



AWS Errata Sheet

The following Errata have been identified and will be incorporated into the next reprinting of AWS D1.1/D1.1M:2015, *Structural Welding Code-Steel*

Page 38, Figure 2.4 references in title: replace (see 2.9.9.1 and 2.9.1.2) with (see 2.9.1.1 and 2.9.1.2)

Page 54, Table 3.2—Base Metal Group I, Column heading A5.29a Low-Alloy Steel: replace “E6XT-XM” with “E6XTX-XM”

Page 72, Figure 3.2; the Tolerance Columns in the Table were aligned with the Root Opening Root Face Bend Radius Column

Page 73, Figure 3.2; the Tolerance Columns in the Table were aligned with the Root Opening Root Face Bend Radius Column

Page 80, Figure 3.2; the Tolerance Columns in the Table were aligned with the Root Opening Root Face Bend Radius Column

Page 81, Figure 3.2; the Tolerance Columns in the Table were aligned with the Root Opening Root Face Bend Radius Column

Page 89, Figure 3.3, Double-bevel-groove weld (5), Butt joint (B); the Tolerance Columns in the Table were aligned with the Root Opening Root Face Bend Radius Column

Page 89, Figure 3.3, Double-bevel-groove weld (5), Butt joint (B), As Detailed (see 3.13.1) Column; replace “ $\alpha + \beta 10^\circ$ ” with “ $\alpha + \beta =$ ”

Page 89, Figure 3.3, Double-bevel-groove weld (5), Butt joint (B), As Detailed (see 3.13.1) Column; replace “ -0° ” with “ $+ 10^\circ, -0^\circ$ ”

Page 89, Figure 3.3, Double-bevel-groove weld (5), Butt joint (B), As Fit-Up (see 3.13.1) Column; replace “ $\alpha + \beta 10^\circ$ ” with “ $\alpha + \beta =$ ”

Page 89, Figure 3.3, Double-bevel-groove weld (5), Butt joint (B), As Fit-Up (see 3.13.1) Column; replace “ -5° ” with “ $+ 10^\circ, -5^\circ$ ”

Page 105, Figure 3.5: Note “a” replace “5.14” with “5.13”

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Page 105, Figure 3.5: Note “a” replace “Table 3.7” with Table “3.6”

Page 105, Figure 3.5: Note “b” replace “5.22.1” with “5.21.1”

Page 105, Figure 3.5: replace “ALL DIMENSIONS IN mm” with “ALL DIMENSIONS IN inches”

Page 105, Figure 3.5: replace welding process “FMAW” with “GMAW”

Page 106, Figure 3.5: added to the top of page “See Notes on Page 105”

Page 106, Figure 3.5: replace welding process “FMAW” with “GMAW”

Page 134, Table 4.9, Note 2, replace “20 ft·lbs [27.1 J]” with “20 ft·lbf [27 J]”

Page 135, Table 4.10: replace title “Welder and Welding Operator Qualification—Production Welding Positions Qualified by Plate, Pipe, and Box Tube Tests (see 4.15.1)” with “Welder and Welding Operator Qualification—Production Welding Positions Qualified by Plate Tests (see 4.15.1)”

Page 139, Table 4.14: add a vertical line between Welding Process and Test Location

Page 149, Figure 4.10, footnote b, replace 0.004 in [0.102 mm] with “0.004 in [0.1 mm]”

Page 149, Figure 4.10, footnote b, replace 0.015 in [0.381 mm] with “0.015 in [0.38 mm]”

Page 177, 5.23.3: replace “Groove weld reinforcement shall comply with Tables 5.8, and 5.9 and with the provisions below” with “Groove weld reinforcement shall comply with Tables 5.8 and 5.9 and with the provisions below”

Page 198, 6.17.7: add an additional sentence to the subclause “Steel backing shall not be considered part of the weld or weld reinforcement in IQI selection.”

Page 245, 7.2.6: replace “ASTM A29, *Standard Specification for Steel Bars, Carbon and Alloy, Hot-Wrought, General Requirements for Grades 1010 through 1020*” with “ASTM A29/A29M-12e1, Standard Specification for General Requirements for Steel Bars, Carbon and Alloy, Hot-Wrought, Grades 1010 through 1020”

Page 283, Table 9.10: replace column heading “Nominal Pipe or Tube Wall Thickness^{b,c} Qualified, in”: with “Nominal Plate, Pipe or Tube Wall Thickness^{b,c} Qualified, in”

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(Errata Notice: 03/01/2016)

Page 283, Table 9.10, footnote b: replace “For square groove welds that are qualified without backgouging, the maximum thickness qualified shall be limited to the plate thickness” to “For square groove welds that are qualified without backgouging, the maximum thickness qualified shall be limited to the test thickness”

Page 284, Table 9.10: replace column heading “Nominal Pipe or Tube Wall Thickness^{b,c} Qualified, mm”: with “Nominal Plate, Pipe or Tube Wall Thickness^{b,c} Qualified, mm”

Page 287, Table 9.14; Tests on Pipe or Tubing: replace column heading “Nominal Plate, Pipe, or Tube Wall Thickness^d Qualified, in” with “Nominal Plate, Pipe or Tube Wall Thickness^d Qualified, in”

Page 287, Table 9.14, Production T-, Y-, or K-Connection Fillet Welds, Type of Test Weld Column, Option 1—Fillet: replace (Fig. 4.26)^g with (Fig. 4.25)^g

Page 287, Table 9.14, Production T-, Y-, or K-Connection Fillet Welds, Type of Test Weld Column, Option 1—Fillet: replace (Fig. 4.23)^g with (Fig. 4.22)^g

Page 288, Table 9.14: replace far left column heading “Tests on Pipe or Tubing^e” with “Tests on Pipe or Tubing^f”

Page 420, Q3(15): Made all the language contained after “Documentation retention requirements.” a new paragraph within Q3(15).

Page 502, C-4.8: replace the sentence “However, departure from variables which affect the mechanical or chemical composition of material properties, or soundness of the weldment is allowed without requalification.” with “However, departure from variables which affect the mechanical or chemical composition of material properties, or soundness of the weldment is not allowed without requalification.”

Page 590, Index—Electrodes, welder qualification groups: replace “Table 9.15” with “Table 4.13”

Page 591, Index—Filler Metals, welder group designation: replace “4.3.2.1” with “4.2.3.1, Table 4.13”

Page 591, Index—Fillet Welds, maximum size: replace “2.4.2.8” with “2.4.2.9”

Page 591, Index—Fillet Welds, test plates: replace “4.4” with “4.12.2, Table 4.4”



Page 594, Index—Overlap: replace “5.25.11” with “5.25.1.1”

Page 594, Index—Prequalified joint details: replace “22.3.5.4” with “2.3.5.4”

Page 595, Index—Radiographs, disposition: replace “6.19” and “C-6.19” with “6.18” and C-6.18” respectively

Page 595, Index—Radiography: replace “6.19.3 and C-6.19.3” with “6.18.3 and C-6.18.3” respectively

Page 596, Index—Skewed T-joints: replace “Figure 3.44” with “Figure 3.4”

Page 596, Index—Statically Loaded Structures, backing: replace “2.6.4.1” with “5.9.1.5”

Throughout the document: replace “ft·lbs” or “ft·lb” with “ft·lbf”

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