CONTENTS

			Page				Page	
List of figures i				7	7 WELDING PROCEDURES		30	
Lis	st of t	ables	iv		7.1	Qualification of a welding		
Preface						procedure	30	
About the author					7.2	Prequalified welding procedure	32	
About the contributing author and editor			vi		7.3	Qualification by testing	33	
Acknowledgements			vii		7.4	Requalification of welding		
		-				procedures	34	
1	CONCEPT OF DESIGN GUIDES		1	8	WO	RKMANSHIP	35	
	1.1	Background	1		8.1	Edge preparation	35	
_			_		8.2	Assembly	35	
2	INTRODUCTION		2		8.3	Preheat	36	
	TVD	es of weld	2		8.4	Tack welds	37	
3					8.5	Distortion and residual stress	38	
		Weld types	3		8.6	Cleaning and dressing welds	39	
	3.2	Fillet welds	5					
	3.3	Butt welds	8			_D IMPERFECTIONS	40	
	3.4	Edge preparations	12			Weld categories	40	
		Prequalified joint preparations	13		9.2	Levels of inspection	42	
	3.6	Standard weld symbols	14		9.3	Imperfection levels	43	
4	WELDABILITY OF STEEL		17		9.4	Weld defects	46	
4	VVLL	DABILITY OF STEEL	17		9.5	Weld repairs	47	
5	WELDING PROCESSES							
•	5.1 Introduction5.2 Fusion welding process5.3 Terminology		18	10		_D INSPECTION		
			19			Introduction	48	
			20			Visual examination	49	
	5.3.		20			Magnetic particle examination	50	
		2 Partially mixed weld metal	20			Liquid penetrant examination	51	
	5.3.3	3 Fusion (boundary) line	20			Radiographic examination	52	
	5.3.4		20		10.6	Ultrasonic examination	54	
	5.3.5		20	4.4		CTICAL CONCIDEDATIONS		
	5.4 Manual metal arc welding		21	11		ACTICAL CONSIDERATIONS		
	5.5					Clearances for welding	55	
	0.0	flux cored arc welding	22			Site welding	57	
	5.6	Summary of characteristics			11.3	Economical design and detailing	58	
		of welding processes	24	12	DEE	REFERENCES	50	
	5.7	Welding positions	25	12	12 NEFERENCES		59	
			20	ΔF	APPENDIX			
6	WELDING CONSUMABLES			, (1	A	ASI Design Guide 2		
	6.1	Manual metal arc welding	26			comment form	61	
		Gas metal arc welding	27				01	
		Flux cored arc welding	28					
		Pregualified welding consumables						





LIST OF FIGURES

	Page		Page							
Figure 1	Weld types in AS 4100 3	Figure 18	Schematic diagram flux cored							
Figure 2	Weld use by joint type4		arc welding22							
Figure 3	Typical applications of fillet welds	Figure 19	Welding positions for plate butt							
	in steelwork connections 6		welds25							
Figure 4	Fillet weld size and details7	Figure 20	Welding positions for plate fillets 25							
Figure 5	Fillet weld size in lapped plates 7	Figure 21	Imperfections in butt welds44							
Figure 6	Types of butt welds 8	Figure 22	Imperfections in fillet welds45							
Figure 7	Typical applications of butt welds	Figure 23	Solidification cracks45							
	in steelwork connections 9	Figure 24	Schematic diagram of magnetic							
Figure 8	Examples of use of run-off plate,		particle examination50							
_	backing bar, extension plate 11	Figure 25	Schematic diagram of liquid							
Figure 9	Terms applicable to full		penetrant examination51							
	penetration butt welds 11	Figure 26	Principles of radiographic							
Figure 10	Terms applicable to partial	J	examination52							
J	penetration butt welds 11	Figure 27	Examples of imperfection detection							
Figure 11	Weld edge preparation terms 12	J	using ultrasonic examination54							
	Construction of a welding symbol . 15	Figure 28	Angular limits for joint preparations							
Figure 13	Basic welding symbols 16	J	for various welding techniques55							
-	Supplementary welding symbols 16	Figure 29	Clearance on an angle cleat							
	Structure of a single pass weld 20	Ü	welded to a beam web55							
	Manual metal arc welding (MMA) . 21	Figure 30	Examples of bad accessibility56							
	Schematic diagram gas metal	Ü	,							
J	arc welding 22									
	3									
LIST OF TABLES										
	Page		Page							
Table 1	Minimum size (leg length) of fillet	Table 4	Levels of non-destructive							
1000	welds 5	rabio i	examination (NDE)42							
Table 2	Characteristics of welding	Table 5	Types of imperfection considered							
. 3510 =	processes	. 45.0 0	in AS/NZS 1554.143							
Table 3	Prequalified welding									
. 45.0 0	consumables 29									



