

AWS D1.1 (Structural Welding Code-Steel)

Quick Review on Performance Qualification

References: AWS D1.1, Clause 4 (Part C), Tables 4.10, 4.11, 4.12, 4.13

AWS D1.1, Table 4.12, Welding Personnel Performance Essential Variables

Require Re-qualification:

Process, Position, Pipe Diameter, Thickness, F-Number (SMAW), Vertical progression, Omission of backing (if used in test), and Multiple electrodes (if a single electrode used by welding operator in the WPQR test)

Note: Welders qualified for SAW, GMAW, FCAW or GTAW shall be considered as qualified welding operators in the same process (es) and subject to the welder essential variable limitations, provided the welders receive training and demonstrate their ability to make satisfactory production welds.

1-Guide (Position)

AWS D1.1, Table 4.10, Groove Test (Plate, Pipe or Box Tube)

Position Tested*	Position Qualified	
Plate, Pipe or Box	Groove	Fillet
1G, 1G Rotated	F	F, H
2G	F, H	F, H
3G	F, H, V	F, H, V
4G	F, OH	F, H, OH
5G	F, V, OH	F, V, OH
6G, 6GR	All	All

AWS D1.1, Table 4.10, Fillet Test (Plate, Pipe or Box Tube)

Position Tested*	Position Qualified
Plate, Pipe or Box	Fillet
1F, 1F Rotated	F
2F, 2F Rotated	F, H
3F	F, H, V
4F	F, H, OH
5F	All

(See AWS D1.1, Table 4.11 for Test Figures)

*Vertical uphill to downhill or vice versa is essential variable.

*Groove test on pipe or box tube also qualifies plate for the same positions qualified. Groove test using box tubing also qualifies welding pipe over 24 in [600 mm] in diameter.

*Groove test on plate also qualifies plug or slot welds for the test positions indicated.

*Groove test on plate qualifies for pipe equal to or greater than 24 in [600 mm] in diameter with backing, backgouging, or both.

*Plug test qualifies plug and slot welding for only the positions tested.

*ESW or EGW process test qualifies welding for only the position tested.

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