Steel

o enl r

E

says a sketch of the required weld should be shown. Common weld types include:

C (CJP). The engineer need only specify “CJP” in the tail of the weld symbol when such a weld is required, as shown in Figure 3. The contractor can choose whether the weld should be a single- or double-sided weld, as well as whether a V, bevel, U, or another option is appropriate. The detail shown in Figure 3 is just one example of the joint preparation that is allowed for a CJP.

P (PJP). The engineer must specify the effective throat E and the filler metal strength. Based on the welding process that will be used and other factors, the contractor can determine the required depth of joint preparation that will achieve the required

tions, as they provide enough guidance to select appropriate fillers for each joint.

S

AWS D1.1 states that T joints under 80 degrees or over 100 degrees are considered skewed T Joints. The details on the bot-

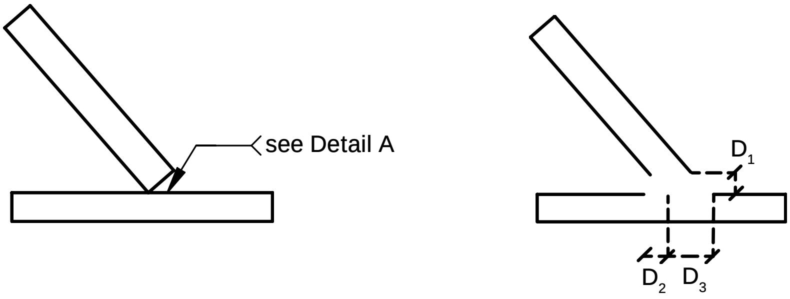
weld, AWS D1.1 Section 2.2.4 says the leg size is shown for fillet welds for joints between 80 and 100 degrees. For welds in skewed T joints under 80 degrees or over 100 degrees, the effective throat

1, 2 3

sions.

Technically Perfect

You’ve looked at all the references and devised the perfect weld symbol to put on your drawings. Now, stop and think about this: Someone has to be able to interpret that symbol in order to create



F 5. H T .