AWS D1.1 Interpretation

Subject: Flux electrode classification essential variable
Code Provision: Table 4.5
AWS Log: D1.1-98-I01

Inquiry:
1) Since the original flux-electrode class no longer exists (for the flux/wire combination under consideration), is it reasonable to presume that during the process of updating the original WPS/PQR, it would be acceptable to revise the old class F7A6-EG-G to F7A6-EM14K?

2) The F7A6-EM14K class used for WPS qualification also qualifies the WPS for the use of filler metals possessing lower strength levels, i.e., F7A6-EM14K also qualifies: F7A4-EXXX, F6A2-EXXX, F6A2-EXXX.... The use of the lower classifications, depending on the flux manufacturer’s recommendation may result in the use of a differing wire class, such as EM13K or EM12K. Is it reasonable to assume that these wires can be used without requiring requalification of the WPS?

Response:
1) Yes, the electrode designation or electrode/flux designation on the WPS may be changed, providing that there has been no other change in the electrode/flux designation other than the electrode classification. The filler metal manufacturer and manufacturer’s trade name(s) must be unchanged.

2) No, a change in electrode classification other than a decrease in tensile strength requires requalification.