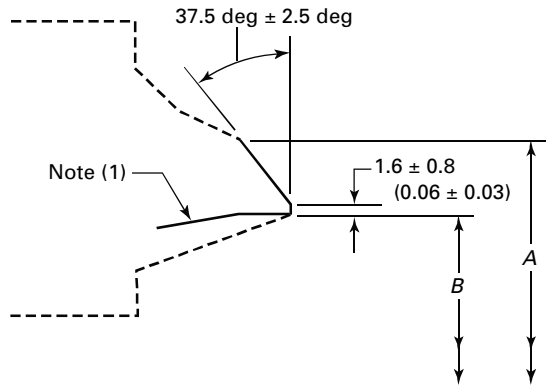
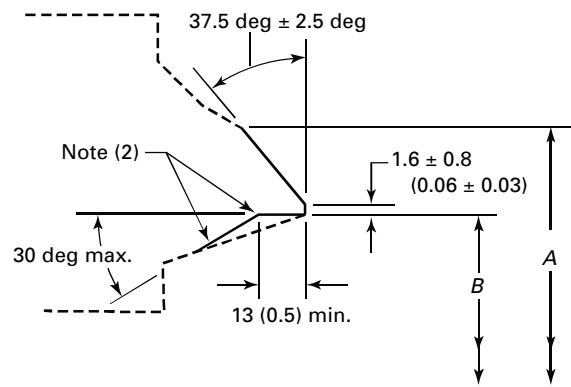


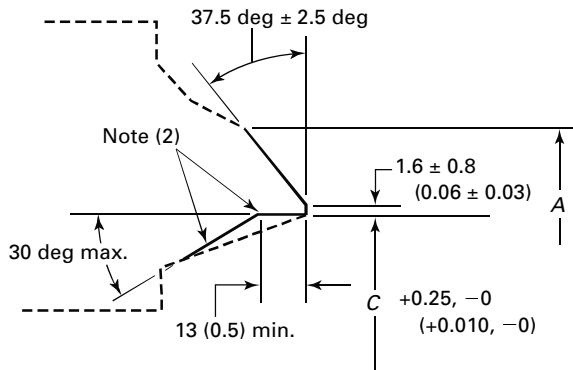
**Fig. 2 Bevels for Wall Thickness Over 3 mm (0.12 in.) to 22 mm (0.88 in.), Inclusive**



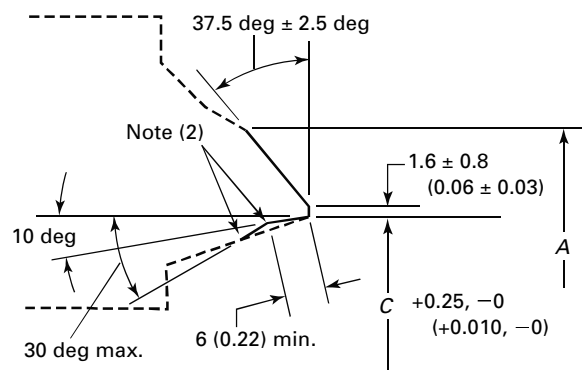
**(a) Welding End Detail for Joint Without Backing Ring**



**(b) Welding End Detail for Joint Using Split Rectangular Backing Ring**



**(c) Welding End Detail for Joint Using Continuous Rectangular Backing Ring**



**(d) Welding End Detail for Joint Using Continuous Tapered Backing Ring**

**GENERAL NOTES:**

(a) Broken lines denote maximum envelope for transitions from welding bevel and root face into body of component. See Fig. 1 for details.

(b) See section 5 for tolerances other than those given in these illustrations.

(c) Purchase order must specify contour of any backing ring to be used.

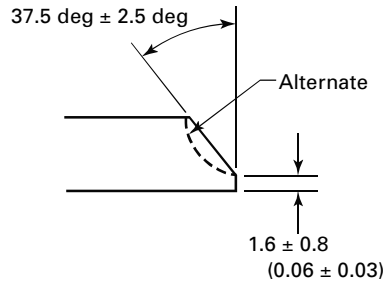
(d) Linear dimensions are in millimeters with inch values in parentheses.

**NOTES:**

(1) Internal surface may be as-formed or machined for dimension *B* at root face. Contour within the envelope shall be in accordance with section 2.

(2) Intersections should be slightly rounded.

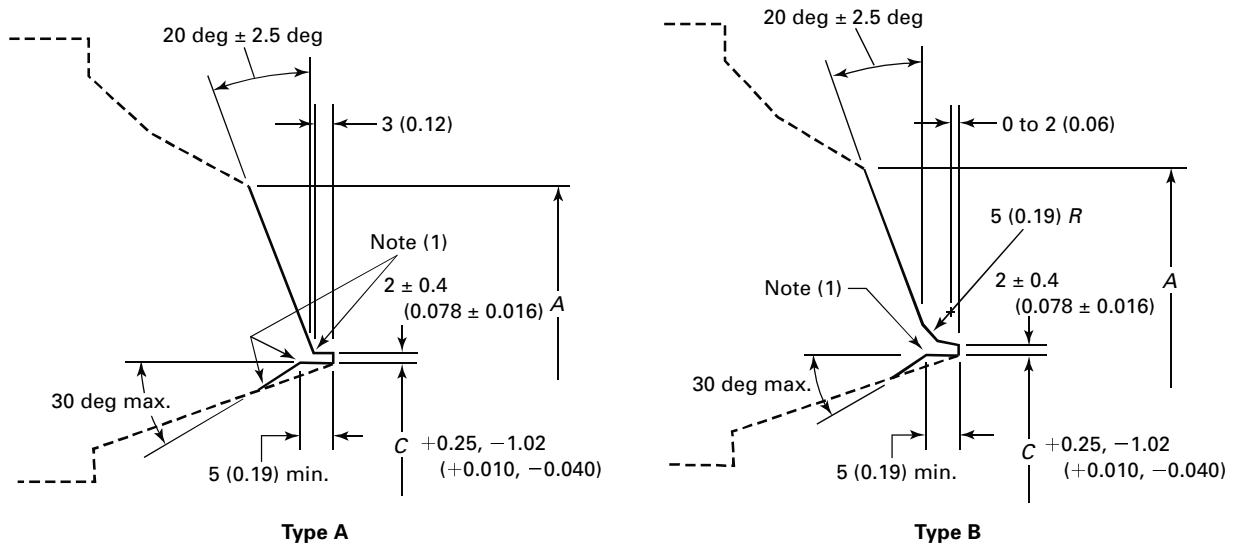
**Fig. 4 Weld Bevel Details for GTAW Root Pass**  
[Wall Thickness Over 3 mm (0.12 in.) to 10 mm (0.38 in.), Inclusive]



**GENERAL NOTES:**

- (a) This detail applies for gas tungsten arc welding (GTAW) of the root pass where nominal wall thickness is over 3 mm (0.12 in.) to 10 mm (0.38 in.), inclusive.
- (b) Linear dimensions are in millimeters with inch values in parentheses.

**Fig. 5 Weld Bevel Details for GTAW Root Pass**  
[Wall Thickness Over 10 mm (0.38 in.) to 25 mm (1.0 in.), Inclusive]



**GENERAL NOTES:**

- (a) This detail applies for gas tungsten arc welding (GTAW) of the root pass where nominal wall thickness is over 10 mm (0.38 in.) to 25 mm (1.0 in.), inclusive.
- (b) Broken lines denote maximum envelope for transitions from welding groove and land into body of component. See Fig. 1 for details.
- (c) See section 5 for tolerances other than those given in these illustrations.
- (d) Linear dimensions are in millimeters with inch values in parentheses.

**NOTE:**

- (1) Inside corners should be slightly rounded.