT phase display.

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Annex D (Informative)

Recommended Guidelines for Safety in Underwater Welding

This annex is not part of AWS D3.6M:2010, *Underwater Welding Code*, but is included for informational purposes only.

The following recommendations reflect the consensus opinion of industry representatives on the AWS D3B Subcommittee on Underwater Welding. AWS and the Subcommittee make no assurances regarding accuracy, completeness, or thoroughness of these recommendations, and expressly disclaim responsibility for any injury or damage arising from adherence to these recommendations. Users should make an independent determination as to the appropriateness of these recommendations, both generally and as applied to a specific situation.

D1.0 Scope

This annex is limited to recommended safe practices specifically related to underwater welding and associated work activities performed in either a dry (hyperbaric) or a wet environment. Although these guidelines are presented as recommendations, many of their provisions are mandatory, depending on the legal jurisdiction applicable at the work location. For additional recommendations applicable to safety in underwater welding, and for requirements and recommendations applicable to diving and diver safety, see the references at the end of this annex.

D2.0 Safe Practices/Operations Manual

Each contractor involved in diving activities involving underwater welding should develop and maintain a safe practices/operations manual which reflects, as a minimum, all legal regulations applicable to the specific work location. This manual should be made available at the dive location to each dive team member. The operations manual should include, in addition to diving safety procedures, procedures dealing with the use of hand-held power tools and welding and thermal cutting equipment.

D3.0 Communications

Two-way communications should be available and accessible at any diving or hyperbaric work site in order to engage emergency services as required. In addition, when underwater welding or cutting is to be performed, constant two-way voice communications should be maintained between the diver and a topside supervisor or tender in control of the welding or cutting equipment.

D4.0 Electrical Equipment

All underwater electrical equipment powered from topside should be equipped with a ground fault interrupter (GFI), between the power source and the tool. Alternating current (ac) circuits should never be used for manual or diver-assisted welding or cutting activities beneath the surface of the water.

Welding machine frames should be securely grounded. Welding and cutting cables, electrode holders, and connections should be properly insulated and capable of carrying the maximum current required for the work.

Welding and thermal cutting electrical circuits should have a positive disconnect switch. The switch should remain open at all times except during actual welding or cutting. When an electronically actuated switch is used for routine circuit activation, a manual emergency disconnect should be within easy reach of the person tending the switch.

D5.0 Hand-Held Power Tools

All hand-held electric power tools should comply with the requirements of D4.0, above. All hand-held hydraulic and pneumatic power tools should have a constant pressure switch or control which causes the tool to stop upon release.

D6.0 Preparation for Work

A Job Hazard Analysis, or tailboard, should be held prior to each diving task, before any hand-held power tools are used, and before any welding or thermal cutting is performed.

A predefined method for welder direction to energize and de-energize the welding or cutting circuits, including supervisor or tender acknowledgment of action taken, should be established and agreed upon prior to any underwater welding or electrode-thermal cutting. It should be emphasized to the welder that the circuit must be opened prior to touching or changing any electrode.

All required equipment should be inspected prior to use to ensure that it is in safe operating order. All electrical devices and umbilicals should be inspected carefully before all operations, and prevented from becoming abraded or cut over sharp edges. GFI circuits should be tested prior to, and at regular intervals throughout, the operation.

All hand-held electrical tools and equipment, including hand-held electrical equipment inside bells and habitats, should be de-energized at the surface before being placed into or retrieved from the water.

Insulated gloves should be worn by the diver while engaged in underwater welding and cutting. Insulated gloves should also be worn whenever handling any electrical equipment or cables underwater—including de-energized components.

Prior to thermal cutting or welding on closed compartments, structures or pipes which contain a flammable vapor or in which a flammable vapor may be generated by the work, should be vented, flooded, or purged with a mixture of gases which will not support combustion. (This is not mandatory for “hot-tapping” operations.)

Underwater habitats should be continuously monitored for the presence of excessive amounts of toxic, asphyxiating, narcotic, and explosive gases. For example, these include, argon and carbon dioxide (used by the welding procedure), helium (from mixed breathing gas), nitrogen (when used to offset partial pressure in the habitat), welding fumes including carbon monoxide (from the welding process), and hydrogen and oxygen (due to possible explosion).

D7.0 Performance of Work

Hand-held power tools should only be supplied with power from the dive location when requested by the diver.

A current supply switch to interrupt the current flow to the welding or thermal cutting electrode should be tended by a dive team member in voice communication with the diver performing the welding or cutting, and kept in the open position except when the diver directs its closure for performance of welding or cutting.

D8.0 Inspections and Examinations

Radiographic examination procedures should address the safety aspects of controlling and using radioactive sources. Equipment used to contain the sources should be designed and constructed in accordance with applicable regulatory standards for use in the underwater environment.

Use of alternating current (ac) for performance of diver-assisted examinations should be avoided. Where they are used, ac circuits should be totally isolated to prevent the possibility of electrocution.

D9.0 References

- (1) AWS *Welding Handbook*, 8th Ed., Volume 3, Chapter 10.
- (2) ADC Consensus Standards—Latest Edition, Association of Diving Contractors, Houston, TX.
- (3) OSHA 1910 (Subpart T)—Occupational Safety and Health Act. (Also issued as 29CFR Chapter XVII.)
- (4) 46CFR Chapter 1, Subchapter V—Marine Occupational Safety and Health Standards, Part 197—Code of Federal Regulations.
- (5) Code of Practice for the Safe Use of Electricity Underwater, Association of Offshore Diving Contractors.

Annex E (Informative) References

This annex is not part of AWS D3.6M:2010, *Underwater Welding Code*, but is included for informational purposes only.

The following documents may be referred to for additional information concerning diving, construction standards, welding, and testing.

A. Construction Standards

- (1) *ANSI/ASME Boiler and Pressure Vessel Code*, American Society of Mechanical Engineers, New York, NY
- (2) *API RP 2A, Recommended Practice for Planning, Designing, and Constructing Fixed Offshore Platforms*, American Petroleum Institute, Washington, DC
- (3) *Guide for Building and Classing Fixed Offshore Structures*, American Bureau of Shipping, Paramus, NJ
- (4) *Rules for Building and Classing Offshore Mobile Drilling Units*, American Bureau of Shipping, Paramus, NJ
- (5) *Rules for Building and Classing Steel Vessels*, American Bureau of Shipping, Paramus, NJ

B. Diving

- (1) 29 CFR 1910, *Occupational Safety and Health Standards*, Subpart T, Commercial Diving Operations
- (2) 46 CFR 197.200, *U.S. Coast Guard Commercial Diving Regulations*
- (3) *Consensus Standards for Commercial Diving Operations*, Association of Diving Contractors, Houston, TX
- (4) NAVSHIPS 0994-LP-001-9010, *U.S. Navy Diving Manual*, Volume 1: Air Diving Volume 2: Mixed-Gas Diving
- (5) *NOAA Diving Manual: Diving for Science and Technology*, U.S. Department of Commerce

C. Destructive Testing

- (1) AWS B4.0, *Standard Methods for Mechanical Testing of Welds*, American Welding Society, Miami, FL
- (2) AWS B4.0M, *Standard Methods for Mechanical Testing of Welds*, American Welding Society, Miami, FL
- (3) ASTM E 8M, *Standard Test Methods for Tension Testing of Metallic Materials (Metric)*, American Society for Testing and Materials, Philadelphia, PA
- (4) ASTM E 18, *Standard Test Methods for Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials*, American Society for Testing and Materials, Philadelphia, PA
- (5) ASTM E 23, *Standard Methods for Notched Bar Impact Testing of Metallic Materials*, American Society for Testing and Materials, Philadelphia, PA

- (6) ASTM E 190, *Standard Method for Guided Bend Test for Ductility of Welds*, American Society for Testing and Materials, Philadelphia, PA
- (7) ISO 148, *Steel—Charpy Impact Test (V-Notch)*
- (8) ISO/R 442, *Verification of Pendulum Impact Machines for Testing Steels*
- (9) ISO/R 615, *Methods for Determining the Mechanical Properties of the Weld Metal Deposited by Electrodes 3.15 mm or More in Diameter*
- (10) ISO 716, *Metallic Materials—Hardness test—Verification of Rockwell Hardness Testing Machines* (scales A-B-C-D-E-F-G-H-K)
- (11) ISO 4964, *Steel—Hardness Conversions*
- (12) ISO 5173, *Fusion Welded Butt Joints in Steel—Transverse Root and Face Bend Test*
- (13) ISO 6507-1, *Metallic Materials—Vickers Hardness Test—Part 1: Test Method*
- (14) ISO 6507-2, *Metallic Materials—Vickers Hardness Test—Part 2: Verification of Testing Machines*
- (14) ISO 6508, *Metallic Materials—Hardness Test—Rockwell Test* (scales A-B-C-D-E-F-G-H-K)
- (15) ISO 7500-1, *Metallic Materials—Verification of Static Uniaxial Testing Machines—Part 1: Tensile Testing Machines*
- (16) ISO/TR 10108, *Steel—Conversion of Hardness Values to Tensile Strength Values*
- (17) ISO/TR 12735-1, *Mechanical Testing of Metals—Symbols Used with Their Definitions—Part 1: Symbols and Definitions in Published Standards*
- (18) *Welding Handbook*, 8th ed., Volume 1, Welding Technology, Chapter 12, Testing for Evaluation of Welded Joints, American Welding Society, Miami, FL

D. Nondestructive Examination

- (1) ANSI/AWS B1.10, *Guide for the Nondestructive Inspection of Welds*, American Welding Society, Miami, FL
- (2) ANSI/AWS B1.11, *Guide for the Visual Inspection of Welds*, American Welding Society, Miami, FL
- (3) ASTM A 577, *Specification for Angle-Beam Examination of Steel Plates*, American Society for Testing and Materials, Philadelphia, PA
- (4) ASTM A 578, *Specification for Straight Beam Ultrasonic Examination of Plain and Clad Steel Plates for Special Applications*, American Society for Testing and Materials, Philadelphia, PA
- (5) ASTM E 94, *Recommended Practice for Radiographic Testing*, American Society for Testing and Materials, Philadelphia, PA
- (6) ASTM E 142, *Controlling Quality of Radiographic Testing*, American Society for Testing Materials, Philadelphia, PA
- (7) ISO 1027, *Radiographic Image Quality Indicators for Non-destructive Testing—Principles and Identification*
- (8) ISO 3058, *Non-destructive Testing—Aids to Visual Inspection—Selection of Low-power Magnifiers*
- (9) ISO 3059, *Non-destructive Testing—Method for Indirect Assessment of Black Light Sources*
- (10) ISO 3452, *Non-destructive Testing—Penetrant Inspection—General Principles*
- (11) ISO 3999, *Apparatus for Gamma Radiography—Specification*
- (12) ISO 5576, *Non-destructive Testing—Industrial X-ray and Gamma-ray Radiology—Vocabulary*
- (13) ISO 5580, *Non-destructive Testing—Industrial Radiographic Illuminators—Minimum Requirements*
- (14) ISO 5655, *Photography—Film Dimensions—Industrial Radiography*

- (15) ISO 6520-1, *Welding and Allied Processes—Classification of Geometric Imperfections in Metallic Materials—Part 1: Fusion Welding*
- (16) ISO 8249, *Welding—Determination of Ferrite Number in Austenitic Weld Metal Deposited by Covered Cr-Ni steel electrodes*
- (17) ISO 9712, *Non-destructive Testing—Qualification and Certification of Personnel*
- (18) ISO 9935, *Non-destructive Testing—Penetrant Flaw Detectors—General Technical Requirements*
- (19) ISO 10375, *Non-destructive Testing—Ultrasonic Inspection—Characterization of Search Unit and Sound field*
- (20) *Metals Handbook*, Ninth Edition, Volume 17, 1989, “Nondestructive Inspection and Quality Control,” ASM International, Metals Park, OH
- (21) *Rules for Nondestructive Testing of Hull Welds*, American Bureau of Shipping, Paramus, NJ
- (22) *Welding Inspection*, 2nd Ed., 1980, American Welding Society, Miami, FL

E. Safety

- (1) 29 CFR 1915, *Occupational Safety and Health Standards for Shipyard Employment*, Subpart D, Welding, Cutting and Heating
- (2) 46 CFR Chapter 1, Subchapter V—*Marine Occupational Safety and Health Standards*, Part 197, code of Federal Regulations
- (3) *ADC Consensus Standards*, Association of Diving Contractors
- (4) ANSI/AWS F4.1, *Recommended Safe Practices for the Preparation for Welding and Cutting of Containers That Have Held Hazardous Substances*, American Welding Society, Miami, FL
- (5) ANSI/AWS Z49.1, *Safety in Welding, Cutting, and Allied Processes*, American Welding Society, Miami, FL
- (6) ANSI Z87.1, *Practice for Occupational and Educational Eye and Face Protection*, American National Standards Institute
- (7) Code of Practice for the Safe Use of Electricity Underwater, Association of Offshore Diving Contractors
- (8) *National Electrical Code*, National Fire Protection Association, Quincy, MA
- (9) NFPA 51B, *Standard for Fire Prevention in the Use of Cutting and Welding Processes*, National Fire Protection Association, Quincy, MA
- (10) NFPA No. 51, *Standard for the Installation and Operation of Oxygen-Fuel Gas Systems for Welding and Cutting*, National Fire Protection Association, Quincy, MA
- (11) OSHA 1910 (Subpart T), Occupational Safety and Health Act
- (12) *Welding Handbook*, 8th ed., Volume 3, Materials and Applications—Part 1, Chapter 10, Underwater Welding and Cutting, American Welding Society, Miami, FL

F. Welding

- (1) AWS A5.1/A5.1M, *Specification for Carbon Steel Electrodes for Shielded Metal Arc Welding*, American Welding Society, Miami, FL
- (2) AWS A5.4/A5.4M, *Specification for Stainless Steel Electrodes for Shielded Metal Arc Welding*, American Welding Society, Miami, FL
- (3) AWS A5.5/A5.5M, *Specification for Low Alloy Steel Covered Arc Welding Electrodes*, American Welding Society, Miami, FL

- (4) AWS A5.18/A5.18M, *Specification for Carbon Steel Electrodes and Rods for Gas Shielded Arc Welding*, American Welding Society, Miami, FL
- (5) AWS A5.20/A5.20M, *Specification for Carbon Steel Electrodes for Flux Cored Arc Welding*, American Welding Society, Miami, FL
- (6) AWS A5.28/A5.28M, *Specification for Low Alloy Steel Electrodes and Rods for Gas Shielded Arc Welding*, American Welding Society, Miami, FL
- (7) AWS A5.29/A5.29M, *Specification for Low Alloy Steel Electrodes for Flux Cored Arc Welding*, American Welding Society, Miami, FL
- (8) AWS A5.32/A5.32M, *Specification for Welding Shielding Gases*, American Welding Society, Miami, FL
- (9) AWS B2.1/B2.1M, *Specification for Welding Procedure and Performance Qualification*, American Welding Society, Miami, FL
- (10) API RP 1107, *Recommended Pipelines Maintenance Welding Practices*, American Petroleum Institute, Washington, DC
- (11) API Std. 1104, *Standard for Welding Pipelines and Related Facilities*, American Petroleum Institute, Washington, DC
- (12) ASME Boiler and Pressure Vessel Code, Section IX, *Welding and Brazing Qualifications*, American Society of Mechanical Engineers, New York, NY
- (13) Bureau Veritas; Underwater Welding, *General Information and Recommendation*, January 1986
- (14) Det Norske Veritas, Recommended Practice RP B604, January 1987
- (15) IIW DOC SCUW 124–90, *Standard Guidelines for Specification of Underwater Fusion Welding*
- (16) ISO 3088, *Welding requirements—Factors to be Considered in Specifying Requirements for Fusion Welded Joints in Steel (technical influencing factors)*
- (17) ISO 3834–1, *Quality Requirements for Welding—Fusion Welding of Metallic Materials—Part 1: Guidelines for Selection and Use*
- (18) ISO 9606, *Approval Testing of Welders—Fusion Welding*
- (19) ISO 9956, *Specification and Approval of Welding Procedures for Metallic Materials*
- (20) ISO 15618–1, *Qualification Testing of Welders for Underwater Welding—Part 1: Diver- Welders for Hyperbaric Wet Welding*
- (21) ISO 15618–2, *Qualification Testing of Welders for Underwater Welding—Part 2: Diver- Welders and Welding Operators for Hyperbaric Dry Welding*
- (22) MIL-STD-22, *Welded Joint Design*
- (23) MIL-STD-248, *Welding and Brazing Procedure and Performance Qualification*
- (24) MIL-STD-271, *Requirements for Nondestructive Testing Methods*
- (25) MIL-STD-1628, *Fillet Weld Size, Strength, and Efficiency Determination*
- (26) NAVSEA S0300-BB-MAN-010, *U.S. Navy Underwater Cutting and Welding Manual*
- (27) *Welding Handbook*, 8th ed., Volume 3, Materials and Applications—Part 1, Chapter 10, Underwater Welding and Cutting, American Welding Society, Miami, FL

Addresses of Publishers of Documents Listed in Annex E

American Bureau of Shipping (ABS)
 45 Eisenhower Drive
 P.O. Box 910
 Paramus, NJ 07653-0910

American National Standards Institute (ANSI)
11 West 42nd Street
New York, NY 10036

American Petroleum Institute (API)
1220 L Street, N.W.
Washington, DC 20005

The American Society for Nondestructive Testing, Inc. (ASNT)
1711 Arlingate Lane
P.O. Box 28518
Columbus, OH 43228-0518

American Society for Testing and Materials (ASTM)
1916 Race Street
Philadelphia, PA 19103

American Welding Society (AWS)
550 N.W. LeJeune Road
Miami, FL 33126-9743

ASM International (formerly: American Society for Metals)
Metals Park, OH 44073
Association of Diving
Houston, TX

Government Printing Office (GPO)
Superintendent of Documents
710 North Capitol Street, N.W.
Washington, DC 20401

International Organization for Standardization (ISO)
Case Postale 56
CH-1211, Geneva 20
Switzerland
(Note: ISO standards are available from ANSI) www.iso.ch
National Fire Protection Association (NFPA)
1 Batterymarch Park
P.O. Box 9101
Quincy, MA 02269-9904

Naval Sea Systems Command (NAVSEA)
Naval Publication & Forms Center
5801 Tabor Avenue
Philadelphia, PA 19120

Military Standards (MIL-STD)
Naval Publication and Forms Center
5801 Taber Avenue
Philadelphia, PA 19120

Det Norske Veritas (DNV)
DNV Loss Control Management
4546 Atlanta Highway
Loganville, GA 30249-2637
404/466-2208

Det Norske Veritas Industry (NDVI)
Veritas Veien 1
N-1322 Hovik
Norway

International Institute of Welding (IIW)
ZI Paris Nord II
BP 50362
F-95942 Roissy CDG Cedex
France
Phone: 011-33-1-49-90-36-08
FAX: 011-33-1-49-90-36-80

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Annex F (Informative)

Guidelines for the Preparation of Technical Inquiries for Structural Welding Committee

This annex is not part of AWS D3.6M:2010, *Underwater Welding Code*, but is included for informational purposes only.

F1. Introduction

The American Welding Society (AWS) Board of Directors has adopted a policy whereby all official interpretations of AWS standards are handled in a formal manner. Under this policy, all interpretations are made by the committee that is responsible for the standard. Official communication concerning an interpretation is directed through the AWS staff member who works with that committee. The policy requires that all requests for an interpretation be submitted in writing. Such requests will be handled as expeditiously as possible, but due to the complexity of the work and the procedures that must be followed, some interpretations may require considerable time.

F2. Procedure

All inquiries shall be directed to:

Managing Director
Technical Services Division
American Welding Society
550 N.W. LeJeune Road
Miami, FL 33126

All inquiries shall contain the name, address, and affiliation of the inquirer, and they shall provide enough information for the committee to understand the point of concern in the inquiry. When the point is not clearly defined, the inquiry will be returned for clarification. For efficient handling, all inquiries should be typewritten and in the format specified below.

F2.1 Scope. Each inquiry shall address one single provision of the code, unless the point of the inquiry involves two or more interrelated provisions. The provision(s) shall be identified in the scope of the inquiry along with the edition of the code that contains the provision(s) the inquirer is addressing.

F2.2 Purpose of the Inquiry. The purpose of the inquiry shall be stated in this portion of the inquiry. The purpose can be either to obtain an interpretation of a code's requirement, or to request the revision of a particular provision in the code.

F2.3 Content of the Inquiry. The inquiry should be concise, yet complete, to enable the committee to quickly and fully understand the point of the inquiry. Sketches should be used when appropriate and all paragraphs, figures, and tables (or the Annex), which bear on the inquiry shall be cited. If the point of the inquiry is to obtain a revision of the code, the inquiry must provide technical justification for that revision.

F2.4 Proposed Reply. The inquirer should, as a proposed reply, state an interpretation of the provision that is the point of the inquiry, or the wording for a proposed revision, if that is what inquirer seeks.

F3. Interpretation of Code Provisions

Interpretations of code provisions are made by the Structural Welding Committee. The secretary of the committee refers all inquiries to the chair of the particular subcommittee that has jurisdiction over the portion of the code addressed by the inquiry. The subcommittee reviews the inquiry and the proposed reply to determine what the response to the inquiry should be. Following the subcommittee's development of the response, the inquiry and the response are presented to the entire Structural Welding Committee for review and approval. Upon approval by the committee, the interpretation is an official interpretation of the Society, and the secretary transmits the response to the inquirer and to the *Welding Journal* for publication.

F4. Publication of Interpretations

All official interpretations shall appear in the *Welding Journal* and will be posted on the AWS web site.

F5. Telephone Inquiries

Telephone inquiries to AWS Headquarters concerning the *Structural Welding Code* should be limited to questions of a general nature or to matters directly related to the use of the code. The AWS Board of Directors' policy requires that all AWS staff members respond to a telephone request for an official interpretation of any AWS standard with the information that such an interpretation can be obtained only through a written request. Headquarters staff cannot provide consulting services. However, the staff can refer a caller to any of those consultants whose names are on file at AWS Headquarters.

F6. The Structural Welding Committee

The activities of the Structural Welding Committee regarding interpretations are limited strictly to the interpretation of code provisions or to consideration of revisions to existing provisions on the basis of new data or technology. Neither AWS staff nor the committees are in a position to offer interpretive or consulting services on: (1) specific engineering problems, or (2) code requirements applied to fabrications outside the scope of the code or points not specifically covered by the code. In such cases, the inquirer should seek assistance from a competent engineer experienced in the particular field of interest.

Index

A

Acceptance Criteria, See Type of Inspection
 Alignment, See *Fit-Up*
 All-Weld-Metal Tension Test, 7.3.2.4, 7.4.2, 9.3, 9.4
 Arc Strikes., 3.10
 Assembly, See *Fit-Up*

B

Backing, 3.3.1.1, 5.16
 Base Metals, 1.5, 5.6.1
 Discontinuities, 3.2
 Preparation, 3.2, 3.8, 3.11
 Repair, 3.2, 3.8.2, 6.6.2
 Bend Radius, 5.11.3, 7.3.2, 8.3.2
 Bend Testing, 5.11.3, 7.3.2, 7.6, 8.3.2, 8.6
 Blow Holes, 3.2.2
 Break Test, See *Fillet Weld Break Test*
 Bridge Bend Test, 5.11.9, 9.4

C

Carbon Content, 1.5.1, 5.6.1.4
 Carbon Equivalent, 1.5.1, 5.6.1
 Charpy Impact Tests, 5.11.5, 7.3.2, 7.4.1, 7.4.2, 8.3.2, 9.3, 9.4
 Chemical Composition, 5.6.1
 Class (defined), Foreword, 2.1
 Class A Welds, 7.0
 Acceptance Criteria, 7.9–7.12
 Definition, 2.1.4
 Inspection, 7.8
 Procedure Qualification, 7.2–7.4
 Welder Qualification, 7.5–7.7
 Class B Welds, 8.0
 Acceptance Criteria, 8.9–8.11
 Definition, 2.1.5

Inspection, 8.8
 Procedure Qualification, 8.2–8.4
 Welder Qualification, 8.5–8.7
 Class O Welds, 9.0
 Acceptance Criteria, 9.7
 Conflicts, 1.4.3, 5.6, 5.15
 Definition, 2.1.7
 Inspection, 9.6
 Procedure Qualification, 9.2–9.4
 Welder Qualification, 5.15, 9.5
 Cleaning, 3.2, 3.11, 6.5.1
 Confirmation Weld, 3.4, 6.4.3
 Contractor Responsibilities, 1.9, 3.2.3, 5.4, 5.15, 6.1.1, 6.1.4, 6.3–6.6, 6.10.2
 Corrosion, 3.2.1
 Cracks, 3.10, 7.6.2, 7.9, 7.10, 8.9, 8.10
 Craters, 7.9, 8.9,
 Customer
 Approval Requirements, 1.4.4, 3.2.1, 3.3, 3.5, 3.7.2, 3.8, 5.1.1, 5.4, 5.6.1, 5.11.4, 6.2.10, 6.4.1, 6.4.3, 6.6.2, 6.9.2, 6.10.2, 6.10.4, 6.12.1, 6.12.10, 6.14, 6.15.2, 6.16.4, 6.17.2, 6.18.4
 (See also *Prerogatives*, below)
 Definition, 1.4.1
 Inspection Requirements, 3.1, 6.2.2, 6.3, 6.10, 6.12
 Notification Requirements, 3.2.3, 6.1.4, 6.14.3
 Prerogatives, 1.4.1, 1.6.2, 2.2, 2.1.3, 3.2.3, 3.7.2, 4.2, 5.2, 5.6.1, 5.11.4, 5.13, 5.14, 5.17.2, 6.1.3, 6.2.2, 6.3–6.5, 6.8.1, 6.9.2, 6.10.1, 6.11.2, 6.12, 6.17.2, 7.8, 8.8, 10.3, 10.6
 Responsibilities,
 Foreword, 1.2, 1.5.2, 2.1.2, 2.2, 3.1, 5.8.2, 6.1.3, 6.11.3, 6.8.1, 6.10.4, 6.12.10, 7.12

D

Definitions, 1.7, Glossary
 Deoxidation, 3.2.2
 Depth (Range), 5.6.2, 5.16
 Design, 2.2
 Diameter (Pipe), 5.16
 Drop-Through, 8.9
 Dry Chamber, Foreword
 Dry Spot Welding, Foreword
 Dye Penetrant, See *Liquid Penetrant*

E

Eddy Current Examination, 6.7.6, 6.8.3, 6.8.8, 6.17, 6.18, 7.11, 8.11
 Acceptance Criteria, 6.17.3
 Elongation, 7.3.2, 7.4.2, 9.3.2
 Equipment—Inspection of, 6.3
 Essential Variables, See *Procedure or Welder Qualification*

F

Filler Metal, 4.1
 Coatings, 4.1.2, 5.16
 Protection, 4.1.1
 Transport, 4.1.3
 Fillet Weld Break Test, 3.4.4, 5.11.7, 7.4.2, 7.7, 8.4, 8.7
 Fillet Weld Shear Test, 5.11.8, 7.4.2, 8.4
 First Position, 5.8.2, 5.10, 5.11.8, 7.2, 8.2
 Fitness-for-Purpose, 2.1.5
 Fit-Up
 Dry Welding, 3.3.1, 5.9.3
 Wet Welding, 3.3.2, 5.9.4
 Fusion, 7.4.2, 7.7.2, 7.9, 8.4.2, 8.7.2, 8.9, 8.10.2

G

Gas

- Breathing/Background, 5.16
- Shielding, 5.6, 5.16

H

- Habitat, Foreword
- Hardness, 2.1.3
- Hardness Test, 5.11.6, 7.4.2, 8.3.2
- Hydrogen Release, 5.11.4

I

- Inclusions, 3.2.2, 7.4.2, 7.7.2, 8.4.2, 8.7.2
- Inspection, 6.0, 7.8–7.12, 8.8–8.11, 9.6, 9.7
- Inspector, 1.4.1

J

Joint

- Configuration, 5.9
- Fit-Up, See *Fit-Up*
- Penetration, 7.9, 8.9, 8.10

L

- Laminations, 3.2.3
- Liquid Penetrant Examination, 6.7.6.5
- Acceptance Criteria, 7.11, 8.11, 9.7

M

- Macroetch Testing, 5.11.2, 5.11.6, 7.3.2, 7.4.2.6, 7.6, 7.7, 7.10.2, 8.3.2, 8.4.2, 8.6, 8.7, 8.10.2, 9.3, 9.4
- Acceptance Criteria, 7.10.2, 8.10.2, 9.10, 9.7
- Magnetic Particle Inspection, 6.7.4, 6.15, 6.16
- Acceptance Criteria, 7.11, 8.11, 9.7
- Materials, Inspection of, 6.2
- Measurement, Units of, Foreword, 1.10
- Melt-Through, 7.9, 8.9, 8.10.1

N

- Nondestructive Examination, 6.7 (See also *Specified Method*)

Nonessential Variable, See *Procedure or Welder Qualification*

O

- One Atmosphere Welding, Foreword

P

- Peening, 3.9
- Performance Qualification, See *Welder Qualification*
- Personnel Qualification
 - Nondestructive Examination, 6.8
 - Supplemental Requirements, 6.8
 - T-, Y-, K-Connections, 6.8.2, 6.14
 - Welder, See *Welder Qualification*
- Porosity, 3.2.2, 7.4.2, 7.7.2, 7.9, 8.1, 8.4.2, 8.7.2, 8.9, 8.10
- Position, 3.4.3, 5.8, 5.11.8, 5.16, Table 5.4
- Definitions, 5.8.4, 5.8.7
- Procedure Qualification
 - Essential Variables, 5.5, 5.6, 5.16, Tables 5.1 and 5.2
 - Fillet vs. Groove, 5.9.2, 7.4.1, 8.4.1
 - Joint Configuration, 5.9
 - Nonessential Variables, 5.5, 5.6, Tables 5.1 and 5.2 Records, 5.1.1, 5.14
 - Requirements, 3.3.1.1, 3.3.2, 4.3, 5.5.2, 5.6.1.3
 - Test Requirements, 5.1.2, 5.7, 5.8, 5.10–5.12
 - Class A Welds, 7.2–7.4
 - Class B Welds, 8.2–8.4
 - Class O Welds, 9.2–9.4
- Procedure Specification, 5.1
- Required Contents, 3.3.1.1, 3.3.2, 5.5.2, 5.9.4, Tables 5.1 and 5.2
- Protection, Diving Suit, 5.16

Q

- Qualification, See *Personnel, Procedure, or Welder Qualification*

R

- Radiographic Examination, 6.7.2, 6.11, 6.12
- Acceptance Criteria, 7.10.2, 8.10.1, 9.7

Records

- Examination, 6.10.4, 6.12.7, 6.12.10, 6.14.8, 6.16.4, 6.18.4
- Performance Qualification, See *Welder Qualification*
- Procedure Qualification, See *Procedure Qualification*
- Production, 4.2, 6.2.1, 6.4.1, 6.5.1, 6.5.2
- Repair, 3.2, 3.8, 6.5.1, 6.6.2
- Rockwell Hardness, See *Hardness*
- Root Opening, 3.3.1

S

- Safety, 1.9, Annex D
- Shear Strength Test, See *Fillet Weld Shear*
- Slag (also see *Inclusions*), 3.2.2, 3.11, 7.7.2, 8.7.2, 8.10.1
- Splatter, 3.11
- Spot Radiographic Examination, 6.1.3, 6.11.3
- Supplementary Requirements, 2.1.2, 2.1.3, 5.13, 6.1.3
- Support, 5.16

T

- Tack Welds, 3.7
- Temperature, 4.3, 5.11.5, 5.16
- Temporary Welds, 3.7
- Tensile Strength, 7.3.2, 7.4.2, 8.3.2, 9.3.2
- Tension Tests, 5.11, 7.3.2.3, 7.4.2, 8.3.2
- Tolerances
 - Alignment, 3.3.1.2, 5.9.3, 5.9.4
 - Length, 3.5
 - Location, 3.5
 - Profile, Shape, 3.6, 7.9, 8.9
 - Root Geometry, 3.3.1, 3.3.2, 5.4.2.2, 5.9.1, Tables 5.1 and 5.2
 - Size, 3.5
- Toughness, 2.1.3

U

- Ultrasonic Examination, 6.7.3, 6.8.2, 6.13, 6.14 Acceptance Criteria, 7.12, 10.7
- Undercut, 7.9, 8.9
- Underfill, 7.9, 8.10

V

Variables, See *Procedure* or *Welder Qualification* Measurement of, 4.2, 5.5.3
 Vertical Travel, 5.6, 5.16, Tables 5.1 and 5.2
 Vickers Hardness, See *Hardness*
 Visibility, 5.16
 Visual Examination, 6.1.2, 6.7.1, 6.9, 6.10
 Acceptance Criteria, 7.9, 8.9, 9.7

W

Waterproof Coating, See *Filler Metal Coating*
 Wave Action, 5.6.2.3 Weld Class, See *Class* Weld Identification., 6.10.3
 Welder Qualification, 5.3, 5.15
 Essential Variables, 5.15, 5.16, Table 5.5
 Expiration, 5.2.1 Records, 5.14, 6.4.1

Requalification, 5.21, 6.4.3
 Retest, 5.20
 T-, Y-, K-Connections, 5.17.4
 Test Requirements, 5. 17–5.19
 Class A, 7.5–7.7
 Class B, 8.5–8.7
 Class O, 9.5

Wet Welding, Foreword

Y

Yield Strength, 7.3.2, 7.4.2, 9.3.2

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List of AWS Documents on Marine Welding

Designation	Title
D3.5	<i>Guide for Steel Hull Welding</i>
D3.6	<i>Underwater Welding Code</i>
D3.7	<i>Guide for Aluminum Hull Welding</i>
D3.9	<i>Specification for Classification of Weld-Through Paint Primers</i>
Additional Documents of Fundamental Subject Matter	
A1.1	<i>Metric Practice Guide for the Welding Industry</i>
A2.4	<i>Standard Symbols for Welding, Brazing, and Nondestructive Examination</i>
A3.0	<i>Standard Welding Terms and Definitions</i>
B4.0	<i>Standard Methods for Mechanical Testing of Welds</i>
B4.0M	<i>Standard Methods for Mechanical Testing of Welds</i>

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