



## AWS D1.1 Interpretation

**Subject:** Cleaning of Completed Welds  
**Code Edition:** D1.1:2006  
**Code Provision:** Subclause 5.30.2  
**AWS Log:** D1.1-06-I17

**Inquiry:**

- (1) Is "brushing" intended to sweep away loose slag particles lying on the weld after slag removal, or does it mean wire brushing?
- (2) Is there a requirement to remove weld smoke residues?
- (3) What "other suitable means" were considered when this wording was added in D1.1:2006?
- (4) Is complete removal of tightly adherent spatter required for VT?
- (5) Is complete removal of tightly adherent spatter required for MT?

**Response:**

- (1) Cleaning of completed welds is to be accomplished by any cleaning technique which prepares the surface for visual inspection or other NDT required. Contractor/fabricator determines which means and methods will achieve this result.
- (2) No.
- (3) See Response (1).
- (4) No.
- (5) No, unless it will interfere with particle mobility in the area of interest. (See ASTM E 709, referenced in AWS D1.1 Subclause 6.14.4.)

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AWS D1.1, Structural Welding Code—Steel, is prepared by the AWS Structural Welding Committee. Because the Code is written in the form of a specification, it cannot present background material or discuss the committee's intent.

Since the publication of the first edition of the Code, the nature of inquiries directed to the American Welding Society and the Structural Welding Committee has indicated that there are some requirements in the Code that are either difficult to understand or not sufficiently specific, and other that appear to be overly conservative.

It should be recognized that the fundamental premise of the Code is to provide general stipulations applicable to any situation and to leave sufficient latitude for the exercise of engineering judgment. Another point to be recognized is that the Code represents the collective experience of the committee; and, while some provisions may seem overly conservative, they have been based on sound engineering practice.