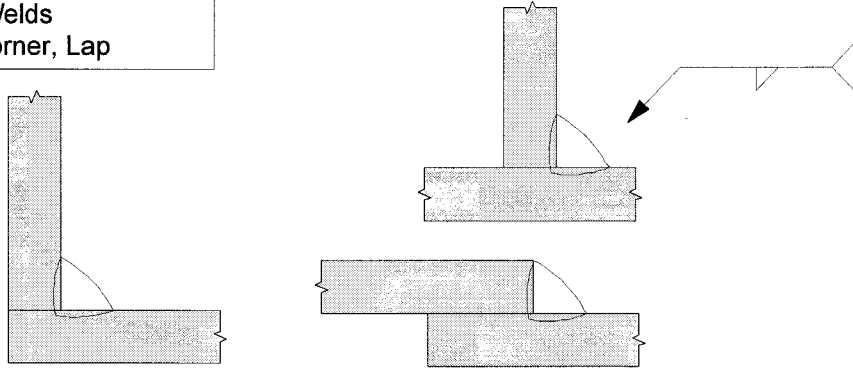


Fillet Welds
Tee, Corner, Lap



If root opening is greater than 1/16", the leg of the fillet shall be increased by the amount of the root opening.

| Welding Process | Joint Designation | Base Metal Thickness (U=unlimited) | | Root Opening | Tolerances | | Permitted Welding Positions (E1+E2) | Weld Size (E1+E2) | Notes |
|-----------------|-------------------|--------------------------------------|----|--------------|--------------------------|------------------------|---------------------------------------|---------------------|-------|
| | | T1 | T2 | | As Detailed (see 3.12.3) | As Fit Up (see 3.12.3) | | | |
| | | SMAW | NA | | 1/8 min to U | - | | | |

MEMO

This WPS applies to joints where the minimum angle between the joined pieces is 60 degs. and the maximum angle is 135 degs. The provisions of weld sizes and base metal thicknesses can be found in AWS D1.6 paragraph 3.14.1. Acceptable weld profiles are defined in Figure 5.2 of AWS D1.6.

Fillet Weld Assembly. The parts to be joined by fillet welds shall be brought into as close contact as practicable. If the separation is greater than 1/16 in. (1.6 mm), the leg of the fillet weld shall be increased by the amount of the root opening. Fit up separations greter than 3/16 in. (5 mm) are unacceptable without prior approval of the engineer and demonstration that the required effective throat has been attained.