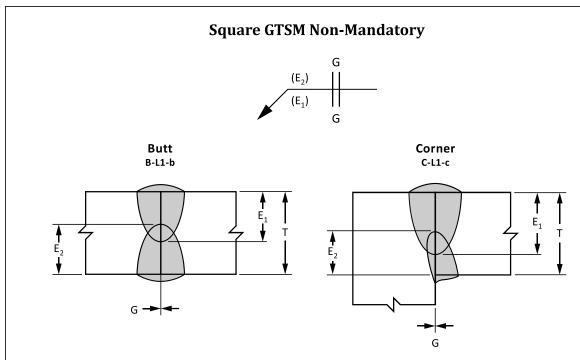
W59-18 Welded steel construction

Figure 10.1 (Continued)



Welding Process	Joint Type	Base Metal Thickness "T"	Root Opening "G"	Root Face "Rf"	Depth of Prep "S"	Groove Angle " θ "	Weld Size "E"	Position
SMAW	Butt	≤ 6 mm (¹ / ₄ in)*	≥ T/2				T	F/V†
FCAW	Butt	≤ 6 mm (¹ /4 in)	0				T	F
MCAW SP	Butt	≤ 6 mm (¹/4 in)	0				T	F
GMAW SP								
GMAW P								
GTAW								
SAW	Butt/Corner	$T \le 12 \text{ mm } (^{1}/_{2} \text{ in})^{\ddagger}$	0				Τ§	F

^{*} T \leq 5 mm ($^3/_{16}$ in) for all position † F/H/V/O

(Continued)

[‡] T ≤ 8 mm (5 /16 in) for Corner Joint § E1 & E2 ≥ T/2