1 / 12 · Fabrication

What does the D1.5 workmanship section cover?

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A root opening measures outside the WPS tolerance. What happens?

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Against what is a fit-up measurement judged?

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Where do you look for rules on laminations found at a cut edge?

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What should be recorded when a fit-up problem is corrected?

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Where are the rules on the shape of a finished weld?

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Welding on that joint waits. The opening is corrected under the workmanship rules, with the Engineer's acceptance where the code requires it.

AASHTO/AWS D1.5M/D1.5:2020, workmanship: fit-up and corrections (section number not confirmed)

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Base metal preparation, fit-up, weld profiles and corrections.

AASHTO/AWS D1.5M/D1.5:2020, workmanship (section number not confirmed)

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The workmanship section, in the base metal preparation provisions.

AASHTO/AWS D1.5M/D1.5:2020, workmanship: base metal preparation (section number not confirmed)

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The WPS and the code's workmanship tolerances. Never shop habit or the last job.

AASHTO/AWS D1.5M/D1.5:2020, workmanship: fit-up (section number not confirmed)

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Weld profiles are in workmanship. Acceptance of the finished weld is in the inspection section.

AASHTO/AWS D1.5M/D1.5:2020, workmanship: weld profiles; inspection: visual acceptance (section number not confirmed)

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The measured value, the correction made, and who accepted it.

AASHTO/AWS D1.5M/D1.5:2020, workmanship; inspection records (section number not confirmed)

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What decides minimum preheat under D1.5?

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Where and when is preheat measured?

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The joint cools below preheat during a break. What now?

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10 / 12 · Fabrication

Why may D1.5 set a maximum interpass temperature for some steels?

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11 / 12 · Fabrication

Why might heat input be limited on bridge work?

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12 / 12 · Fabrication

Low-hydrogen electrodes passed their exposure limit. What happens?

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At the distance from the joint the code states, before the arc starts, and kept during welding.

AASHTO/AWS D1.5M/D1.5:2020, technique: preheat and interpass (section number not confirmed)

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The steel, its thickness and the hydrogen level of the consumable. Read the technique section.

AASHTO/AWS D1.5M/D1.5:2020, technique: preheat (section number not confirmed)

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10 / 12 · Fabrication

Too much heat can harm the properties of some bridge steels, so a maximum may apply as well as a minimum.

AASHTO/AWS D1.5M/D1.5:2020, technique: interpass temperature (section number not confirmed)

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Reheat to the required temperature before the next pass. Preheat applies throughout welding.

AASHTO/AWS D1.5M/D1.5:2020, technique: preheat and interpass (section number not confirmed)

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12 / 12 · Fabrication

They come out of use until they are redried or discarded as the code's consumable rules direct.

AASHTO/AWS D1.5M/D1.5:2020, technique: consumable storage and exposure (section number not confirmed)

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11 / 12 · Fabrication

High heat input can lower toughness in the heat affected zone.

AASHTO/AWS D1.5M/D1.5:2020, technique: heat input (section number not confirmed)

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