



Subject: Groove Weld Test Assembly
Code Edition: A5.1-91
Code Provision: Figure 2
AWS Log: A5.1-91-INT 1

Inquiry: In Figure 2 (Groove Weld Test Assembly for Mechanical Properties and Soundness Except for E6022 and E7018M Electrodes) of ANSI/AWS A5.1-91 (identical to SFA-5.1 of ASME 2004 Section II, Part (C)), Note 9 (not Note 8) states that “In addition to the stops and starts at the ends, each pass shall contain a stop and start in between the ends.” Can this note be interpreted to mean that during the groove assembly welding, no grinding or filing shall be permitted, and weld cleaning shall be limited to slag chipping, brushing, and needle scaling?

Response: No. Figure 3 (Fillet Weld Test Assembly), Note 8, of ANSI/AWS A5.1-91, states that “weld cleaning shall be limited to slag chipping, brushing, and needle scaling. Grinding or filing of the weld face is prohibited.” The requirements for the Fillet Weld Test Assembly in Figure 3 do not apply to the Groove Weld Test Assembly in Figure 2.