5.3.2.17   Method of Cooling After Welding
If forced cooling is to be used, the specification shall designate the type of cooling after welding, such as forced cooling with water or air, as well as the maximum metal temperature at which forced cooling is applied.

Add into Essential Variables

5.4.2.15 Method of Cooling After Welding
An increase in the maximum weld temperature prior to forced cooling. A change in the method of cooling after welding resulting in a higher rate of cooling also requires requalification of the welding procedure.

Need to work with the Mechanized subcommittee to make the sections 12.4.2.18 & 12.5.2.17 similar or the same as Section 5

5.4.2.3   QUESTION - Needs to address addition of backing

Proposal was rejected. Backing is not a part of the joint design.

5.6.2.3   QUESTION - Tensile retest requirements are different throughout the document. 5.6.2.3 procedure qualification passes >95% SMTS, 6.5.3 welder qualification does not allow retest, and A.3.2.1.2 allows >95% SMTS with 2-for-1 retest. Also, sections 10 & 12 adopt the retest requirement in sections 5 & 6. This is confusing and will result in mistakes of using the incorrect retest requirement.

Proposal was rejected. The requirements are different for welding procedure and welder testing, no changes required.
Welding Procedures and Welder Qualification Sub Committee Meeting
Jan. 29, 2015

Sort Key # 112

5.6.5.2
QUESTION - Alternate bend test fixtures shall conform to the requirements in AWS B4.0 "Standard Methods for Mechanical Testing of Welds."

No change required. Changes have been incorporated in 21st edition.

Editorial change required: Last sentence, change Figure 9 to Figure 8.

The side bend specimens shall be bent in a guided-bend test jig similar to that shown in Figure 8. Each specimen shall be placed on the die with the weld at midspan and with the face of the weld perpendicular to the gap. The plunger shall be forced into the gap until the curvature of the specimen is approximately U shaped. Alternate bend test fixtures with bend radii equal to or less than the radius specified in Figure 9* may be used at the discretion of the company.

Sort Key # 120

6.2.2.f
QUESTION - Add a definition of "lap fillet welds" to the definitions section. Or change the term to "socket welds" or just use "fillet welds". Figure 11 has a lap fillet weld in the illustration but it is not specifically identified in the figure.

RESPONSE:
AWS 3.0 definition of fillet weld includes 'lap joint'. The term 'lap fillet weld' in 6.2.2 f) is not required as it is covered in AWS 3.0., it is defined as 'corner joint, lap joint, or tee joint'.

Editorial Change Required: Add “joint”. Change "lap fillet weld" to "lap joint fillet weld" in two sentences.

A change in position from that for which the welder has already qualified (e.g. a change from rolled to fixed or a change from vertical to horizontal or vice versa). A welder who qualifies in the fixed position shall also be qualified to perform rolled welds within the essential variables qualified. A welder who qualifies on a butt weld shall also be qualified to make lap joint fillet welds within the essential variables qualified. A welder who successfully passes a butt weld qualification test in the fixed position with the axis inclined 45° from horizontal shall be qualified to do butt welds and lap joint fillet welds in all positions.

BALLOT 2914

Sort Key # 65

Figure 3 & 12
QUESTION - The first subfigure does not clarify that this is for pipe the option of pipe with wall thickness less than or equal to 0.500 in.

RESPONSE:
In Figures 3 & 12, remove from 2nd figure (top left), the last 3 lines –

Greater than or equal to 2.375 in. (60.3 mm)
but less than or equal to 4.500 in. (114.3 mm);
also, less than or equal to 4.500 in. (114.3 mm)
when wall thickness is greater than
0.500 in. (12.7 mm)
Sort Key # 75

5.6.3.3  
QUESTION - The 2nd paragraph dispositions pipe greater than 12 3/4 but there is no disposition for pipe less than or equal to 12 3/4  
RESPONSE:  
No changes required. Smaller diameters are covered in 1st paragraph of 5.6.3.3

Sort Key # 77

5.6.4.3  
QUESTION - The 3rd sentence dispositions test weld diameters greater than 12 3/4 but there does not appear to be a disposition for smaller diameter test welds.  
RESPONSE:  
No changes required. Smaller diameters are covered in 1st 2 sentences of 5.6.4.3

Sort Key # 79

5.6.5.3  
QUESTION - The clause dispositions pipe greater than 12 3/4 but there is no disposition for pipe less than or equal to 12 3/4  
RESPONSE:  
No changes required. Smaller diameters are covered in 1st sentence of 5.6.5.3

Sort Key # 86

6.2.2.c  
QUESTION - reference to filler metal classification should also include flux classification  
RESPONSE:  
To be resolved with changes from Table 1 Task Group

Sort Key # 126

Table 1  
QUESTION - Title does not include reference to fluxes  
RESPONSE:  
To be resolved with changes from Table 1 Task Group

Sort Key # 127

Table 1  
QUESTION - Reference to AWS A5.23 in 4.2.2.1 is not also included in this table  
RESPONSE:  
To be resolved with changes from Table 1 Task Group
EXISTING BUSINESS
REFERENCE TO TABLE 1 DISCUSSIONS
There is concern from the subcommittee regarding the welders’ qualification requirements once the new table is introduced. We need to keep in mind that impact that the new Table 1 will have on welder qualifications.

NEW BUSINESS
REFERENCE TO BASE METAL GROUPING IN 5.4.2.2
It was brought up that the 3 groupings in Section 5.4.2.2 should be looked at to add or expand the explanation of the material groupings. This will be discussed in future meetings.