

PART QW WELDING

ARTICLE I WELDING GENERAL REQUIREMENTS

QW-100 SCOPE

The rules in this Part apply to the preparation of Welding Procedure Specifications (WPS) and the qualification of welding procedures, welders, and welding operators for all types of manual and machine welding processes permitted in this Part. These rules may also be applied, insofar as they are applicable, to other manual or machine welding processes permitted in other Sections.

(21) QW-101 PROCEDURE SPECIFICATION

A WPS used by an organization that will have responsible operational control of production welding shall be a WPS that has been qualified by that organization in accordance with [Article II](#), or it shall be an AWS Standard Welding Procedure Specification (SWPS) listed in [Mandatory Appendix E](#) and adopted by that organization in accordance with [Article V](#).

Both WPSs and SWPSs specify the variables (including ranges, if any) under which welding must be performed. These conditions include the base metals that are permitted, the filler metals that must be used (if any), preheat and postweld heat treatment requirements, etc.

When a WPS is to be prepared by the organization, it must address, as a minimum, the specific variables, both essential and nonessential, as provided in [Article II](#) for each process to be used in production welding. In addition, when referencing codes, standards, or specifications require toughness qualification of the WPS, the supplementary essential variables must be addressed in the WPS.

When a variable is outside the scope of a WPS (e.g., the variable applies to a P-Number not included on the WPS) or is addressed by another variable (e.g., the AWS Classification specifies the filler metal product form), that variable need not be specifically addressed on the WPS or PQRs that support the WPS.

QW-102 PERFORMANCE QUALIFICATION

In performance qualification, the basic criterion established for welder qualification is to determine the welder's ability to deposit sound weld metal. The purpose of the performance qualification test for the welding operator is to determine the welding operator's mechanical ability to operate the welding equipment.

QW-103 RESPONSIBILITY

QW-103.1 Welding. Each organization shall conduct the tests required in this Section to qualify the welding procedures used in the construction of the weldments built under this Code and the performance of welders and welding operators who apply these procedures.

QW-103.2 Records. Each organization shall maintain a record of the results obtained in welding procedure and welder and welding operator performance qualifications. Refer to recommended Forms in [Nonmandatory Appendix B](#).

QW-110 WELD ORIENTATION

The orientations of welds are illustrated in [Figure QW-461.1](#) or [Figure QW-461.2](#).

QW-120 TEST POSITIONS FOR GROOVE WELDS

Groove welds may be made in test coupons oriented in any of the positions in [Figure QW-461.3](#) or [Figure QW-461.4](#) and as described in the following paragraphs, except that an angular deviation of ± 15 deg from the specified horizontal and vertical planes, and an angular deviation of ± 5 deg from the specified inclined plane are permitted during welding.

QW-121 PLATE POSITIONS

QW-121.1 Flat Position 1G. Plate in a horizontal plane with the weld metal deposited from above. Refer to [Figure QW-461.3](#), illustration (a).

QW-121.2 Horizontal Position 2G. Plate in a vertical plane with the axis of the weld horizontal. Refer to [Figure QW-461.3](#), illustration (b).

QW-121.3 Vertical Position 3G. Plate in a vertical plane with the axis of the weld vertical. Refer to [Figure QW-461.3](#), illustration (c).

QW-121.4 Overhead Position 4G. Plate in a horizontal plane with the weld metal deposited from underneath. Refer to [Figure QW-461.3](#), illustration (d).

QW-122 PIPE POSITIONS

QW-122.1 Flat Position 1G. Pipe with its axis horizontal and rolled during welding so that the weld metal is deposited from above. Refer to [Figure QW-461.4](#), illustration (a).

QW-122.2 Horizontal Position 2G. Pipe with its axis vertical and the axis of the weld in a horizontal plane. Pipe shall not be rotated during welding. Refer to [Figure QW-461.4](#), illustration (b).

QW-122.3 Multiple Position 5G. Pipe with its axis horizontal and with the welding groove in a vertical plane. Welding shall be done without rotating the pipe. Refer to [Figure QW-461.4](#), illustration (c).

QW-122.4 Multiple Position 6G. Pipe with its axis inclined at 45 deg to horizontal. Welding shall be done without rotating the pipe. Refer to [Figure QW-461.4](#), illustration (d).

QW-123 TEST POSITIONS FOR STUD WELDS

QW-123.1 Stud Welding. Stud welds may be made in test coupons oriented in any of the positions as described in [QW-121](#) for plate and [QW-122](#) for pipe (excluding [QW-122.1](#)). In all cases, the stud shall be perpendicular to the surface of the plate or pipe. See [Figures QW-461.7](#) and [QW-461.8](#).

QW-124 SPECIAL POSITIONS

QW-124.1 Test positions other than those defined in [QW-120](#) through [QW-123](#) are defined as “special positions.”

QW-130 TEST POSITIONS FOR FILLET WELDS

Fillet welds may be made in test coupons oriented in any of the positions of [Figure QW-461.5](#) or [Figure QW-461.6](#), and as described in the following paragraphs, except that an angular deviation of ± 15 deg from the specified horizontal and vertical planes is permitted during welding.

QW-131 PLATE POSITIONS

QW-131.1 Flat Position 1F. Plates so placed that the weld is deposited with its axis horizontal and its throat vertical. Refer to [Figure QW-461.5](#), illustration (a).

QW-131.2 Horizontal Position 2F. Plates so placed that the weld is deposited with its axis horizontal on the upper side of the horizontal surface and against the vertical surface. Refer to [Figure QW-461.5](#), illustration (b).

QW-131.3 Vertical Position 3F. Plates so placed that the weld is deposited with its axis vertical. Refer to [Figure QW-461.5](#), illustration (c).

QW-131.4 Overhead Position 4F. Plates so placed that the weld is deposited with its axis horizontal on the underside of the horizontal surface and against the vertical surface. Refer to [Figure QW-461.5](#), illustration (d).

QW-132 PIPE POSITIONS

QW-132.1 Flat Position 1F. Pipe with its axis inclined at 45 deg to horizontal and rotated during welding so that the weld metal is deposited from above and at the point of deposition the axis of the weld is horizontal and the throat vertical. Refer to [Figure QW-461.6](#), illustration (a).

QW-132.2 Horizontal Positions 2F and 2FR.

(a) *Position 2F.* Pipe with its axis vertical so that the weld is deposited on the upper side of the horizontal surface and against the vertical surface. The axis of the weld will be horizontal and the pipe is not to be rotated during welding. Refer to [Figure QW-461.6](#), illustration (b).

(b) *Position 2FR.* Pipe with its axis horizontal and the axis of the deposited weld in the vertical plane. The pipe is rotated during welding. Refer to [Figure QW-461.6](#), illustration (c).

QW-132.3 Overhead Position 4F. Pipe with its axis vertical so that the weld is deposited on the underside of the horizontal surface and against the vertical surface. The axis of the weld will be horizontal and the pipe is not to be rotated during welding. Refer to [Figure QW-461.6](#), illustration (d).

QW-132.4 Multiple Position 5F. Pipe with its axis horizontal and the axis of the deposited weld in the vertical plane. The pipe is not to be rotated during welding. Refer to [Figure QW-461.6](#), illustration (e).

QW-133 SPECIAL POSITIONS

QW-133.1 Test positions other than those defined in [QW-130](#) through [QW-132](#) are defined as “special positions.”

QW-140 TYPES AND PURPOSES OF TESTS AND EXAMINATIONS

QW-141 MECHANICAL TESTS

Mechanical tests used in procedure or performance qualification are specified in [QW-141.1](#) through [QW-141.5](#).

QW-141.1 Tension Tests. Tension tests as described in [QW-150](#) are used to determine the ultimate strength of groove-weld joints.

QW-141.2 Guided-Bend Tests. Guided-bend tests as described in [QW-160](#) are used to determine the degree of soundness and ductility of groove-weld joints.

QW-141.3 Fillet-Weld Tests. Tests as described in [QW-180](#) are used to determine the size, contour, and degree of soundness of fillet welds.

QW-141.4 Toughness Tests. Tests as described in [QW-171](#) and [QW-172](#) are used to determine the toughness of the weldment.

QW-141.5 Stud-Weld Test. Deflection bend, hammering, torque, or tension tests as shown in [Figures QW-466.4](#), [QW-466.5](#), and [QW-466.6](#), and a macro-examination performed in accordance with [QW-202.5](#), respectively, are used to determine acceptability of stud welds.

QW-142 SPECIAL EXAMINATIONS FOR WELDERS

Radiographic or Ultrasonic examination per [QW-191](#) may be substituted for mechanical testing of [QW-141](#) for groove-weld performance qualification as permitted in [QW-304](#) to prove the ability of welders to make sound welds.

QW-143 EXAMINATION FOR WELDING OPERATORS

Radiographic or Ultrasonic examination per [QW-191](#) may be substituted for mechanical testing of [QW-141](#) for groove weld performance qualification as permitted in [QW-305](#) to prove the ability of welding operators to make sound welds.

QW-144 VISUAL EXAMINATION

Visual examination as described in [QW-194](#) is used to determine that the final weld surfaces meet specified quality standards.

QW-150 TENSION TESTS

QW-151 SPECIMENS

Tension test specimens shall conform to one of the types illustrated in [Figures QW-462.1\(a\)](#) through [QW-462.1\(e\)](#) and shall meet the requirements of [QW-153](#).

QW-151.1 Reduced Section — Plate. Reduced-section specimens conforming to the requirements given in [Figure QW-462.1\(a\)](#) may be used for tension tests on all thicknesses of plate.

(a) For thicknesses up to and including 1 in. (25 mm), a full thickness specimen shall be used for each required tension test.

(b) For plate thickness greater than 1 in. (25 mm), full thickness specimens or multiple specimens may be used, provided [\(c\)](#) and [\(d\)](#) are complied with.

(c) When multiple specimens are used, in lieu of full thickness specimens, each set shall represent a single tension test of the full plate thickness. Collectively, all of the specimens required to represent the full thickness of the weld at one location shall comprise a set.

(d) When multiple specimens are necessary, the entire thickness shall be mechanically cut into a minimum number of approximately equal strips of a size that can be tested in the available equipment. Each specimen of the set shall be tested and meet the requirements of [QW-153](#).

QW-151.2 Reduced Section — Pipe. Reduced-section specimens conforming to the requirements given in [Figure QW-462.1\(b\)](#) may be used for tension tests on all thicknesses of pipe having an outside diameter greater than 3 in. (75 mm).

(a) For thicknesses up to and including 1 in. (25 mm), a full thickness specimen shall be used for each required tension test.

(b) For pipe thicknesses greater than 1 in. (25 mm), full thickness specimens or multiple specimens may be used, provided [\(c\)](#) and [\(d\)](#) are complied with.

(c) When multiple specimens are used, in lieu of full thickness specimens, each set shall represent a single tension test of the full pipe thickness. Collectively, all of the specimens required to represent the full thickness of the weld at one location shall comprise a set.

(d) When multiple specimens are necessary, the entire thickness shall be mechanically cut into a minimum number of approximately equal strips of a size that can be tested in the available equipment. Each specimen of the set shall be tested and meet the requirements of [QW-153](#).

For pipe having an outside diameter of 3 in. (75 mm) or less, reduced-section specimens conforming to the requirements given in [Figure QW-462.1\(c\)](#) may be used for tension tests.

QW-151.3 Turned Specimens. Turned specimens conforming to the requirements given in [Figure QW-462.1\(d\)](#) may be used for tension tests.

(a) For thicknesses up to and including 1 in. (25 mm), a single turned specimen may be used for each required tension test, which shall be a specimen of the largest diameter D of [Figure QW-462.1\(d\)](#) possible for test coupon thickness [per Note [\(a\)](#) of [Figure QW-462.1\(d\)](#)].

(b) For thicknesses over 1 in. (25 mm), multiple specimens shall be cut through the full thickness of the weld with their centers parallel to the metal surface and not

over 1 in. (25 mm) apart. The centers of the specimens adjacent to the metal surfaces shall not exceed $\frac{5}{8}$ in. (16 mm) from the surface.

(c) When multiple specimens are used, each set shall represent a single required tension test. Collectively, all the specimens required to represent the full thickness of the weld at one location shall comprise a set.

(d) Each specimen of the set shall be tested and meet the requirements of [QW-153](#).

QW-151.4 Full-Section Specimens for Pipe. Tension specimens conforming to the dimensions given in [Figure QW-462.1\(e\)](#) may be used for testing pipe with an outside diameter of 3 in. (75 mm) or less.

QW-152 TENSION TEST PROCEDURE

The tension test specimen shall be ruptured under tensile load. The tensile strength shall be computed by dividing the ultimate total load by the least cross-sectional area of the specimen as calculated from actual measurements made before the load is applied.

QW-153 ACCEPTANCE CRITERIA — TENSION TESTS

QW-153.1 Tensile Strength. Minimum values for procedure qualification are provided under the column heading "Minimum Specified Tensile, ksi" of [Table QW/QB-422](#). In order to pass the tension test, the specimen shall have a tensile strength that is not less than

(a) the minimum specified tensile strength of the base metal; or

(b) the minimum specified tensile strength of the weaker of the two, if base metals of different minimum tensile strengths are used; or

(c) the minimum specified tensile strength of the weld metal when the applicable Section provides for the use of weld metal having lower room temperature strength than the base metal;

(d) if the specimen breaks in the base metal outside of the weld or weld interface, the test shall be accepted as meeting the requirements, provided the strength is not more than 5% below the minimum specified tensile strength of the base metal.

(e) the specified minimum tensile strength is for full thickness specimens including cladding for Aluminum Alclad materials (P-No. 21 through P-No. 23) less than $\frac{1}{2}$ in. (13 mm). For Aluminum Alclad materials $\frac{1}{2}$ in. (13 mm) and greater, the specified minimum tensile strength is for both full thickness specimens that include cladding and specimens taken from the core.

QW-160 GUIDED-BEND TESTS

QW-161 SPECIMENS

Guided-bend test specimens shall be prepared by cutting the test plate or pipe to form specimens of approximately rectangular cross section. The cut surfaces shall

be designated the sides of the specimen. The other two surfaces shall be called the face and root surfaces, the face surface having the greater width of weld. The specimen thickness and bend radius are shown in [Figures QW-466.1](#), [QW-466.2](#), and [QW-466.3](#). For materials with less than 3% elongation, a macro-etch specimen shall be used in lieu of bend test at each bend test location. Acceptance criteria shall be in accordance with [QW-183\(a\)](#). [Figure QW-466.3](#) shows the recommended method of testing aluminum weldments. Guided-bend specimens are of five types, depending on whether the axis of the weld is transverse or parallel to the longitudinal axis of the specimen, and which surface (side, face, or root) is on the convex (outer) side of bent specimen. The five types are defined as follows.

QW-161.1 Transverse Side Bend. The weld is transverse to the longitudinal axis of the specimen, which is bent so that one of the side surfaces becomes the convex surface of the bent specimen. Transverse side-bend test specimens shall conform to the dimensions shown in [Figure QW-462.2](#).

Specimens of base metal thickness equal to or greater than $1\frac{1}{2}$ in. (38 mm) may be cut into approximately equal strips between $\frac{3}{4}$ in. (19 mm) and $1\frac{1}{2}$ in. (38 mm) wide for testing, or the specimens may be bent at full width (see requirements on jig width in [Figure QW-466.1](#)). When the width of the weld is so large that a bend specimen cannot be bent so that the entire weld and heat affected zones are within the bent portion, multiple specimens across the entire weld and heat affected zones shall be used.

If multiple specimens are used in either situation above, one complete set shall be made for each required test. Each specimen shall be tested and meet the requirements in [QW-163](#).

QW-161.2 Transverse Face Bend. The weld is transverse to the longitudinal axis of the specimen, which is bent so that the face surface becomes the convex surface of the bent specimen. Transverse face-bend test specimens shall conform to the dimensions shown in [Figure QW-462.3\(a\)](#). For subsizes transverse face bends, see [QW-161.4](#).

QW-161.3 Transverse Root Bend. The weld is transverse to the longitudinal axis of the specimen, which is bent so that the root surface becomes the convex surface of the bent specimen. Transverse root-bend test specimens shall conform to the dimensions shown in [Figure QW-462.3\(a\)](#). For subsizes transverse root bends, see [QW-161.4](#).

QW-161.4 Subsize Transverse Face and Root Bends. Bend specimens taken from small diameter pipe coupons may be subsized in accordance with General Note (b) of [Figure QW-462.3\(a\)](#).

QW-161.5 Longitudinal-Bend Tests. Longitudinal-bend tests may be used in lieu of the transverse side-bend, face-bend, and root-bend tests for testing weld metal or base metal combinations, which differ markedly in bending properties between

- (a) the two base metals, or
- (b) the weld metal and the base metal

QW-161.6 Longitudinal Face Bend. The weld is parallel to the longitudinal axis of the specimen, which is bent so that the face surface becomes the convex surface of the bent specimen. Longitudinal face-bend test specimens shall conform to the dimensions shown in [Figure QW-462.3\(b\)](#).

QW-161.7 Longitudinal Root Bend. The weld is parallel to the longitudinal axis of the specimen, which is bent so that the root surface becomes the convex side of the bent specimen. Longitudinal root-bend test specimens shall conform to the dimensions shown in [Figure QW-462.3\(b\)](#).

QW-162 GUIDED-BEND TEST PROCEDURE

- (21) **QW-162.1 Jigs.** Guided-bend specimens shall be bent in test jigs that are in substantial accordance with QW-466. When using the jigs illustrated in [Figure QW-466.1](#) or [Figure QW-466.2](#), the side of the specimen turned toward the gap of the jig shall be the face for face-bend specimens, the root for root-bend specimens, and the side with the greater discontinuities, if any, for side-bend specimens. The specimen shall be forced into the die by applying load on the plunger until the curvature of the specimen is such that a $\frac{1}{8}$ in. (3 mm) diameter wire cannot be inserted between the specimen and the die of [Figure QW-466.1](#), or the specimen is bottom ejected if the roller type of jig ([Figure QW-466.2](#)) is used.

When using the wrap around jig ([Figure QW-466.3](#)), the side of the specimen turned toward the roller shall be the face for face-bend specimens, the root for root-bend specimens, and the side with the greater discontinuities, if any, for side-bend specimens.

When specimens wider than $1\frac{1}{2}$ in. (38 mm) are to be bent as permitted in [Figure QW-462.2](#), the test jig mandrel must be at least $\frac{1}{4}$ in. (6 mm) wider than the specimen width.

The plunger radius, B , shall be no larger than that given in [Figure QW-466.1](#).

QW-163 ACCEPTANCE CRITERIA — BEND TESTS

The weld and heat-affected zone of a transverse weld-bend specimen shall be completely within the bent portion of the specimen after testing.

The guided-bend specimens shall have no open discontinuity in the weld or heat-affected zone exceeding $\frac{1}{8}$ in. (3 mm), measured in any direction on the convex surface of the specimen after bending. Open discontinuities occurring on the corners of the specimen during testing shall not be considered unless there is definite evidence

that they result from lack of fusion, slag inclusions, or other internal discontinuities. For corrosion-resistant weld overlay cladding, no open discontinuity exceeding $\frac{1}{16}$ in. (1.5 mm), measured in any direction, shall be permitted in the cladding, and no open discontinuity exceeding $\frac{1}{8}$ in. (3 mm) shall be permitted along the approximate weld interface.

QW-170 TOUGHNESS TESTS

QW-171 TOUGHNESS TESTS

QW-171.1 General. Toughness tests shall be made when required by referencing codes. Test procedures and apparatus shall conform to the requirements of the referencing code. When not specified by the referencing code, the test procedures and apparatus shall conform to the requirements of SA-370.

QW-171.2 Acceptance. The acceptance criteria shall be in accordance with that Section specifying toughness testing requirements.

QW-171.3 Location and Orientation of Test Specimen. The toughness test specimen removal and preparation requirements shall be as given in the Section requiring such tests.

When qualifying pipe in the 5G or 6G position, the toughness specimens shall be removed from the shaded portion of [Figure QW-463.1\(f\)](#).

QW-172 TOUGHNESS TESTS — DROP WEIGHT

QW-172.1 General. Drop-weight tests shall be made when required by referencing codes. Test procedures and apparatus shall conform to the requirements of the referencing code. When not specified by the referencing code, the test procedures and apparatus shall conform to the requirements of ASTM specification E208.

QW-172.2 Acceptance. The acceptance criteria shall be in accordance with that Section requiring drop weight tests.

QW-172.3 Location and Orientation of Test Specimen. The drop weight test specimen, the crack starter location, and the orientation shall be as given in the Section requiring such tests.

When qualifying pipe in the 5G or 6G position, the toughness specimens shall be removed from the shaded portion of [Figure QW-463.1\(f\)](#).

QW-180 FILLET-WELD TESTS

QW-181 PROCEDURE AND PERFORMANCE QUALIFICATION SPECIMENS

QW-181.1 Procedure. The dimensions and preparation of the fillet-weld test coupon for procedure qualification as required in [QW-202](#) shall conform to the requirements in [Figure QW-462.4\(a\)](#) or [Figure](#)

QW-462.4(d). The test coupon for plate-to-plate shall be cut transversely to provide five test specimen sections, each approximately 2 in. (50 mm) long. For pipe-to-plate or pipe-to-pipe, the test coupon shall be cut transversely to provide four approximately equal test specimen sections. The test specimens shall be macro-examined to the requirements of **QW-183**.

QW-181.1.1 Production Assembly Mockups. Production assembly mockups may be used in lieu of **QW-181.1**. When a production assembly mockup is used, the range qualified shall be limited to the base metal thickness, fillet weld size, and configuration of the mockup. Alternatively, multiple production assembly mockups may be qualified. The range of thicknesses of the base metal qualified shall be not less than the thickness of the thinner member tested and not greater than the thickness of the thicker member tested. The range for fillet weld sizes qualified shall be limited to no less than the smallest fillet weld tested and no greater than the largest fillet weld tested. The configuration of production assemblies shall be the same as that used in the production assembly mockup. The mockups for plate-to-shape shall be cut transversely to provide five approximately equal test specimens not to exceed approximately 2 in. (50 mm) in length. For pipe-to-shape mockups, the mockup shall be cut transversely to provide four approximately equal test specimens. For small mockups, multiple mockups may be required to obtain the required number of test specimens. The test specimens shall be macro-examined to the requirements of **QW-183**.

QW-181.2 Performance. The dimensions and the preparation of the fillet-weld test coupon for performance qualification shall conform to the requirements in **Figure QW-462.4(b)** or **Figure QW-462.4(c)**. The test coupon for plate-to-plate shall be cut transversely to provide a center section approximately 4 in. (100 mm) long and two end sections, each approximately 1 in. (25 mm) long. For pipe-to-plate or pipe-to-pipe, the test coupon shall be cut to provide two quarter sections test specimens opposite to each other. One of the test specimens shall be fracture tested in accordance with **QW-182** and the other macro-examined to the requirements of **QW-184**. When qualifying pipe-to-plate or pipe-to-pipe in the 5F position, the test specimens shall be removed as indicated in **Figure QW-463.2(h)**.

QW-181.2.1 Production Assembly Mockups. Production assembly mockups may be used in lieu of the fillet-weld test coupon requirements of **QW-181.2**. When production assembly mockups are used, the range qualified shall be limited to the fillet sizes, base metal thicknesses, and configuration of the mockup.

(a) Plate-to-Shape

(1) The mockup for plate-to-shape shall be cut transversely to provide three approximately equal test specimens not to exceed approximately 2 in. (50 mm) in length. The test specimen that contains the start and stop

of the weld shall be fracture tested in accordance with **QW-182**. A cut end of one of the remaining test specimens shall be macro-examined in accordance with **QW-184**.

(b) Pipe-to-Shape

(1) The mockup for pipe-to-shape shall be cut transversely to provide two quarter sections approximately opposite to each other. The test specimen that contains the start and stop of the weld shall be fracture tested in accordance with **QW-182**. A cut end of the other quarter section shall be macro-examined in accordance with **QW-184**. When qualifying pipe-to-shape in the 5F position, the fracture specimen shall be removed from the lower 90-deg section of the mockup.

QW-182 FRACTURE TESTS

The stem of the 4 in. (100 mm) performance specimen center section in **Figure QW-462.4(b)** or the stem of the quarter section in **Figure QW-462.4(c)**, as applicable, shall be loaded laterally in such a way that the root of the weld is in tension. The load shall be steadily increased until the specimen fractures or bends flat upon itself.

If the specimen fractures, the fractured surface shall show no evidence of cracks or incomplete root fusion, and the sum of the lengths of inclusions and porosity visible on the fractured surface shall not exceed $\frac{3}{8}$ in. (10 mm) in **Figure QW-462.4(b)** or 10% of the quarter section in **Figure QW-462.4(c)**.

QW-183 MACRO-EXAMINATION — PROCEDURE SPECIMENS

One face of each cross section of the five test specimens in **Figure QW-462.4(a)** or four test specimens in **Figure QW-462.4(d)**, as applicable shall be smoothed and etched with a suitable etchant (see **QW-470**) to give a clear definition to the weld metal and heat-affected zone. The examination of the cross sections shall include only one side of the test specimen at the area where the plate or pipe is divided into sections i.e., adjacent faces at the cut shall not be used. In order to pass the test

(a) visual examination of the cross sections of the weld metal and heat-affected zone shall show complete fusion and freedom from cracks

(b) there shall be not more than $\frac{1}{8}$ in. (3 mm) difference in the length of the legs of the fillet

QW-184 MACRO-EXAMINATION — PERFORMANCE SPECIMENS

(21)

The cut end of one of the end plate sections, approximately 1 in. (25 mm) long, in **Figure QW-462.4(b)** or the cut end of one of the pipe quarter sections in **Figure QW-462.4(c)**, as applicable, shall be smoothed and etched with a suitable etchant (see **QW-470**) to give a clear definition of the weld metal and heat-affected zone. Visual examination of the cross section of the weld metal and heat-affected zone shall reveal

(a) no incomplete fusion

- (b) no cracks
- (c) no other linear indications with a length greater than $\frac{1}{32}$ in. (0.8 mm)
- (d) no concavity or convexity greater than $\frac{1}{16}$ in. (1.5 mm)
- (e) no more than $\frac{1}{8}$ -in. (3-mm) difference between the fillet weld leg lengths

QW-185 DIFFUSION WELDING — PROCEDURE AND PERFORMANCE QUALIFICATION SPECIMENS

QW-185.1 The test block shall be a minimum of 8 in. × 8 in. (200 mm × 200 mm) and of a thickness such that there are at least 50 interface planes being welded.

QW-185.2 A minimum of three tension test specimens in accordance with the requirements of SA-370 shall be taken perpendicular to the interface planes and three parallel to the interface planes. The tension test results shall comply with QW-153.

QW-185.3 Microstructural evaluation shall be conducted in accordance with the requirements of ASTM E3 on a minimum of three cross-sections, one each from the top, center, and bottom one-third of the test coupon. The samples shall be polished, etched, and shall be free from cracks and shall show no incomplete bond or porosity on or adjacent to the bond lines. Size of each sample shall be that which can be mounted and polished to allow examination with an optical microscope at 50X to 100X magnification.

QW-190 OTHER TESTS AND EXAMINATIONS

QW-191 VOLUMETRIC NDE

QW-191.1 Radiographic Examination

QW-191.1.1 Method

The radiographic examination in QW-142 for welders and in QW-143 for welding operators shall meet the requirements of Section V, Article 2, except as follows:

(a) A written radiographic examination procedure is not required. Demonstration of image quality requirements on production or technique radiographs shall be considered satisfactory evidence of compliance with Section V, Article 2.

(b) Final acceptance of radiographs shall be based on the ability to see the prescribed image and the specified hole of a hole-type image quality indicator (IQI) or the designated wire of a wire-type IQI. The acceptance standards of QW-191.1.2 shall be met.

QW-191.1.2 Acceptance Criteria.

QW-191.1.2.1 Terminology.

(a) *Linear Indications.* Cracks, incomplete fusion, inadequate penetration, and slag are represented on the radiograph as linear indications in which the length is more than three times the width.

(b) *Rounded Indications.* Porosity and inclusions such as slag or tungsten are represented on the radiograph as rounded indications with a length three times the width or less. These indications may be circular, elliptical, or irregular in shape; may have tails; and may vary in density.

(c) *Thickness.* The term "thickness" refers to the thickness of the weld excluding any allowable reinforcement. For a groove weld joining two members having different thicknesses at the weld, thickness is the thinner of these two materials being joined.

QW-191.1.2.2 Qualification Test Welds. Weld reinforcement may be removed or left in place but shall not be considered when determining the thickness for which the welder is qualified. (21)

Welder and welding operator performance tests by radiography of welds in test assemblies shall be judged unacceptable when the radiograph exhibits any imperfections in excess of the limits specified below

(a) Linear Indications

(1) any type of crack or zone of incomplete fusion or penetration

(2) any elongated slag inclusion which has a length greater than

(-a) $\frac{1}{8}$ in. (3 mm) for thicknesses up to $\frac{3}{8}$ in. (10 mm), inclusive

(-b) $\frac{1}{3}$ the thickness when the thickness is greater than $\frac{3}{8}$ in. (10 mm) to $2\frac{1}{4}$ in. (57 mm), inclusive

(-c) $\frac{3}{4}$ in. (19 mm) for thicknesses greater than $2\frac{1}{4}$ in. (57 mm)

(3) any group of slag inclusions in line that have an aggregate length greater than the thickness in a length of 12 times that thickness, except when the distance between the successive imperfections exceeds $6L$ where L is the length of the longest imperfection in the group

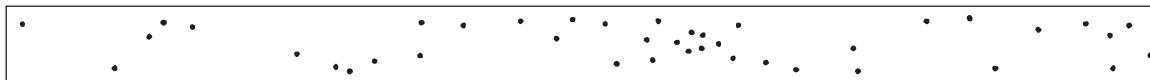
(b) Rounded Indications

(1) The maximum permissible dimension for rounded indications shall be 20% of the thickness or $\frac{1}{8}$ in. (3 mm), whichever is smaller.

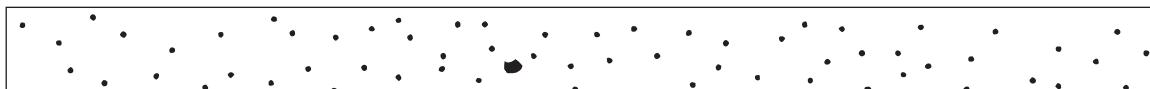
(2) For welds in material less than $\frac{1}{8}$ in. (3 mm) in thickness, the maximum number of acceptable rounded indications shall not exceed 12 in a 6 in. (150 mm) length of weld. A proportionately fewer number of rounded indications shall be permitted in welds less than 6 in. (150 mm) in length.

(3) For welds in material $\frac{1}{8}$ in. (3 mm) or greater in thickness, the charts in Figure QW-191.1.2.2(b)(4) represent the maximum acceptable types of rounded indications illustrated in typically clustered, assorted, and randomly dispersed configurations. Rounded indications less than $\frac{1}{32}$ in. (0.8 mm) in maximum diameter shall not be considered in the radiographic acceptance tests of welders and welding operators in these ranges of material thicknesses.

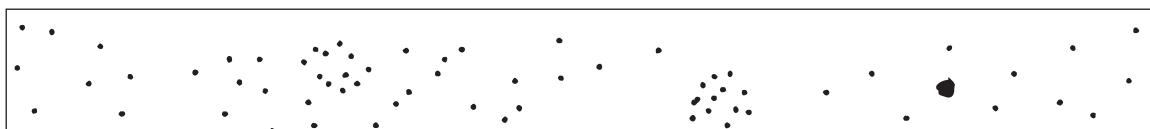
Figure QW-191.1.2.2(b)(4)
Rounded Indication Charts



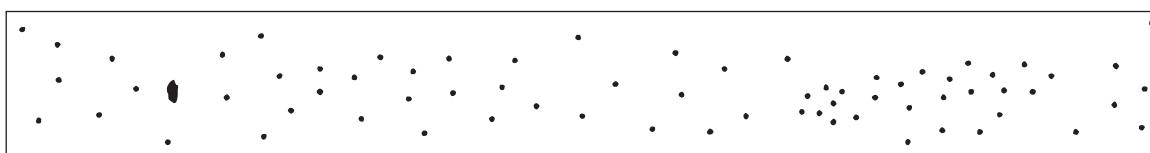
Typical Quantity and Size Permitted
in 6 in. (150 mm) Length of Weld
1/8 in. (3 mm) to 1/4 in. (6 mm)
Thickness



Typical Quantity and Size Permitted
in 6 in. (150 mm) Length of Weld
Over 1/4 in. (6 mm) to 1/2 in. (13 mm)
Thickness



Typical Quantity and Size Permitted
in 6 in. (150 mm) Length of Weld
Over 1/2 in. (13 mm) to 1 in. (25 mm)
Thickness



Typical Quantity and Size Permitted
in 6 in. (150 mm) Length of Weld
Over 1 in. (25 mm) Thickness

QW-191.1.2.3 Production Welds. The acceptance criteria for welders or welding operators who qualify on production welds by radiography as permitted in QW-304.1 or QW-305.1 shall be per QW-191.1.2.2

QW-191.2 Ultrasonic Examination

(21) QW-191.2.1 Method

(a) The ultrasonic examination in QW-142 for welders and in QW-143 for welding operators may be conducted on test welds in material $\frac{1}{4}$ in. (6 mm) thick or greater.

(b) Ultrasonic examinations shall be performed using a written procedure in compliance with Section V, Article 1, T-150 and the requirements of Section V, Article 4 for methods and procedures.

(c) For terminology, see QW-191.1.2.1.

(21) QW-191.2.2 Acceptance Criteria for Qualification

Test Welds. Weld reinforcement may be removed or left in place but shall not be considered when determining the deposited weld thickness for which the welder is qualified.

Indications shall be sized using the applicable technique(s) provided in the written procedure for the examination method. Indications shall be evaluated for acceptance as follows:

(a) All indications characterized as cracks, lack of fusion, or incomplete penetration are unacceptable regardless of length.

(b) Indications exceeding $\frac{1}{8}$ in. (3 mm) in length are considered relevant, and are unacceptable when their lengths exceed

(1) $\frac{1}{8}$ in. (3 mm) for thicknesses up to $\frac{3}{8}$ in. (10 mm), inclusive

(2) $\frac{1}{3}$ the thickness for thicknesses greater than $\frac{3}{8}$ in. up to $2\frac{1}{4}$ in. (10 mm to 57 mm), inclusive

(3) $\frac{3}{4}$ in. (19 mm) for thicknesses greater than $2\frac{1}{4}$ in. (57 mm)

QW-191.2.3 Acceptance Criteria for Production Welds. The acceptance criteria for welders or welding operators who qualify on production welds by ultrasonic examination as permitted in QW-304.1 or QW-305.1 shall be per QW-191.2.2.

QW-191.3 Record of Tests. The results of welder and welding operator performance tests evaluated by volumetric NDE shall be recorded in accordance with QW-301.4.

QW-191.4 Personnel Qualifications and Certifications.

(a) All personnel performing volumetric examinations for welder and welding operator qualifications shall be qualified and certified in accordance with their employer's written practice.

(b) The employer's written practice for qualification and certification of examination personnel shall meet all applicable requirements of Section V, Article 1.

(c) If the weld being examined is a production weld, the examiner may be qualified and certified in accordance with the requirements of the referencing code as an alternative to the requirements of this paragraph.

QW-192 STUD-WELD TESTS

QW-192.1 Procedure Qualification Specimens.

QW-192.1.1 Required Tests. Ten stud-weld tests are required to qualify each procedure. The equipment used for stud welding shall be completely automatic except for manual starting.

Every other welding stud (five joints) shall be tested either by hammering over until one-fourth of its length is flat on the test piece, or by bending the stud to an angle of at least 15 deg and returning it to its original position using a test jig and an adapter location dimension that are in accordance with Figure QW-466.4.

The remaining five welded stud joints shall be tested in torque using a torque testing arrangement that is substantially in accordance with Figure QW-466.5. Alternatively, where torquing is not feasible, tensile testing may be used, and the fixture for tensile testing shall be similar to that shown in Figure QW-466.6, except that studs without heads may be gripped on the unwelded end in the jaws of the tensile testing machine.

QW-192.1.2 Acceptance Criteria — Bend and Hammer Tests.

Hammer Tests. In order to pass the test(s), each of the five stud welds and heat-affected zones shall be free of visible separation or fracture after bending and return bending or after hammering.

QW-192.1.3 Acceptance Criteria — Torque Tests.

In order to pass the test(s), each of the five stud welds shall be subjected to the required torque shown in the following table before failure occurs.

Required Torque for Testing Threaded Carbon Steel Studs		
Nominal Diameter of Studs, in. (mm)	Threads/in. and Series Designated	Testing Torque, ft-lb (J)
$\frac{1}{4}$ (6.4)	28 UNF	5.0 (6.8)
$\frac{1}{4}$ (6.4)	20 UNC	4.2 (5.7)
$\frac{5}{16}$ (7.9)	24 UNF	9.5 (12.9)
$\frac{5}{16}$ (7.9)	18 UNC	8.6 (11.7)
$\frac{3}{8}$ (9.5)	24 UNF	17 (23.0)
$\frac{3}{8}$ (9.5)	16 UNC	15 (20.3)
$\frac{7}{16}$ (11.1)	20 UNF	27 (36.6)
$\frac{7}{16}$ (11.1)	14 UNC	24 (32.5)
$\frac{1}{2}$ (12.7)	20 UNF	42 (57.0)
$\frac{1}{2}$ (12.7)	13 UNC	37 (50.2)
$\frac{9}{16}$ (14.3)	18 UNF	60 (81.4)
$\frac{9}{16}$ (14.3)	12 UNC	54 (73.2)
$\frac{5}{8}$ (15.9)	18 UNF	84 (114.0)
$\frac{5}{8}$ (15.9)	11 UNC	74 (100.0)
$\frac{3}{4}$ (19.0)	16 UNF	147 (200.0)
$\frac{3}{4}$ (19.0)	10 UNC	132 (180.0)

Table continued

Required Torque for Testing Threaded Carbon Steel Studs		
Nominal Diameter of Studs, in. (mm)	Threads/in. and Series Designated	Testing Torque, ft-lb (J)
7/8 (22.2)	14 UNF	234 (320.0)
7/8 (22.2)	9 UNC	212 (285.0)
1 (25.4)	12 UNF	348 (470.0)
1 (25.4)	8 UNC	318 (430.0)

Required Torque for Testing Threaded Austenitic Stainless Steel Studs		
Nominal Diameter of Studs, in. (mm)	Threads/in. and Series Designated	Testing Torque, ft-lb (J)
1/4 (6.4)	28 UNF	4.5 (6.1)
1/4 (6.4)	20 UNC	4.0 (5.4)
5/16 (7.9)	24 UNF	9.0 (12.2)
5/16 (7.9)	18 UNC	8.0 (10.8)
3/8 (9.5)	24 UNF	16.5 (22.4)
3/8 (9.5)	16 UNC	14.5 (19.7)
7/16 (11.1)	20 UNF	26.0 (35.3)
7/16 (11.1)	14 UNC	23.0 (31.2)
1/2 (12.7)	20 UNF	40.0 (54.2)
1/2 (12.7)	13 UNC	35.5 (48.1)
5/8 (15.9)	18 UNF	80.00 (108.5)
5/8 (15.9)	11 UNC	71.00 (96.3)
3/4 (19.0)	16 UNF	140.00 (189.8)
3/4 (19.0)	10 UNC	125.00 (169.5)
7/8 (22.2)	14 UNF	223.00 (302.3)
7/8 (22.2)	9 UNC	202.00 (273.9)
1 (25.4)	14 UNF	339.00 (459.6)
1 (25.4)	8 UNC	303.00 (410.8)

Alternatively, where torquing to destruction is not feasible, tensile testing may be used. For carbon and austenitic stainless steel studs, the failure strength shall be not less than 35,000 psi (240 MPa) and 30,000 psi (210 MPa), respectively. For other metals, the failure strength shall not be less than half of the minimum specified tensile strength of the stud material. The failure strength shall be based on the minor diameter of the threaded section of externally threaded studs, except where the shank diameter is less than the minor diameter, or on the original cross-sectional area where failure occurs in a nonthreaded, internally threaded, or reduced-diameter stud.

(21) **QW-192.1.4 Macro-Examination.** In order to pass the macro-examination, each of the five sectioned specimens shall be smoothed and etched with a suitable etchant (see QW-470) to give clear definition of the stud welds and the heat-affected zones. The welds and heat-affected zones shall be free of cracks when examined at 10X magnification.

QW-192.2 Performance Qualification Specimens.

QW-192.2.1 Required Tests. Five stud-weld tests are required to qualify each stud-welding operator. The equipment used for stud welding shall be completely automatic except for manual starting. The performance test shall be welded in accordance with a qualified WPS per QW-3012.

Each stud (five joints) shall be tested either by hammering over until one-fourth of its length is flat on the test piece or by bending the stud to an angle of at least 15 deg and returning it to its original position using a test jig and an adapter location dimension that are in accordance with Figure QW-466.4.

QW-192.2.2 Acceptance Criteria — Bend and Hammer Tests. In order to pass the test(s), each of the five stud welds and heat affected zones shall be free of visible separation or fracture after bending and return bending or after hammering.

QW-193 TUBE-TO-TUBESHEET TESTS

When the applicable Code Section requires the use of this paragraph for tube-to-tubesheet demonstration mockup qualification, QW-193.1 through QW-193.1.3 shall apply.

QW-193.1 Procedure Qualification Specimens. Ten mockup welds are required for qualifying each tube-to-tubesheet welding procedure. The mockup assembly shall essentially duplicate the tube-to-tubesheet weld joint design to be used in production, within the limits of the essential variables of QW-288. The mockup test assembly shall be prepared with the tubesheet element having a thickness not less than the lesser of the thickness of the production tubesheet or 2 in. (50 mm). For tube-to-tubesheet welds to clad tubesheets, the cladding or overlay may be represented by a base material with a chemical composition that is essentially equivalent to the cladding composition. All welds in the mockup assembly shall be subjected to the following tests and shall meet the applicable acceptance criteria.

QW-193.1.1 Visual Examination. The accessible surfaces of the welds shall be examined visually with no magnification required. The welds shall show complete fusion, be free from visual cracks or porosity indications, and have no evidence of burning through the tube wall.

QW-193.1.2 Liquid Penetrant. The liquid penetrant examination shall meet the requirements of Section V, Article 6. The weld surfaces shall meet the requirements of QW-195.2.

QW-193.1.3 Macro-Examination. The mockup welds shall be sectioned through the center of the tube for macro-examination. The four exposed surfaces shall be smoothed and etched with a suitable etchant (see QW-470) to give a clear definition of the weld and heat-affected zone. Using a magnification of 10X to 20X, the exposed cross sections of the weld shall confirm

- (a) minimum leak path dimension required by the design
- (b) no cracking
- (c) complete fusion of the weld deposit into the tube-sheet and tube wall face

QW-193.2 Performance Qualification Specimens. A minimum of five mockup tube-to-tubesheet welds are required to qualify each welder or welding operator. The same rules as those applicable for procedure qualification (QW-193.1) shall be followed, with the following additional requirements and exceptions:

- (a) The essential variables in QW-387 shall apply.
- (b) Essential performance qualification variables applicable for each welding process listed in QW-350 or QW-360 shall also be observed in addition to the variables of Table QW-388.
- (c) Postweld heat treatment may be omitted.

Only one mockup weld is required to renew a welder's or welding operator's qualification when that qualification has expired or has been revoked per the requirements of QW-322.

QW-194 VISUAL EXAMINATION — PERFORMANCE

Performance test coupons shall show no cracks and complete joint penetration with complete fusion of weld metal and base metal.

QW-195 LIQUID PENETRANT EXAMINATION

QW-195.1 The liquid penetrant examination in QW-214 for corrosion-resistant weld metal overlay shall meet the requirements of Section V, Article 6. The acceptance standards of QW-195.2 shall be met.

QW-195.2 Liquid Penetrant Acceptance Criteria.

QW-195.2.1 Terminology.

relevant indications: indications with major dimensions greater than $\frac{1}{16}$ in. (1.5 mm)

linear indications: an indication having a length greater than three times the width.

rounded indications: an indication of circular or elliptical shape with the length equal to or less than three times the width.

QW-195.2.2 Acceptance Standards. Procedure and performance tests examined by liquid penetrant techniques shall be judged unacceptable when the examination exhibits any indication in excess of the limits specified in the following:

- (a) relevant linear indications
- (b) relevant rounded indications greater than $\frac{3}{16}$ in. (5 mm)
- (c) four or more relevant rounded indications in a line separated by $\frac{1}{16}$ in. (1.5 mm) or less (edge-to-edge)

QW-196 RESISTANCE WELD TESTING

QW-196.1 Macro-Examination.

QW-196.1.1 Welds shall be cross-sectioned, polished, and etched to reveal the weld metal. The section shall be examined at 10X magnification. Seam welding specimens shall be prepared as shown in Figure QW-462.7.3. The sectioned weldment shall be free of cracks, incomplete penetration, expulsions, and inclusions. Porosity shall not exceed one void in the transverse cross section or three voids in the longitudinal cross section of a specimen. The maximum dimension of any void shall not exceed 10% of the thickness of the weld bead.

QW-196.1.2 For spot and seam welds, the minimum diameter or width of the weld nugget shall be as follows in relation to thickness, T , of the thinner member. (21)

Material Thickness, T , in. (mm)	Weld Nugget Width
<0.010 (0.25)	6T
≥0.010 (0.25) and <0.020 (0.50)	5T
≥0.020 (0.50) and <0.040 (1.00)	4T
≥0.040 (1.00) and <0.069 (1.75)	3T
≥0.069 (1.75) and <0.100 (2.54)	2.50T
≥0.100 (2.54) and <0.118 (3.00)	2.25T
≥0.118 (3.00) and <0.157 (4.00)	2T
≥0.157 (4.00)	1.80T

The weld depth (extent of fusion) shall be a minimum of 20% of the thickness of the thinner ply (in each member) and a maximum of 80% of the total thickness of all plies.

QW-196.1.3 For projection welds, the width of the nugget shall be not less than 80% of the width of the projection.

QW-196.2 Mechanical Testing.

QW-196.2.1 Shear test specimens shall be prepared as shown on Figure QW-462.9. For spot and projection welds, each test specimen shall produce a strength that, when calculated according to the following equation, is no less than that specified in Table QW/QB-422 for the weaker of the two base metals joined:

$$\text{strength} = \frac{\text{load to failure}}{\text{area of the nugget}}$$

where the area of the nugget = $\pi \times d^2 / 4$ and d equals the minimum diameter of the spot or projection weld at the faying surface. The diameter shall be no less than that specified in the table in QW-196.1.2 for the thinner of the two members joined.

QW-196.2.2 Peel test specimens shall be prepared as shown in Figure QW-462.8.1 for spot and projection welding and per Figure QW-462.8.2 for seam welding. The specimens shall be peeled or separated mechanically, and fracture shall occur in the base metal by tearing out of the weld in order for the specimen to be acceptable.

QW-197 LASER BEAM WELDING (LBW) LAP JOINT TESTS

QW-197.1 Procedure Qualification Specimens.

QW-197.1.1 Required Tests. Six tension shear specimens and eight macro specimens are required to qualify each procedure. The qualification test coupon shall be prepared in accordance with [Figure QW-464.1](#). The tension shear specimens shall conform to the dimensions indicated in the table of [Figure QW-464.1](#). The longitudinal and transverse sections indicated in [Figure QW-464.1](#) shall be cross-sectioned as closely as possible through the centerline of the weld. A minimum of 1 in. (25 mm) shall be provided for examination of each longitudinal specimen. The transverse specimens shall be of sufficient length to include weld, the heat-affected zone, and portions of the unaffected base material. Cross-sections shall be smoothed and etched with a suitable etchant (see [QW-470](#)), and examined at a minimum magnification of 25X. The dimensions of the fusion zone and penetration of each weld of the transverse specimens shall be measured to the nearest hundredth of an inch and recorded.

QW-197.1.2 Acceptance Criteria — Tension Shear Tests. In order to pass the tension shear test(s), the requirements of [QW-153](#) shall apply.

QW-197.1.3 Acceptance Criteria — Macro-Examination. In order to pass the macro-examination, each of the eight specimens shall meet the following criteria:

(a) The outline of the fusion zone shall be generally consistent in size and regular in shape and uniformity of penetration.

(b) The examination of the weld area shall reveal sound weld metal, complete fusion along the bond line, and complete freedom from cracks in the weld metal and heat-affected zone.

QW-197.2 Performance Qualification Specimens.

QW-197.2.1 Required Tests. A peel test specimen at least 6 in. (150 mm) long shall be prepared as shown in [Figure QW-464.2](#) illustration (a) and macro specimens as shown in [Figure QW-464.2](#) illustration (b). The peel test specimens shall be peeled apart to destruction and the fusion zone and penetration measured to the nearest hundredth of an inch. The end of each strip of the macro coupon shall be polished and etched to clearly reveal the weld metal. The width and depth of penetration of each weld shall be measured to the nearest hundredth of an inch. Each specimen shall be examined in accordance with [QW-197.1](#).

QW-197.2.2 Acceptance Criteria — Peel Test and Macro-Examination. In order to pass the peel test and macro-examination, the dimensions of the fusion zone (averaged) and the penetration (averaged) shall be within the range of dimensions of those specified on the WPS that was used to make the test coupon.

QW-199 FLASH WELDING

QW-199.1 Procedure Qualification Test Coupons and Testing.

QW-199.1.1 Test Coupon Preparation. For coupons NPS 1 (DN 25) and smaller, four test welds shall be made, and for pipes over NPS 1 (DN 25), three test coupons shall be made using one set of welding parameters (i.e., the same equipment, base metals, joint preparation, and other essential variables to be utilized for production welding.) These variables shall be recorded on the qualification record.

QW-199.1.2 Tensile Tests. For pipes NPS 1 (DN 25) and smaller, and nontubular cross sections, two full-section tensile specimens shall be prepared in accordance with [Figure QW-462.1\(e\)](#). For pipes greater than NPS 1 (DN 25), two reduced section tension specimens shall be prepared in accordance with [Figure QW-462.1\(b\)](#) or [Figure QW-462.1\(c\)](#) from one coupon. For nontubular cross sections, two reduced section tension specimens shall be prepared in accordance with [Figure QW-462.1\(a\)](#) or [Figure QW-462.1\(d\)](#) from two of the coupons. The specimens shall be tested in accordance with [QW-150](#).

QW-199.1.3 Section and Bend Testing. The entire circumference of each remaining pipe coupon shall be cut along the axis of the pipe into an even number of strips of a length sufficient to perform bend tests. The maximum width of each strip shall be 1½ in. (38 mm) and the minimum width

$$w = T + D/4 \text{ for pipes NPS 2 (DN 50) and smaller}$$

$$w = T + D/8 \text{ for pipes greater than NPS 2 (DN 50)}$$

where

D = OD of the tube

T = nominal wall thickness

w = width of the specimen

One edge of one strip from each coupon shall be polished to a 600 grit finish with the final grinding parallel to the long axis of the strip. The polished surface shall be examined at 5X magnification. No incomplete fusion or other open flaws on the polished surface are acceptable. Defects occurring in the base metal not associated with the weld may be disregarded. For nontubular cross sections, four side-bend specimens shall be prepared from the two remaining coupons as specified in [Figure QW-462.2](#) and polished for examination.

All flash shall be removed from the strips and the welds shall be visually examined per [QW-194](#). Half of the strips from each pipe specimen shall then be prepared as root bend specimens and the remaining strips shall be

prepared as face bend specimens in accordance with [QW-160](#). The specimens shall be tested in accordance with [QW-160](#), except for the following:

(a) For P-No. 1, Groups 2 through 4 materials, the minimum bend radius (dimension *B* in [Figure QW-466.1](#)) shall be three times the thickness of the specimen.

(b) In lieu of [QW-163](#), the sum of lengths of individual open flaws on the convex surface of all the bend test specimens taken from each pipe individually shall not exceed 5% of the outside circumference of that test pipe.

QW-199.2 Flash Welding — Performance Qualification Test Coupons and Testing. One test coupon shall be welded, cut into strips, visually examined, and bend tested in accordance with [QW-199.1.3](#). Polishing and examination of a cross-section is not required.

APPENDIX I ROUNDED INDICATION CHARTS

Illustration that appeared in this Appendix in the previous edition and addenda has been designated as [Figure QW-191.1.2.2\(b\)\(4\)](#), which follows [QW-191.1.2.2\(b\)\(3\)](#).

ARTICLE II

WELDING PROCEDURE QUALIFICATIONS

QW-200 GENERAL

(21) **QW-200.1** Each organization shall prepare written Welding Procedure Specifications that are defined as follows:

(a) *Welding Procedure Specification (WPS).* A WPS is a written qualified welding procedure prepared to provide direction for making production welds to Code requirements. The WPS or other documents may be used to provide direction to the welder or welding operator to assure compliance with the Code requirements.

(b) *Contents of the WPS.* The completed WPS shall describe all the essential, nonessential, and, when required, supplementary essential variables for each welding process used in the WPS. These variables are listed for each process in [QW-250](#) and are defined in [Article IV](#), Welding Data.

The WPS shall reference the supporting Procedure Qualification Record(s) (PQR) described in [QW-200.2](#). The organization may include any other information in the WPS that may be helpful in making a Code weldment.

(c) *Changes to the WPS.* Changes may be made in the nonessential variables of a WPS to suit production requirements without requalification provided such changes are documented with respect to the essential, nonessential, and, when required, supplementary essential variables for each process. This may be by amendment to the WPS or by use of a new WPS.

Changes in essential or supplementary essential variables require requalification of the WPS (i.e., new or additional PQRs to support the change in essential or supplementary essential variables).

(d) *Format of the WPS.* The information required to be in the WPS may be in any format, written or tabular, to fit the needs of each organization, as long as every essential, nonessential, and, when required, supplementary essential variables outlined in [QW-250](#) is included or referenced.

Form QW-482 (see [Nonmandatory Appendix B](#)) has been provided as a guide for the WPS. This Form includes the required data for the SMAW, SAW, GMAW, and GTAW processes. It is only a guide and does not list all required data for other processes. It also lists some variables that do not apply to all processes (e.g., listing shielding gas which is not required for SAW). The guide does not easily lend itself to multiple process procedure specification (e.g., GTAW root with SMAW fill).

(21) **QW-200.2** Each organization shall be required to prepare a procedure qualification record which is defined as follows:

(a) *Procedure Qualification Record (PQR).* The PQR is a record of variables recorded during the welding of the test coupons. It also contains the test results of the tested specimens. Recorded variables normally fall within a small range of the actual variables that will be used in production welding.

(b) *Contents of the PQR.* The completed PQR shall document all essential and, when required, supplementary essential variables of [QW-250](#) for each welding process used during the welding of the test coupon. Nonessential or other variables used during the welding of the test coupon may be recorded at the organization's option. All variables, if recorded, shall be the actual variables (including ranges) used during the welding of the test coupon. If variables are not monitored during welding, they shall not be recorded. It is not intended that the full range or the extreme of a given range of variables to be used in production be used during qualification unless required due to a specific essential or, when required, supplementary essential variable.

The PQR shall be certified accurate by the organization. The organization may not subcontract the certification function. This certification is intended to be the organization's verification that the information in the PQR is a true record of the variables that were used during the welding of the test coupon and that the resulting tensile, bend, or macro (as required) test results are in compliance with Section IX.

One or more combinations of welding processes, filler metal, and other variables may be used when welding a test coupon. The approximate thickness of weld metal deposited, excluding weld reinforcement, shall be recorded for each set of essential and, when required, supplementary essential variables. Weld metal deposited using each set of variables shall be included in the tension, bend, toughness, and other mechanical test specimens that are required.

(c) *Changes to the PQR.* Changes to the PQR are not permitted except as described below. Editorial corrections or addenda to the PQR are permitted. An example of an editorial correction is an incorrect P-Number, F-Number, or A-Number that was assigned to a particular base metal or filler metal. An example of an addendum would be a change resulting from a Code change. For example, Section IX may assign a new F-Number to a filler metal or

adopt a new filler metal under an established F-Number. This may permit, depending on the particular construction Code requirements, an organization to use other filler metals that fall within that particular F-Number where, prior to the Code revision, the organization was limited to the particular electrode classification that was used during qualification. Additional information can be incorporated into a PQR at a later date provided the information is substantiated as having been part of the original qualification condition by lab record or similar data.

All changes to a PQR require recertification (including date) by the organization.

(d) *Format of the PQR.* Form QW-483 (see Nonmandatory Appendix B) has been provided as a guide for the PQR. The information required to be in the PQR may be in any format to fit the needs of each organization. Every essential and, when required, supplementary essential variable described in QW-250 shall be included in the PQR. Also, the type of tests, number of tests, and test results shall be listed in the PQR.

Form QW-483 does not easily lend itself to cover combinations of welding processes or more than one F-Number filler metal in one test coupon. Additional sketches or information may be attached or referenced to record the required variables.

(e) *Availability of the PQR.* The PQR shall be available for review but need not be made available to the welder or welding operator.

(f) *Multiple WPSs With One PQR or Multiple PQRs With One WPS.* Several WPSs may be prepared from the data on a single PQR (e.g., a 1G plate PQR may support WPSs for the F, V, H, and O positions on plate or pipe within all other essential variables). A single WPS may cover several sets of essential variable ranges as long as a supporting PQR exists for each essential and, when required, supplementary essential variable [e.g., a single WPS may cover a thickness range from $\frac{1}{16}$ in. (1.5 mm) through $1\frac{1}{4}$ in. (32 mm) if PQRs exist for both the $\frac{1}{16}$ in. (1.5 mm) through $\frac{3}{16}$ in. (5 mm) and $\frac{3}{16}$ in. (5 mm) through $1\frac{1}{4}$ in. (32 mm) thickness ranges].

QW-200.3 To reduce the number of welding procedure qualifications required, P-Numbers are assigned to base metals dependent on characteristics such as composition, weldability, and mechanical properties, where this can logically be done; and for steel and steel alloys (Table QW/QB-422) Group Numbers are assigned additionally to P-Numbers. These Group Numbers classify the metals within P-Numbers for the purpose of procedure qualification where toughness requirements are specified. The assignments do not imply that base metals may be indiscriminately substituted for a base metal which was used in the qualification test without consideration of the compatibility from the standpoint of metallurgical properties, postweld heat treatment, design, mechanical

properties, and service requirements. Where toughness is a consideration, it is presupposed that the base metals meet the specific requirements.

In general, toughness requirements are mandatory for all P-No. 11 quenched and tempered metals, for low temperature applications of other metals as applied to Section VIII, and for various classes of construction required by Section III. Acceptance criteria for the toughness tests are as established in the other Sections of the Code.

QW-200.4 Combination of Welding Procedures.

(21)

(a) More than one WPS having different essential, supplementary essential, or nonessential variables may be used in a single production joint. Each WPS may include one or a combination of processes, filler metals, or other variables. These provisions also apply to special process WPSs as defined in QW-251.4.

Where more than one WPS specifying different processes, filler metals, or other essential or supplementary essential variables is used, QW-451 or Table QW-453, as applicable, shall be used to determine the range of base metal thickness and maximum weld metal thickness qualified for each process, filler metal, or set of variables, and those limits shall be observed.

When following a WPS that has more than one welding process, filler metal, or set of variables, each process, filler metal, or set of variables may be used individually or in different combinations, provided

(1) the essential, nonessential, and required supplementary essential variables associated with the process, filler metal, or set of variables are applied

(2) the base metal and deposited weld metal thickness limits of QW-451 or Table QW-453, as applicable, for each process, filler metal, or set of variables are applied

(b) As an alternative to (a), a production weld may be made using a WPS that is supported by more than one PQR, provided the following conditions are met:

(1) All PQRs were qualified

(-a) with GTAW, SMAW, GMAW, FCAW, PAW, LBW, LLBW, or SAW, or combinations of these processes

(-b) on test coupons at least $\frac{1}{2}$ in. (13 mm) thick

(2) Note (1) of Tables QW-451.1 and QW-451.2 shall apply to the WPS. The WPS may be used to deposit

(-a) root layers with the process or combinations of processes on one PQR for weld metal deposits up to $2t$

(-b) fill layers with the process(es) on the other PQR(s) on base metal up to the maximum thickness qualified by the other PQR(s)

QW-201 ORGANIZATIONAL RESPONSIBILITY

The organization shall certify that they have qualified each Welding Procedure Specification, performed the procedure qualification test, and documented it with the necessary Procedure Qualification Record (PQR).

QW-202 TYPE OF TESTS REQUIRED

(21) **QW-202.1 Mechanical Tests.** The type and number of test specimens that shall be tested to qualify a groove weld procedure are given in [QW-451](#), and shall be removed in a manner similar to that shown in [Figures QW-463.1\(a\)](#) through [QW-463.1\(f\)](#). If any test specimen required by [QW-451](#) fails to meet the applicable acceptance criteria, the test coupon shall be considered as failed.

When it can be determined that the cause of failure is not related to welding parameters, another test coupon may be welded using identical welding parameters.

Alternatively, if adequate material of the original test coupon exists, additional test specimens may be removed as close as practicable to the original specimen location to replace the failed test specimens.

When it has been determined that the test failure was caused by an essential or supplementary essential variable, a new test coupon may be welded with appropriate changes to the variable(s) that was determined to cause the test failure. If the new test passes, the essential and supplementary essential variables shall be documented on the PQR.

When it is determined that the test failure was caused by one or more welding related factors other than essential or supplementary essential variables, a new test coupon may be welded with the appropriate changes to the welding related factors that were determined to cause the test failure. If the new test passes, the welding related factors that were determined to cause the previous test failure shall be addressed by the organization to ensure that the required properties are achieved in the production weldment.

Where qualification is for fillet welds only, the requirements are given in [QW-202.2\(c\)](#); and where qualification is for stud welds only, the requirements are given in [QW-202.5](#).

(21) QW-202.2 Groove and Fillet Welds

(a) *Qualification for Groove Full Penetration Welds.* Groove-weld test coupons shall qualify the thickness ranges of both base metal and deposited weld metal to be used in production. Limits of qualification shall be in accordance with [QW-451](#). The thickness, t , of deposited weld metal in [QW-451](#) shall be exclusive of weld reinforcement. WPS qualification for groove welds shall be made on groove welds using tension and guided-bend specimens. Toughness tests shall be made when required by other Section(s) of the Code. The WPS shall be qualified for use with groove welds within the range of essential variables listed.

When dissimilar thickness test coupons are welded, the "Range of Thickness T of Base Metal, Qualified" in [QW-451](#) shall be determined individually for each base metal in the test coupon. When the thicker test coupon is tapered to provide a thickness transition at the weld,

the qualified range shall be based on the base metal thickness adjacent to the toe of the weld at the thinnest end of the transition. The test specimens for tensile and bend tests may be machined to the thickness required for the thinner base metal prior to testing.

(b) *Qualification for Partial Penetration Groove Welds.* Partial penetration groove welds shall be qualified in accordance with the requirements of [QW-451](#) for both base metal and deposited weld metal thickness, except there need be no upper limit on the base metal thickness provided qualification was made on base metal having a thickness of $1\frac{1}{2}$ in. (38 mm) or more. When dissimilar thickness test coupons are welded, the provisions of [\(a\)](#) for dissimilar thickness test coupons shall be met.

(c) *Qualification for Fillet Welds.* WPS qualification for fillet welds shall be made on groove-weld test coupons using test specimens specified in [\(a\)](#) or [\(b\)](#). These qualifications may be used for welding all thicknesses of base metal for all sizes of fillet welds, and all diameters of pipe or tube in accordance with [Table QW-451.4](#). Non-pressure-retaining fillet welds, as defined in other Sections of the Code, may as an alternate be qualified with fillet weld qualification tests. Tests shall be made in accordance with [QW-180](#). Limits of qualification shall be in accordance with [Table QW-451.3](#).

QW-202.3 Weld Repair and Buildup. WPS qualified on groove welds shall be applicable for weld repairs to groove and fillet welds and for weld buildup under the following provisions:

(a) There is no limitation on the thickness of base metal or deposited weld metal for fillet welds.

(b) For other than fillet welds, the thickness range for base metal and deposited weld metal for each welding process shall be in accordance with [QW-451](#), except there need be no upper limit on the base metal thickness provided qualification was made on base metal having a thickness of $1\frac{1}{2}$ in. (38 mm) or more.

QW-202.4 Dissimilar Base Metal Thicknesses. WPS qualified on groove welds shall be applicable for production welds between dissimilar base metal thicknesses provided:

(a) the thickness of the thinner member shall be within the range permitted by [QW-451](#)

(b) the thickness of the thicker member shall be as follows:

(1) For P-No. 8, P-No. 41, P-No. 42, P-No. 43, P-No. 44, P-No. 45, P-No. 46, P-No. 49, P-No. 51, P-No. 52, P-No. 53, P-No. 61, and P-No. 62 metal, there shall be no limitation on the maximum thickness of the thicker production member in joints of similar P-Number materials provided qualification was made on base metal having a thickness of $\frac{1}{4}$ in. (6 mm) or greater.

(2) For all other metal, the thickness of the thicker member shall be within the range permitted by [QW-451](#), except there need be no limitation on the

maximum thickness of the thicker production member provided qualification was made on base metal having a thickness of $1\frac{1}{2}$ in. (38 mm) or more.

More than one procedure qualification may be required to qualify for some dissimilar thickness combinations.

- (21) **QW-202.5 Stud Welding.** Procedure qualification tests for stud welds shall be made in accordance with QW-192. The procedure qualification tests shall qualify the welding procedures for use within the range of the essential variables of Table QW-261. Except for studs used for extended heating surfaces and studs welded to P-No. 1 metals, five additional welds shall be made and subjected to a macro-test in accordance with QW-192.1.4

QW-202.6 Tube-to-Tubesheet Qualification. When the applicable Code Section requires the use of QW-193 for tube-to-tubesheet demonstration mockup qualification tests, QW-193.1 shall apply. If specific qualification test requirements are not specified by the applicable Code Section, tube-to-tubesheet welds shall be qualified with one of the following methods:

- (a) groove welds per the requirements of QW-202.2 and QW-202.4
- (b) a demonstration mockup per the requirements of QW-193.1
- (c) fillet welds per the requirements of QW-202.2(c) (for non-pressure-retaining tube-to-tubesheet welds only)

QW-203 LIMITS OF QUALIFIED POSITIONS FOR PROCEDURES

Unless specifically required otherwise by the welding variables (QW-250), a qualification in any position qualifies the procedure for all positions. The welding process and electrodes must be suitable for use in the positions permitted by the WPS. A welder or welding operator making and passing the WPS qualification test is qualified for the position tested. see QW-301.2.

QW-210 PREPARATION OF TEST COUPON

QW-211 BASE METAL

The base metals may consist of either plate, pipe, or other product forms. Qualification in plate also qualifies for pipe welding and vice versa. The dimensions of the test coupon shall be sufficient to provide the required test specimens.

QW-211.1 A weld metal overlay deposited on the base metal following a qualified WPS may be considered as the same P-Number as any base metal having a nominally matching chemical analysis.

QW-212 TYPE AND DIMENSIONS OF GROOVE WELDS

Except as otherwise provided in QW-250, the type and dimensions of the welding groove are not essential variables.

QW-214 CORROSION-RESISTANT WELD METAL OVERLAY

QW-214.1 The size of test coupons, limits of qualification, required examinations and tests, and test specimens shall be as specified in QW-214.2 and Table QW-453.

QW-214.2 The qualification test coupon for procedure qualification shall consist of base metal not less than 6 in. (150 mm) \times 6 in. (150 mm). The weld overlay cladding shall be a minimum of $1\frac{1}{2}$ in. (38 mm) wide by approximately 6 in. (150 mm) long. For qualification on pipe, the pipe length shall be a minimum of 6 in. (150 mm) and the diameter shall be the minimum needed to allow the required number of test specimens. The weld overlay shall be continuous around the circumference of the test coupon.

(a) The corrosion-resistant surface shall be examined by the liquid penetrant method and shall meet the acceptance standards as specified in QW-195.

(b) Following the liquid penetrant examination, four guided side-bend tests shall be made from the test coupon in accordance with QW-161. The test specimens shall be cut so that there are either two specimens parallel and two specimens perpendicular to the direction of the welding, or four specimens perpendicular to the direction of the welding. For coupons that are less than $\frac{3}{8}$ in. (10 mm) thick, the width of the side-bend specimens may be reduced to the thickness of the test coupon. The side-bend specimens shall be removed from locations specified in Figure QW-462.5(c) or Figure QW-462.5(d).

(c) When a chemical composition is specified in the WPS, chemical analysis specimens shall be removed at locations specified in Figure QW-462.5(b) or Figure QW-462.5(e). The chemical analysis shall be performed in accordance with Figure QW-462.5(a) and shall be within the range specified in the WPS. This chemical analysis is not required when a chemical composition is not specified on the WPS.

QW-214.3 Essential variables shall be as specified in QW-250 for the applicable welding process.

QW-215 ELECTRON BEAM WELDING, LASER BEAM WELDING, AND LOW-POWER DENSITY LASER BEAM WELDING

QW-215.1 For electron beam welding and laser beam welding (excluding low-power density laser beam welding), the WPS qualification test coupon shall be prepared with the joint geometry duplicating that to be used in production. If the production weld is to include a lap-over

(completing the weld by rewelding over the starting area of the weld, as for a girth weld), such lap-over shall be included in the WPS qualification test coupon.

QW-215.2 The mechanical testing requirements of **QW-451** shall apply.

QW-215.3 Essential variables shall be as specified in Tables **QW-260**, **QW-264**, and **QW-264.2** for the applicable welding process.

(21) **QW-215.4** A laser beam WPS or electron beam WPS previously qualified in accordance with **QW-215.1** through **QW-215.3** for groove welds may be further qualified for depositing partial-penetration groove welds provided the following conditions are met:

(a) The partial-penetration groove welds are deposited in P-No. 8, P-No. 41, P-No. 42, P-No. 43, P-No. 44, P-No. 45, P-No. 46, P-No. 49, P-No. 51, P-No. 52, P-No. 53, P-No. 61, or P-No. 62 metals or any combination of these metals.

(b) A workmanship test coupon is prepared following the previously qualified WPS, with the following exceptions:

(1) The workmanship test coupon shall consist of production parts joined by a partial-penetration groove weld with a joint geometry and dimensions falling within the specified tolerances of the production weld.

(2) For electron beam welding, the following variables may be revised from those given in the previously qualified WPS: **QW-402.6**, **QW-404.1**, **QW-404.8** (change in amount only), **QW-409.6**, **QW-409.7**, and **QW-410.7**.

(3) For laser beam welding, the following variables may be revised from those given in the previously qualified WPS: **QW-402.26**, **QW-403.3**, **QW-404.8** (change in amount only), **QW-408.12**, **QW-409.21**, **QW-410.7**, **QW-410.14**, **QW-410.37**, **QW-410.66**, and **QW-410.80**.

(c) A minimum of four cross sections of the partial-penetration groove weld in each workmanship test coupon shall be sectioned, polished, and etched with a suitable etchant to reveal the weld and heat-affected zone (see **QW-470**). If the workmanship test coupon includes a lap-over, then one of the cross sections shall be taken from that location.

(d) The workmanship test coupon shall be acceptable when the weld and heat-affected zones of each cross section exhibit complete fusion and are free of cracks when visually examined at 10X magnification. Any indications $\frac{1}{32}$ in. (0.8 mm) in length at the root of the weld may be disregarded. The depth of penetration of each cross section shall be measured to within 0.01 in. (0.3 mm) and shall meet the specified production requirements.

(e) A workmanship PQR shall be prepared to document the workmanship test and shall include the information listed in (1) through (4).

(1) the essential variables observed when preparing the workmanship test coupon

(2) the geometric configuration and dimensions of the production parts at the weld joint

(3) a photomicrograph of at least one cross section

(4) the observed depth of weld-joint penetration, measured to within 0.01 in. (0.3 mm), for all four cross sections

(f) A workmanship WPS shall be prepared based on the workmanship PQR and shall include the information listed in (1) through (4).

(1) reference to the previously qualified groove-weld PQR and the workmanship PQR

(2) the essential variable ranges based on the observed and recorded information on the workmanship PQR

(3) the geometric configuration and dimensions of the production parts to be welded

(4) the minimum required depth of weld penetration

(g) When more than one workmanship PQR has been developed to address different configurations of the production parts, a separate workmanship WPS shall be prepared for each of the production configurations to be welded.

QW-216 HARD-FACING WELD METAL OVERLAY

Hard-facing weld metal overlay refers to weld deposits made, using a variety of processes, to deter the effects of wear and/or abrasion. The requirements specified in **QW-216.1** through **QW-216.5** apply regardless of which hard-facing process is used.

QW-216.1 The size of test coupons, limits of qualification, required examinations and tests, and test specimens shall be as specified in **Table QW-453**.

QW-216.2 The test base metal coupon for procedure qualification shall have minimum dimensions of 6 in. (150 mm) wide \times approximately 6 in. (150 mm) long with a hard-faced layer a minimum of $1\frac{1}{2}$ in. (38 mm) wide \times 6 in. (150 mm) long. The minimum hard-faced thickness shall be as specified in the WPS. Alternatively, the qualification may be performed on a test base metal coupon that represents the size of the production part. For qualification on pipe, the pipe length shall be 6 in. (150 mm) minimum and the diameter shall be the minimum needed to allow the required number of test specimens. The weld overlay shall be continuous around the circumference of the test coupon.

(a) The hard-facing surface shall be examined by the liquid penetrant method and shall meet the acceptance standards in **QW-195.2** or as specified in the WPS. Surface conditioning prior to liquid penetrant examination is permitted.

(b) After surface conditioning to the minimum thickness specified in the WPS, a minimum of three hardness readings shall be made on each of the specimens from the locations shown in **Figure QW-462.5(b)** or **Figure QW-462.5(e)**. All readings shall meet the requirements of the WPS.

(c) The base metal shall be sectioned transversely to the direction of the hard-facing overlay. The two faces of the hard facing exposed by sectioning shall be polished

and etched with a suitable etchant and shall be visually examined with 5X magnification for cracks in the base metal or the heat-affected zone, lack of fusion, or other linear defects. The overlay and base metal shall meet the requirements specified in the WPS. All exposed faces shall be examined. See [Figure QW-462.5\(b\)](#) for pipe and [Figure QW-462.5\(e\)](#) for plate.

(d) When a chemical composition is specified in the WPS, chemical analysis specimens shall be removed at locations specified in [Figure QW-462.5\(b\)](#) or [Figure QW-462.5\(e\)](#). The chemical analysis shall be performed in accordance with [Figure QW-462.5\(a\)](#) and shall be within the range specified in the WPS. This chemical analysis is not required when a chemical composition is not specified on the WPS.

QW-216.3 Welding variables shall be as specified in [QW-250](#) for the applicable process.

QW-216.4 Where Spray Fuse methods of hard facing (e.g., Oxyfuel and Plasma Arc) are to be used, the coupons for these methods shall be prepared and welding variables applied in accordance with [QW-216.1](#) and [QW-216.3](#), respectively.

QW-216.5 If a weld deposit is to be used under a hard-facing weld metal overlay, a base metal with an assigned P-Number and a chemical analysis nominally matching the weld deposit chemical analysis may be substituted to qualify the PQR.

(21) **QW-217 JOINING OF CLAD MATERIALS**

The WPS for groove welds in clad metal shall be qualified by method A [see [\(a\)](#)] when any part of the cladding thickness, as permitted by the referencing Code Section, is included in the design calculations. Either method A [see [\(a\)](#)] or method B [see [\(b\)](#)] may be used when the cladding thickness is not included in the design calculations.

(a) Method A.

(1) The essential and nonessential variables of [QW-250](#) shall apply for each welding process used in production.

(2) The composite (base metal with cladding) procedure qualification test coupon shall be made using the same P-Number or unassigned base metal, cladding (major alloying elements nominal chemical composition), welding process(es), and filler metal combinations to be specified in the WPS.

(3) The qualified thickness range for the base metals (P-Number or unassigned base metal and cladding) and filler metal(s) used to weld each material shall be based on the actual test coupon thickness for each material (base metal and cladding) as applied to [QW-451](#), except that the minimum thickness of filler metal joining the cladding portion of the weldment shall be based on a chemical analysis performed in accordance with [QW-216.2\(d\)](#).

(4) The groove weld tension and side-bend test specimens (only type bend specimens permitted for this method) and number required by [QW-451](#) shall contain as much of the full thickness base metal and cladding thickness in the tested portion of the specimens as possible.

(5) The acceptance criteria for tensile tests shall be based on the tensile strength of the P-Number or unassigned base metal applied to the full thickness of the test coupon to the requirements of [QW-151.1\(a\)](#), [QW-151.1\(b\)](#), or [QW-151.1\(c\)](#), unless specified otherwise by the applicable Construction Code.

(6) The bend test requirements and acceptance criteria for side-bend specimens shall be according to [QW-162](#) and [QW-163](#). For the side-bend specimens, the bond line between the original cladding and base metal may be disregarded when evaluating the tested bend specimens if the cladding was applied by a process other than fusion welding.

(b) *Method B.* The essential and nonessential variables of [QW-250](#) shall apply for each welding process used in production for joining the base metal portion of the weldment. The PQRs that support this portion of the WPS need not be based on test coupons made with clad metal. For the corrosion-resistant overlay portion of the weld, the essential variables of [QW-251.4](#) shall apply and the test coupon and testing shall be in accordance with [Table QW-453](#). The WPS shall limit the depth of the groove, which will receive the corrosion-resistant overlay in order to ensure development of the full strength of the underlying weld in the base metal.

QW-218 APPLIED LININGS

QW-218.1 WPSs for attaching applied linings shall be qualified in accordance with [QW-202.2\(a\)](#), [QW-202.2\(b\)](#), or [QW-202.2\(c\)](#).

QW-218.2 As an alternative to the above, each process to be used in attaching applied linings to base metal shall be qualified on a test coupon welded into the form and arrangement to be used in construction using materials that are within the range of chemical composition of the metal to be used for the base plate, the lining, and the weld metal. The welding variables of [QW-250](#) shall apply except for those regarding base metal or weld metal thickness. Qualification tests shall be made for each position to be used in production welding in accordance with [Table QW-461.9](#), except that qualification in the vertical position, uphill progression shall qualify for all positions. One cross section for each position tested shall be sectioned, polished, and etched to clearly show the demarcation between the base metal and the weld metal. In order to be acceptable, each specimen shall exhibit complete fusion of the weld metal with the base metal and freedom from cracks.

- (21) **QW-218.3** When chemical analysis of the weld deposit for any elements is required, a chemical analysis shall be performed per [QW-216.2\(d\)](#) for those elements.

QW-219 FLASH WELDING

Flash welding shall be limited to automatic electrical resistance flash welding. Procedure qualification tests shall be conducted in accordance with [QW-199.1](#).

QW-219.1 Tolerances on Variables. Flash welding variables that may require adjustment during production welding are synergistically related. Accordingly, even though the variables shown in [Table QW-265](#) provide tolerances on many welding variables, the WPS shall specify the same specific variables shown on the PQR with tolerance shown for no more than one variable (e.g., if it is desired to provide a tolerance on the upset current, all other variables shown on the WPS must be the same as they are shown on the PQR). If it is desired to provide tolerances in the WPS for two variables, the first variable with a tolerance shall be set at the midpoint of its tolerance and two test coupons shall be welded with each of the upper and lower extremes of the tolerance for the second variable (i.e., four coupons must be welded). These coupons shall be examined and tested in accordance with [QW-199.1.3](#).

If it is desired to provide tolerance for a third variable, the first two variables shall be set at the midpoint of their tolerance, and two test coupons shall be welded with each of the upper and lower extremes of the new tolerances for the third variable (i.e., four coupons must be welded). These coupons shall be examined and tested in accordance with [QW-199.1.3](#).

No more than three essential variables on a WPS may show tolerances.

Production tests conducted in accordance with the requirements of other Sections may be used to satisfy this requirement.

QW-220 HYBRID WELDING PROCEDURE VARIABLES

Requirements of [QW-221](#) through [QW-223](#) shall be observed for all hybrid welding procedure qualifications.

QW-221 ESSENTIAL VARIABLES FOR HYBRID WELDING

The following essential variables are in addition to the welding variables for each welding process used during hybrid welding provided in [QW-250](#):

- (a) an addition or deletion of welding processes used in a hybrid welding process from those used during qualification.
- (b) a change in the process sequence used in a hybrid welding process from that used during qualification.

(c) a change in the process separation used in a hybrid welding process greater than 10% from that used during qualification (e.g., measured at the weld surface, measured between the welding torch and laser, etc.)

(d) a change in any angle, between each individual welding process used in a hybrid welding process or a change in any angle between the hybrid welding process and the material to be welded, of greater than 10 deg from that used during qualification.

(e) a change in the height between the individual welding processes used in a hybrid welding process and the material surface or a change in the height between the hybrid welding process and the material surface greater than 10% from that used during qualification.

QW-222 WELDING PROCESS RESTRICTIONS

The hybrid welding process shall be limited to machine or automatic welding.

QW-223 TEST COUPON PREPARATION AND TESTING

The hybrid welding procedure qualification test coupon shall be prepared in accordance with the rules in [QW-210](#) and tested in accordance with the rules in [QW-202](#).

QW-250 WELDING VARIABLES

QW-251 GENERAL

QW-251.1 Types of Variables for Welding Procedure Specifications (WPS). These variables (listed for each welding process in [Tables QW-252](#) through [QW-267](#)) are subdivided into essential variables, supplementary essential variables, and nonessential variables ([QW-401](#)). The "Brief of Variables" listed in the tables are for reference *only*. See the complete variable in Welding Data of Article IV.

QW-251.2 Essential Variables. Essential variables (21) are those in which a change, as described in the specific variables, is considered to affect the mechanical properties of the weldment and therefore shall require requalification of the WPS.

Supplementary essential variables are required for metals for which the referencing code, standard, or specification requires toughness tests and are in addition to the essential variables for each welding process.

When toughness requirements are invoked by a referencing code, standard, or specification, the supplementary essential variables are applicable to both groove and fillet welds.

QW-251.3 Nonessential Variables. Nonessential variables are those in which a change, as described in the specific variables, may be made in the WPS without requalification.

QW-251.4 Special Processes.

(a) The special process essential variables for corrosion-resistant and hard-surfacing weld metal overlays are as indicated in the following tables for the specified process. Only the variables specified for special processes shall apply. A change in the corrosion-resistant or hard-surfacing welding process shall require requalification.

(b) WPS qualified for corrosion-resistant and hard-surfacing overlay welding, in accordance with other Sections when such qualification rules were included in those Sections, may be used with the same provisions as provided in [QG-101](#).

Table QW-252
Welding Variables Procedure Specifications (WPS) — Oxyfuel Gas Welding (OFW)

Paragraph	Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-402 Joints	.1 ϕ Groove design			X
	.2 \pm Backing			X
	.3 ϕ Backing comp.			X
	.10 ϕ Root spacing			X
QW-403 Base Metals	.1 ϕ P-Number	X		
	.2 Max. T Qualified	X		
QW-404 Filler Metals	.3 ϕ Size			X
	.4 ϕ F-Number	X		
	.5 ϕ A-Number	X		
	.12 ϕ Classification	X		
QW-405 Positions	.1 + Position			X
QW-406 Preheat	.1 Decrease > 100°F (55°C)			X
QW-407 PWHT	.1 ϕ PWHT	X		
QW-408 Gas	.7 ϕ Type fuel gas	X		
QW-410 Technique	.1 ϕ String or weave			X
	.2 ϕ Flame characteristics			X
	.4 $\leftarrow \rightarrow$ Technique			X
	.5 ϕ Method cleaning			X
	.26 \pm Peening			X
	.64 Use of thermal processes	X		

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand

Table QW-252.1
Welding Variables Procedure Specifications (WPS) — Oxyfuel Gas Welding (OFW)

Paragraph	Special Process Essential Variables		Hard-Facing Spray Fuse (QW-216)
	Hard-Facing Overlay (QW-216)	Corrosion-Resistant Overlay (QW-214)	
QW-402 Joint	.16 < Finished <i>t</i>		
	.17		> Finished <i>t</i>
QW-403 Base Metals	.20 ϕ P-Number		ϕ P-Number
	.23 ϕ <i>T</i> Qualified	ϕ <i>T</i> Qualified	ϕ <i>T</i> Qualified
QW-404 Filler Metals	.12 ϕ Classification		ϕ Classification
	.42		> 5% Particle size range
	.46		ϕ Powder feed rate
QW-405 Positions	.4 + Position		+ Position
QW-406 Preheat	.4 Dec. > 100°F (55°C) preheat > Interpass		Dec. > 100°F (55°C) preheat > Interpass
	.5		ϕ Preheat maint.
QW-407 PWHT	.6 ϕ PWHT		ϕ PWHT
	.7		ϕ PWHT after fusing
QW-408 Gas	.7 ϕ Type of fuel gas		
	.14 ϕ Oxyfuel gas pressure		
	.16		ϕ > 5% Gas feed rate
	.19		ϕ Plasma or feed gas comp.
QW-410 Technique	.38 ϕ Multiple to single layer		ϕ Multiple to single layer
	.39 ϕ Torch type, tip sizer		
	.44		ϕ > 15% Torch to workpiece
	.45		ϕ Surface prep.
	.46		ϕ Spray torch
	.47		ϕ > 10% Fusing temp. or method

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand
			∅ Change

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Table QW-253
Welding Variables Procedure Specifications (WPS) — Shielded Metal-Arc Welding (SMAW)

Paragraph	Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-402 Joints	.1 ϕ Groove design			X
	.4 - Backing			X
	.10 ϕ Root spacing			X
	.11 \pm Retainers			X
QW-403 Base Metals	.5 ϕ Group Number		X	
	.6 T Limits toughness		X	
	.8 ϕ T Qualified	X		
	.9 t Pass > $\frac{1}{2}$ in. (13 mm)	X		
	.11 ϕ P-No. qualified	X		
QW-404 Filler Metals	.4 ϕ F-Number	X		
	.5 ϕ A-Number	X		
	.6 ϕ Diameter			X
	.12 ϕ Classification		X	
	.30 ϕ t	X		
	.33 ϕ Classification			X
QW-405 Positions	.1 + Position			X
	.3 ϕ $\uparrow\downarrow$ Vertical welding			X
QW-406 Preheat	.1 Decrease > 100°F (55°C)	X		
	.2 ϕ Preheat maint.			X
	.3 Increase > 100°F (55°C) (IP)		X	
QW-407 PWHT	.1 ϕ PWHT	X		
	.2 ϕ PWHT (T & T range)		X	
QW-409 Electrical Characteristics	.1 > Heat input		X	
	.4 ϕ Current or polarity		X	X
	.8 ϕ I & E range			X
QW-410 Technique	.1 ϕ String or weave			X
	.5 ϕ Method cleaning			X
	.6 ϕ Method back gouge			X
	.9 ϕ Multiple to single pass/side		X	X
	.25 ϕ Manual or automatic			X
	.26 \pm Peening			X
	.64 Use of thermal processes	X		

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand

Table QW-253.1
Welding Variables Procedure Specifications (WPS) — Shielded Metal-Arc Welding (SMAW)

		Special Process Variables		Nonessential Variables for HFO and CRO
Paragraph		Essential Variables		
		Hard-Facing Overlay (HFO) (QW-216)	Corrosion-Resistant Overlay (CRO) (QW-214)	
QW-402 Joints	.16	< Finished t	< Finished t	
QW-403 Base Metals	.20	ϕ P-Number	ϕ P-Number	
	.23	ϕ T Qualified	ϕ T Qualified	
QW-404 Filler Metals	.12	ϕ Classification		
	.37		ϕ A-Number	
	.38			ϕ Diameter (1st layer)
QW-405 Positions	.4	+ Position	+ Position	
QW-406 Preheat	.4	Dec. > 100°F (55°C) preheat > Interpass	Dec. > 100°F (55°C) preheat > Interpass	
QW-407 PWHT	.6	ϕ PWHT		
	.9		ϕ PWHT	
QW-409 Electrical Characteristics	.4	ϕ Current or polarity	ϕ Current or polarity	
	.8			ϕ I & E range
	.22	Inc. > 10% 1st layer	Inc. > 10% 1st layer	
QW-410 Technique	.1			ϕ String or weave
	.5			ϕ Method of cleaning
	.26			\pm Peening
	.38	ϕ Multiple to single layer	ϕ Multiple to single layer	

Legend:

+ Addition
- Deletion

> Increase or greater than
< Decrease or less than

↑ Uphill
↓ Downhill

← Forehand
→ Backhand

ϕ Change

Table QW-254
Welding Variables Procedure Specifications (WPS) — Submerged-Arc Welding (SAW)

Paragraph	Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-402 Joints	.1 ϕ Groove design			X
	.4 - Backing			X
	.10 ϕ Root spacing			X
	.11 \pm Retainers			X
QW-403 Base Metals	.5 ϕ Group Number		X	
	.6 T Limits		X	
	.8 ϕ T Qualified	X		
	.9 t Pass $1/2$ in. (13 mm)	X		
	.11 ϕ P-No. qualified	X		
QW-404 Filler Metals	.4 ϕ F-Number	X		
	.5 ϕ A-Number	X		
	.6 ϕ Diameter			X
	.9 ϕ Flux-wire class.	X		
	.10 ϕ Alloy flux	X		
	.24 \pm or ϕ Supplemental	X		
	.27 ϕ Alloy elements	X		
	.29 ϕ Flux designation			X
	.30 ϕ t	X		
	.33 ϕ Classification			X
	.34 ϕ Flux type	X		
	.35 ϕ Flux-wire class.		X	X
	.36 Recrushed slag	X		
QW-405 Positions	.1 + Position			X
QW-406 Preheat	.1 Decrease > 100°F (55°C)	X		
	.2 ϕ Preheat maint.			X
	.3 Increase > 100°F (55°C) (IP)		X	
QW-407 PWHT	.1 ϕ PWHT	X		
	.2 ϕ PWHT (T & T range)		X	
QW-409 Electrical Characteristics	.1 > Heat input		X	
	.4 ϕ Current or polarity		X	X
	.8 ϕ I & E range			X
QW-410 Technique	.1 ϕ String or weave			X
	.5 ϕ Method cleaning			X
	.6 ϕ Method back gouge			X
	.7 ϕ Oscillation			X
	.8 ϕ Tube-work distance			X
	.9 ϕ Multi to single pass per side		X	X
	.10 ϕ Single to multi electrodes		X	X
	.15 ϕ Electrode spacing			X
	.25 ϕ Manual or automatic			X
	.26 \pm Peening			X
	.64 Use of thermal processes	X		

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand	ϕ Change
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand	

Table QW-254.1
Welding Variables Procedure Specifications (WPS) — Submerged-Arc Welding (SAW)

Paragraph		Special Process Variables		Nonessential Variables for HFO and CRO
		Essential Variables		
		Hard-Facing Overlay (HFO) (QW-216)	Corrosion-Resistant Overlay (CRO) (QW-214)	
QW-402 Joints	.16	< Finished t	< Finished t	
QW-403 Base Metals	.20	ϕ P-Number	ϕ P-Number	
	.23	ϕ T Qualified	ϕ T Qualified	
QW-404 Filler Metals	.6			ϕ Nominal size of electrode
	.12	ϕ Classification		
	.24	\pm or $\phi > 10\%$ in supplemental filler metal	\pm or $\phi > 10\%$ in supplemental filler metal	
	.27	ϕ Alloy elements		
	.37		ϕ A-Number	
	.39	ϕ Nominal flux comp.	ϕ Nominal flux comp.	
	.57	> Strip thickness or width	> Strip thickness or width	
QW-405 Positions	.4	+ Position	+ Position	
QW-406 Preheat	.4	Dec. $> 100^{\circ}\text{F}$ (55°C) preheat > Interpass	Dec. $> 100^{\circ}\text{F}$ (55°C) preheat > Interpass	
QW-407 PWHT	.6	ϕ PWHT		
QW-409 Electrical Characteristics	.9		ϕ PWHT	
	.4	ϕ Current or polarity	ϕ Current or polarity	
	.8			ϕ I & E range
	.26	1st layer — Heat input $> 10\%$	1st layer — Heat input $> 10\%$	
QW-410 Technique	.1			ϕ String or weave
	.5			ϕ Method of cleaning
	.7			ϕ Oscillation
	.8			ϕ Tube to work distance
	.15			ϕ Electrode spacing
	.25			ϕ Manual or automatic
	.26			\pm Peening
	.38	ϕ Multiple to single layer	ϕ Multiple to single layer	
	.40		- Supplemental device	
	.50	ϕ No. of electrodes	ϕ No. of electrodes	

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand
			ϕ Change

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Table QW-255
Welding Variables Procedure Specifications (WPS) — Gas Metal-Arc Welding (GMAW and FCAW)

Paragraph		Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-402 Joints	.1	ϕ Groove design			X
	.4	- Backing			X
	.10	ϕ Root spacing			X
	.11	\pm Retainers			X
QW-403 Base Metals	.5	ϕ Group Number		X	
	.6	T Limits		X	
	.8	ϕ T Qualified	X		
	.9	t Pass > $\frac{1}{2}$ in. (13 mm)	X		
	.11	ϕ P-No. qualified	X		
QW-404 Filler Metals	.4	ϕ F-Number	X		
	.5	ϕ A-Number	X		
	.6	ϕ Diameter			X
	.12	ϕ Classification		X	
	.23	ϕ Filler metal product form	X		
	.24	\pm or ϕ Supplemental	X		
	.27	ϕ Alloy elements	X		
	.30	ϕ t	X		
	.33	ϕ Classification			X
QW-405 Positions	.1	+ Position			X
	.3	ϕ ↑ ↓ Vertical welding			X
QW-406 Preheat	.1	Decrease > 100°F (55°C)	X		
	.2	ϕ Preheat maint.			X
	.3	Increase > 100°F (55°C) (IP)		X	
QW-407 PWHT	.1	ϕ PWHT	X		
	.2	ϕ PWHT (T & T range)		X	
QW-408 Gas	.1	\pm Trail or ϕ comp.			X
	.2	ϕ Single, mixture, or %	X		
	.3	ϕ Flow rate			X
	.5	\pm or ϕ Backing flow			X
	.9	- Backing or ϕ comp.	X		
	.10	- Trail or ϕ comp.	X		
QW-409 Electrical Characteristics	.1	> Heat input		X	
	.2	ϕ Transfer mode	X		
	.4	ϕ Current or polarity		X	X
	.8	ϕ I & E range			X

Table QW-255
Welding Variables Procedure Specifications (WPS) — Gas Metal-Arc Welding (GMAW and FCAW)
(Cont'd)

Paragraph	Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-410 Technique	.1 ϕ String or weave			X
	.3 ϕ Orifice, cup, or nozzle size			X
	.5 ϕ Method cleaning			X
	.6 ϕ Method back gouge			X
	.7 ϕ Oscillation			X
	.8 ϕ Tube-work distance			X
	.9 ϕ Multiple to single pass per side		X	X
	.10 ϕ Single to multiple electrodes		X	X
	.15 ϕ Electrode spacing			X
	.25 ϕ Manual or automatic			X
	.26 \pm Peening			X
	.64 Use of thermal processes	X		

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand	ϕ Change
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand	

Table QW-255.1
Welding Variables Procedure Specifications (WPS) — Gas Metal-Arc Welding (GMAW and FCAW)

Paragraph		Special Process Variables		Nonessential Variables for HFO and CRO
		Essential Variables	Hard-Facing Overlay (HFO) (QW-216) Corrosion-Resistant Overlay (CRO) (QW-214)	
QW-402 Joints	.16	< Finished t	< Finished t	
QW-403 Base Metals	.20	ϕ P-Number	ϕ P-Number	
	.23	ϕ T Qualified	ϕ T Qualified	
	.6			ϕ Nominal size of electrode
QW-404 Filler Metals	.12	ϕ Classification		
	.23	ϕ Filler metal product form	ϕ Filler metal product form	
	.24	\pm or $\phi > 10\%$ in supplemental filler metal	\pm or $\phi > 10\%$ in supplemental filler metal	
	.27	ϕ Alloy elements		
	.37		ϕ A-Number	
QW-405 Positions	.4	+ Position	+ Position	
QW-406 Preheat	.4	Dec. $> 100^{\circ}\text{F}$ (55°C) preheat > Interpass	Dec. $> 100^{\circ}\text{F}$ (55°C) preheat > Interpass	
QW-407 PWHT	.6	ϕ PWHT		
	.9		ϕ PWHT	
QW-408 Gas	.2	ϕ Single, mixture, or %	ϕ Single, mixture, or %	
	.3			ϕ Flow rate
QW-409 Electrical Characteristics	.4	ϕ Current or polarity	ϕ Current or polarity	
	.8			ϕ I & E range
	.26	1st layer — Heat input $> 10\%$	1st layer — Heat input $> 10\%$	
QW-410 Technique	.1			ϕ String or weave
	.3			ϕ Orifice, cup, or nozzle size
	.5			ϕ Method of cleaning
	.7			ϕ Oscillation
	.8			ϕ Tube to work distance
	.25			ϕ Manual or automatic
	.26			\pm Peening
	.38	ϕ Multiple to single layer	ϕ Multiple to single layer	
	.50	ϕ No. of electrodes	ϕ No. of electrodes	

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand
			ϕ Change

Table QW-256
Welding Variables Procedure Specifications (WPS) — Gas Tungsten-Arc Welding (GTAW)

Paragraph		Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-402 Joints	.1	ϕ Groove design			X
	.5	+ Backing			X
	.10	ϕ Root spacing			X
	.11	\pm Retainers			X
QW-403 Base Metals	.5	ϕ Group Number		X	
	.6	T Limits		X	
	.8	T Qualified	X		
	.11	ϕ P-No. qualified	X		
QW-404 Filler Metals	.3	ϕ Size			X
	.4	ϕ F-Number	X		
	.5	ϕ A-Number	X		
	.12	ϕ Classification		X	
	.14	\pm Filler	X		
	.22	\pm Consum. insert			X
	.23	ϕ Filler metal product form	X		
	.30	ϕ t	X		
	.33	ϕ Classification			X
	.50	\pm Flux			X
QW-405 Positions	.1	+ Position			X
	.3	ϕ ↑ Vertical welding			X
QW-406 Preheat	.1	Decrease > 100°F (55°C)	X		
	.3	Increase > 100°F (55°C) (IP)		X	
QW-407 PWHT	.1	ϕ PWHT	X		
	.2	ϕ PWHT (T &T range)		X	
QW-408 Gas	.1	\pm Trail or ϕ comp.			X
	.2	ϕ Single, mixture, or %	X		
	.3	ϕ Flow rate			X
	.5	\pm or ϕ Backing flow			X
	.9	- Backing or ϕ comp.	X		
	.10	- Trail or ϕ comp.	X		
QW-409 Electrical Characteris- tics	.1	> Heat input		X	
	.3	\pm Pulsing I			X
	.4	ϕ Current or polarity		X	X
	.8	ϕ I & E range			X
	.12	ϕ Tungsten electrode			X

Table QW-256
Welding Variables Procedure Specifications (WPS) — Gas Tungsten-Arc Welding (GTAW) (Cont'd)

Paragraph	Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-410 Technique	.1 ϕ String or weave			X
	.3 ϕ Orifice, cup, or nozzle size			X
	.5 ϕ Method cleaning			X
	.6 ϕ Method back gouge			X
	.7 ϕ Oscillation			X
	.9 ϕ Multi to single pass per side		X	X
	.10 ϕ Single to multi electrodes		X	X
	.11 ϕ Closed to out chamber	X		
	.15 ϕ Electrode spacing			X
	.25 ϕ Manual or automatic			X
	.26 \pm Peening			X
	.64 Use of thermal processes	X		

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand	ϕ Change
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand	

Table QW-256.1
Welding Variables Procedure Specifications (WPS) — Gas Tungsten-Arc Welding (GTAW)

Paragraph		Special Process Variables		
		Essential Variables		Nonessential Variables for HFO and CRO
		Hard-Facing Overlay (HFO) (QW-216)	Corrosion-Resistant Overlay (CRO) (QW-214)	
QW-402	Joints	.16 < Finished t	< Finished t	
QW-403	Base Metals	.20 ϕ P-Number .23 ϕ T Qualified	ϕ P-Number ϕ T Qualified	
QW-404	Filler Metals	.3		ϕ Wire size
		.12 ϕ Classification		
		.14 \pm Filler metal	\pm Filler metal	
		.23 ϕ Filler metal product form	ϕ Filler metal product form	
		.37	ϕ A-Number	
QW-405	Positions	.4 + Position	+ Position	
QW-406	Preheat	.4 Dec. > 100°F (55°C) preheat > Interpass	Dec. > 100°F (55°C) preheat > Interpass	
QW-407	PWHT	.6 ϕ PWHT .9	ϕ PWHT	
QW-408	Gas	.2 ϕ Single, mixture, or % .3	ϕ Single, mixture, or %	ϕ Flow rate
QW-409	Electrical Characteristics	.4 ϕ Current or polarity	ϕ Current or polarity	
		.8		ϕ I & E range
		.12		ϕ Tungsten electrode
		.26 1st layer — Heat input > 10%	1st layer — Heat input > 10%	
QW-410	Technique	.1		ϕ String or weave
		.3		ϕ Orifice, cup, or nozzle size
		.5		ϕ Method of cleaning
		.7		ϕ Oscillation
		.15		ϕ Electrode spacing
		.25		ϕ Manual or automatic
		.26		\pm Peening
		.38 ϕ Multiple to single layer	ϕ Multiple to single layer	
		.50 ϕ No. of electrodes	ϕ No. of electrodes	
		.52		ϕ Filler metal delivery

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand	ϕ Change
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand	

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Table QW-257
Welding Variables Procedure Specifications (WPS) — Plasma-Arc Welding (PAW)

Paragraph		Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-402 Joints	.1	ϕ Groove design		X	
	.5	+ Backing			X
	.10	ϕ Root spacing			X
	.11	\pm Retainers			X
QW-403 Base Metals	.5	ϕ Group Number		X	
	.6	T Limits		X	
	.8	ϕ T Qualified	X		
	.12	ϕ P-Number or melt-in	X		
QW-404 Filler Metals	.3	ϕ Size			X
	.4	ϕ F-Number	X		
	.5	ϕ A-Number	X		
	.12	ϕ Classification		X	
	.14	\pm Filler metal	X		
	.22	\pm Consum. insert			X
	.23	ϕ Filler metal product form	X		
	.27	ϕ Alloy elements	X		
	.30	ϕ t	X		
	.33	ϕ Classification			X
QW-405 Positions	.1	+ Position			X
	.3	ϕ ↑↓ Vertical welding			X
QW-406 Preheat	.1	Decrease > 100°F (55°C)	X		
	.3	Increase > 100°F (55°C) (IP)		X	
QW-407 PWHT	.1	ϕ PWHT	X		
	.2	ϕ PWHT (T & T range)		X	
QW-408 Gas	.1	\pm Trail or ϕ comp.			X
	.4	ϕ Composition	X		
	.5	\pm Or ϕ backing flow			X
	.9	- Backing or ϕ comp.	X		
	.10	- Trail or ϕ comp.	X		
	.21	ϕ Flow rate			X
QW-409 Electrical Characteristics	.1	> Heat input		X	
	.4	ϕ Current or polarity		X	X
	.8	ϕ I & E range			X
	.12	ϕ Tungsten electrode			X
QW-410 Technique	.1	ϕ String or weave			X
	.3	ϕ Orifice, cup, or nozzle size			X
	.5	ϕ Method cleaning			X
	.6	ϕ Method back gouge			X
	.7	ϕ Oscillation			X
	.9	ϕ Multiple to single pass per side		X	X
	.10	ϕ Single to multiple electrodes		X	X
	.11	ϕ Closed to out chamber	X		
	.15	ϕ Electrode spacing			X
	.26	\pm Peening			X
	.64	Use of thermal processes	X		

**Table QW-257
Welding Variables Procedure Specifications (WPS) — Plasma-Arc Welding (PAW) (Cont'd)**

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand	ϕ Change
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand	

**Table QW-257.1
Welding Variables Procedure Specifications (WPS) — Plasma-Arc Welding (PAW)**

Paragraph		Special Process Variables			Nonessential Variables for HFO, CRO, and HFSF
		Essential Variables			
		Hard-Facing Overlay (HFO) (QW-216)	Corrosion-Resistant Overlay (CRO) (QW-214)	Hard-Facing Spray Fuse (HFSF) (QW-216)	
QW-402	.16	< Finished t	< Finished t		
	.17			> Finished t	
QW-403	.20	ϕ P-Number	ϕ P-Number	ϕ P-Number	
	.23	ϕ T Qualified	ϕ T Qualified		
QW-404	.12	ϕ Classification		ϕ Classification	
	.14	± Filler metal	± Filler metal		
	.23	ϕ Filler metal product form	ϕ Filler metal product form		
	.37		ϕ A-Number		
	.41	ϕ > 10% Powder feed rate	ϕ > 10% Powder feed rate		
	.42			ϕ > 5% Particle size	
	.43	ϕ Particle size	ϕ Particle size		
	.44	ϕ Powder type	ϕ Powder type		
	.46			ϕ Powder feed rate	
	.4	+ Position	+ Position	+ Position	
QW-405	.4	Dec. > 100°F (55°C) preheat > Interpass	Dec. > 100°F (55°C) preheat > Interpass	Dec. > 100°F (55°C) preheat > Interpass	
	.5			ϕ Preheat maintenance	
QW-407	.6	ϕ PWHT		ϕ PWHT	
	.7			ϕ PWHT after fusing	
	.9		ϕ PWHT		
QW-408	.1				± Trail or π comp.
	.16	ϕ > 5% Arc or metal feed gas	ϕ > 5% Arc or metal feed gas	ϕ > 5% Arc or metal feed gas	
	.17	ϕ Type or mixture	ϕ Type or mixture		
	.18	ϕ > 10% Mix. comp.	ϕ > 10% Mix. comp.		
	.19			ϕ Plasma or feed gas comp.	
	.20			ϕ Plasma gas flow-rate range	
QW-409	.4	ϕ Current or polarity	ϕ Current or polarity		
	.8				ϕ I & E range
	.12			ϕ Type or size of electrode	
	.23			ϕ > 10% I & E	
	.24	ϕ > 10% Filler wire watt.	ϕ > 10% Filler wire watt.		
	.25	ϕ > 10% I & E	ϕ > 10% I & E		

Table QW-257.1
Welding Variables Procedure Specifications (WPS) — Plasma-Arc Welding (PAW) (Cont'd)

		Special Process Variables			
Paragraph	Technique	Essential Variables			Nonessential Variables for HFO, CRO, and HFSF
		Hard-Facing Overlay (HFO) (QW-216)	Corrosion-Resistant Overlay (CRO) (QW-214)	Hard-Facing Spray Fuse (HFSF) (QW-216)	
QW-410	.1				ϕ String or weave (HFO and CRO only)
	.3				ϕ Orifice, cup, or nozzle size
	.5				ϕ Method of cleaning
	.7				ϕ Oscillation
	.25				ϕ Manual or automatic
	.26				± Peening
	.38	ϕ Multiple to single layer	ϕ Multiple to single layer	ϕ Multiple to single layer	
	.41	ϕ > 15% Travel speed	ϕ > 15% Travel speed		
	.43			ϕ > 10% Travel speed range	
	.44			ϕ > 15% Torch to workplace	
	.45			ϕ Surface preparation	
	.46			ϕ Spray torch	
	.47			ϕ > 10% Fusing temp. or method	
	.48	ϕ Transfer mode	ϕ Transfer mode	ϕ Transfer mode	
	.49	ϕ Torch orifice diameter	ϕ Torch orifice diameter		
	.52	ϕ Filler metal del.	ϕ Filler metal del.		

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand	ϕ Change
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand	

Table QW-258
Welding Variables Procedure Specifications (WPS) — Electroslag Welding (ESW)

Paragraph	Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-402 Joints	.1 ϕ Groove design			X
	.10 ϕ Root spacing			X
	.11 \pm Retainers	X		
QW-403 Base Metals	.1 ϕ P-Number	X		
	.4 ϕ Group Number		X	
	.9 t Pass > $1/2$ in. (13 mm)	X		
QW-404 Filler Metals	.4 ϕ F-Number	X		
	.5 ϕ A-Number	X		
	.6 ϕ Diameter			X
	.12 ϕ Classification		X	
	.17 ϕ Flux type or comp.	X		
	.18 ϕ Wire to plate	X		
	.19 ϕ Consum. guide	X		
	.33 ϕ Classification			X
	.1 ϕ PWHT	X		
QW-407 PWHT	.2 ϕ PWHT (T & T range)		X	
QW-409 Electrical Characteristics	.5 ϕ $\pm 15\%$ I & E range	X		
QW-410 Technique	.5 ϕ Method cleaning			X
	.7 ϕ Oscillation	X		
	.10 ϕ Single to multiple electrodes	X		
	.15 ϕ Electrode spacing			X
	.26 \pm Peening			X
	.64 Use of thermal processes	X		

Legend:

+ Addition
- Deletion

> Increase or greater than
< Decrease or less than

↑ Uphill
↓ Downhill

← Forehand
→ Backhand

ϕ Change

Table QW-258.1
Welding Variables Procedure Specifications (WPS) — Electroslag Welding (ESW)

Paragraph		Special Process Variables		
		Essential Variables		Nonessential Variables for HFO and CRO
		Hard-Facing Overlay (HFO) (QW-216)	Corrosion-Resistant Overlay (CRO) (QW-214)	
QW-402 Joints	.16	< Finished t	< Finished t	
QW-403 Base Metals	.20	ϕ P-Number	ϕ P-Number	
	.23	ϕ T Qualified	ϕ T Qualified	
QW-404 Filler Metals	.6			ϕ Nominal size of electrode
	.12	ϕ Classification		
	.24	\pm or $\phi > 10\%$ in supplemental filler metal	\pm or $\phi > 10\%$ in supplemental filler metal	
	.37		ϕ A-Number	
	.39	ϕ Nominal flux comp.	ϕ Nominal flux comp.	
	.57	> Strip thickness or width	> Strip thickness or width	
QW-406 Preheat	.4	Dec. $> 100^{\circ}\text{F}$ (55°C) preheat > Interpass	Dec. $> 100^{\circ}\text{F}$ (55°C) preheat > Interpass	
QW-407 PWHT	.6	ϕ PWHT		
	.9		ϕ PWHT	
QW-409 Electrical Characteristics	.4	ϕ Current or polarity	ϕ Current or polarity	
	.8			ϕ I & E range
	.26	1st layer — Heat input $> 10\%$	1st layer — Heat input $> 10\%$	
QW-410 Technique	.5			ϕ Method of cleaning
	.7			ϕ Oscillation (CRO only)
	.38	ϕ Multiple to single layer	ϕ Multiple to single layer	
	.40	- Supplemental device	- Supplemental device	
	.50	ϕ No. of electrodes	ϕ No. of electrodes	

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand
			ϕ Change

Table QW-259
Welding Variables Procedure Specifications (WPS) — Electrogas Welding (EGW)

Paragraph	Brief of Variables	Essential	Supplementary Essential	Nonsupplementary
QW-402 Joints	.1 ϕ Groove design			X
	.10 ϕ Root spacing			X
	.11 \pm Retainers	X		
QW-403 Base Metals	.1 ϕ P-Number	X		
	.5 ϕ Group Number		X	
	.6 T Limits		X	
	.8 ϕ T Qualified	X		
	.9 t Pass > $1/2$ in. (13 mm)	X		
QW-404 Filler Metals	.4 ϕ F-Number	X		
	.5 ϕ A-Number	X		
	.6 ϕ Diameter			X
	.12 ϕ Classification		X	
	.23 ϕ Filler metal product form	X		
QW-406 Preheat	.33 ϕ Classification			X
	.1 Decrease > 100°F (55°C)			X
QW-407 PWHT	.1 ϕ PWHT	X		
	.2 ϕ PWHT (T & T range)		X	
QW-408 Gas	.2 ϕ Single, mixture, or %	X		
	.3 ϕ Flow rate			X
QW-409 Electrical Characteristics	.1 > Heat input		X	
	.4 ϕ Current or polarity		X	X
	.8 ϕ I & E range			X
QW-410 Technique	.5 ϕ Method cleaning			X
	.7 ϕ Oscillation			X
	.8 ϕ Tube-work distance			X
	.9 ϕ Multiple to single pass per side		X	X
	.10 ϕ Single to multiple electrodes	X		
	.15 ϕ Electrode spacing			X
	.26 \pm Peening			X
	.64 Use of thermal processes	X		

Legend:

+ Addition
- Deletion

> Increase or greater than
< Decrease or less than

↑ Uphill
↓ Downhill

← Forehand
→ Backhand

ϕ Change

GENERAL NOTE: Automated vertical gas metal-arc welding for vertical position only.

Table QW-260
Welding Variables Procedure Specifications (WPS) — Electron Beam Welding (EBW)

Paragraph	Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-402 Joints	.1 ϕ Groove design	X		
	.2 - Backing	X		
	.6 > Fit-up gap	X		
QW-403 Base Metals	.1 ϕ P-Number	X		
	.3 ϕ Penetration	X		
	.15 ϕ P-Number	X		
QW-404 Filler Metals	.1 ϕ Cross section or speed	X		
	.2 < t or ϕ comp.	X		
	.8 \pm or ϕ Chem. comp.	X		
	.14 \pm Filler	X		
	.20 ϕ Method of addition	X		
	.21 ϕ Analysis	X		
QW-406 Preheat	.33 ϕ Classification			X
	.1 Decrease > 100°F (55°C)	X		
QW-407 PWHT	.1 ϕ PWHT	X		
QW-408 Gas	.6 ϕ Environment	X		
QW-409 Electrical Characteristics	.6 ϕ I, E, speed, distance, osc.	X		
	.7 ϕ Pulsing frequency	X		
QW-410 Technique	.5 ϕ Method cleaning			X
	.7 ϕ Oscillation	X		
	.14 ϕ Angle of beam axis	X		
	.17 ϕ Type equip.	X		
	.18 > Pressure of vacuum	X		
	.19 ϕ Filament type, size, etc.	X		
	.20 + Wash pass	X		
	.21 1 vs. 2 side welding	X		
	.64 Use of thermal processes	X		

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand	ϕ Change
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand	

Table QW-261
Welding Variables Procedure Specifications (WPS) — Stud Welding

Paragraph	Brief of Variables		Essential	Supplementary Essential	Nonessential
QW-402 Joints	.8	ϕ Stud shape size	X		
	.9	- Flux or ferrule	X		
QW-403 Base Metal	.17	ϕ Base metal or stud metal P-No.	X		
QW-405 Positions	.1	+ Position	X		
QW-406 Preheat	.1	Decrease > 100°F (55°C)	X		
QW-407 PWHT	.1	ϕ PWHT	X		
QW-408 Gas	.2	ϕ Single, mixture, or %	X		
QW-409 Electrical Characteristics	.4	ϕ Current or polarity	X		
	.9	ϕ Arc timing	X		
	.10	ϕ Amperage	X		
	.11	ϕ Power source	X		
QW-410 Technique	.22	ϕ Gun model or lift	X		
	.64	Use of thermal processes	X		

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand	ϕ Change
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand	

Table QW-262
Welding Variables Procedure Specifications (WPS) — Inertia and Continuous Drive Friction Welding

Paragraph	Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-402 Joints	.12 $\phi \pm 10$ deg	X		
	ϕ Cross section > 10%	X		
	ϕ O.D. > $\pm 10\%$	X		
	ϕ Solid-to-tube	X		
QW-403 Base Metals	.19 ϕ Base metal	X		
QW-406 Preheat	.1 ϕ Decrease > 100°F (55°C)	X		
QW-407 PWHT	.1 ϕ PWHT	X		
QW-408 Gas	.6 ϕ Environment	X		
QW-410 Technique	.27 ϕ Spp. > $\pm 10\%$	X		
	.28 ϕ Load > $\pm 10\%$	X		
	.29 ϕ Energy > $\pm 10\%$	X		
	.30 ϕ Upset > $\pm 10\%$	X		
	.64 Use of thermal processes	X		

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand	ϕ Change
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand	

Table QW-263
Welding Variables Procedure Specifications (WPS) — Resistance Welding

Paragraph	Brief of Variables	Essential	Nonessential
QW-402 Joints	.13 ϕ Spot, projection, seam	X	
	.14 ϕ Overlap, spacing	X	
	.15 ϕ Projection, shape, size	X	
QW-403 Base Metals	.1 ϕ P-No.	X	
	.21 \pm Coating, plating	X	
	.22 $\pm T$	X	
QW-407 PWHT	.1 ϕ PWHT	X	
QW-408 Gas	.23 - Gases	X	
QW-409 Electrical	.13 ϕ RWMA class	X	
	.14 $\pm \phi$ Slope	X	
	.15 ϕ Pressure, current, time	X	
	.17 ϕ Power supply		X
	.18 Tip cleaning		X
QW-410 Technique	.31 ϕ Cleaning method	X	
	.32 ϕ Pressure, time	X	
	.33 ϕ Equipment	X	
	.34 ϕ Cooling medium		X
	.35 ϕ Throat		X
	.64 Use of thermal processes	X	

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand	ϕ Change
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand	

(21)

Table QW-264
Welding Variables Procedure Specifications (WPS) — Laser Beam Welding (LBW)

Paragraph	Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-402 Joints	.2 ± Backing	X		
	.6 > Fit-up gap	X		
	.18 ϕ Lap joint config.	X		
	.25 ϕ Lap to groove	X		
	.26 < Bevel angle > 5 deg	X		
QW-403 Base Metals	.1 ϕ P-Number	X		
	.3 ϕ Penetration	X		
QW-404 Filler Metals	.1 ϕ Cross section or speed	X		
	.2 < t or ϕ comp.	X		
	.4 ϕ F-No.	X		
	.5 ϕ A-No.	X		
	.8 ± or ϕ chem. comp.	X		
	.14 ± Filler metal	X		
	.20 ϕ Method of addition	X		
QW-406 Preheat	.1 Decrease > 100°F (55°C)	X		
QW-407 PWHT	.1 ϕ PWHT	X		
QW-408 Gas	.2 ϕ Single, mixture, or %	X		
	.6 ϕ Environment	X		
	.11 ± Gases	X		
	.12 Decrease > 10% flow rate	X		
QW-409 Electrical Characteristics	.19 ϕ Pulse	X		
	.20 ϕ Mode, energy	X		
	.21 Decrease in power	X		
QW-410 Technique	.5 ϕ Method cleaning			X
	.14 ϕ Angle of beam axis	X		
	.20 + Wash pass	X		
	.21 1 vs. 2 side welding	X		
	.37 ϕ Single to multiple pass	X		
	.64 Use of thermal processes	X		
	.66 ϕ Travel, Beam factors	X		
	.67 ϕ Optical technique	X		
	.68 ϕ Type of equipment	X		
	.77 ϕ Wavelength	X		
	.80 ϕ Spot size	X		
	.86 ϕ Oscillation	X		

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand

 ϕ Change

(21)

Table QW-264.1
Welding Variables Procedure Specifications (WPS) — Laser Beam Welding (LBW)

Paragraph		Special Process Variables		
		Essential Variables		Nonessential Variables for HFO and CRO
		Hard-Facing Overlay (HFO) (QW-216)	Corrosion-Resistant Overlay (CRO) (QW-214)	
QW-402 Joints	.16	< Finished t	< Finished t	
QW-403 Base Metals	.20	ϕ P-Number	ϕ P-Number	
QW-404 Filler Metals	.12	ϕ Classification	ϕ Classification	
	.27	ϕ Alloy elements	ϕ Alloy elements	
	.44	ϕ Particle type	ϕ Particle type	
	.47	ϕ Filler or powder metal size	ϕ Filler or powder metal size	
	.48	ϕ Powder metal density	ϕ Powder metal density	
	.49	ϕ Filler metal powder feed rate	ϕ Filler metal powder feed rate	
QW-405 Positions	.1	+ Position	+ Position	
QW-406 Preheat	.4	Dec. > 100°F (55°C) preheat > Interpass	Dec. > 100°F (55°C) preheat > Interpass	
QW-407 PWHT	.6	ϕ PWHT		
	.9		ϕ PWHT	
QW-408 Gas	.2	ϕ Single, mixture, or %	ϕ Single, mixture, or %	
	.6	ϕ Environment	ϕ Environment	
	.11	\pm Gases	\pm Gases	
	.12	Decrease > 10% flow rate	Decrease > 10% flow rate	
QW-409 Electrical Characteristics	.19	ϕ Pulse	ϕ Pulse	
	.20	ϕ Mode, energy	ϕ Mode, energy	
	.21	Decrease in power	Decrease in power	
QW-410 Technique	.5			ϕ Method of cleaning
	.17	ϕ Type or model of equipment	ϕ Type or model of equipment	
	.38	ϕ Multiple to single layer	ϕ Multiple to single layer	
	.45	ϕ Method of surface prep.	ϕ Method of surface prep.	
	.52	ϕ Filler metal delivery	ϕ Filler metal delivery	
	.53	ϕ Overlap, spacing	ϕ Overlap, spacing	
	.77	ϕ Wavelength	ϕ Wavelength	
	.80	ϕ Spot size	ϕ Spot size	
	.86	ϕ Oscillation	ϕ Oscillation	

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand
			ϕ Change

(21)

Table QW-264.2
Welding Variables Procedure Specifications (WPS) — Low-Power Density Laser Beam Welding (LLBW)

Paragraph	Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-402 Joints	.1 ϕ Groove design			X
	.5 + Backing			X
	.10 ϕ Root spacing			X
	.11 \pm Retainers			X
QW-403 Base Metals	.5 ϕ Group number		X	
	.6 T Limits		X	
	.8 T Qualified	X		
	.11 ϕ P-No. qualified	X		
QW-404 Filler Metals	.3 ϕ Size			X
	.4 ϕ F-Number	X		
	.5 ϕ A-Number	X		
	.12 ϕ Classification		X	
	.14 \pm Filler	X		
	.22 \pm Consum. insert			X
	.23 ϕ Filler metal product form	X		
	.30 ϕ t	X		
	.33 ϕ Classification			X
	.50 \pm Flux			X
QW-405 Positions	.1 + Position			X
	.3 ϕ $\uparrow \downarrow$ Vertical welding			X
QW-406 Preheat	.1 Decrease $> 100^{\circ}\text{F}$ (55°C)	X		
	.3 Increase $> 100^{\circ}\text{F}$ (55°C) (IP)		X	
QW-407 PWHT	.1 ϕ PWHT	X		
	.2 ϕ PWHT (T & T range)		X	
QW-408 Gas	.1 \pm Trail or ϕ comp.			X
	.2 ϕ Single, mixture, or %	X		
	.3 ϕ Flow rate			X
	.5 \pm or ϕ Backing flow			X
	.9 - Backing or ϕ comp.	X		
	.10 ϕ Shielding or trailing	X		
QW-409 Electrical Characteristics	.1 $>$ Heat input		X	
	.19 ϕ Pulse	X		
	.20 ϕ Mode, energy	X		
	.21 Decrease in power	X		

Table QW-264.2
Welding Variables Procedure Specifications (WPS) — Low-Power Density Laser Beam Welding (LLBW) (Cont'd)

Paragraph		Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-410 Technique	.3	ϕ Orifice, cup, or nozzle size			X
	.5	ϕ Method cleaning			X
	.6	ϕ Method back gouge			X
	.7	ϕ Oscillation			X
	.9	ϕ Multi to single pass per side		X	X
	.11	ϕ Closed to out chamber	X		
	.26	\pm Peening			X
	.64	Use of thermal processes	X		
	.66	ϕ Travel, Beam factors	X		
	.67	ϕ Optical technique	X		
	.68	ϕ Type of equipment	X		
	.77	ϕ Wavelength	X		
	.80	ϕ Spot size	X		

Legend:

+ Addition
- Deletion

> Increase or greater than
< Decrease or less than

↑ Uphill
↓ Downhill

← Forehand
→ Backhand

ϕ Change

Table QW-265
Welding Variables Procedure Specifications (WPS) — Flash Welding

Paragraph		Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-402 Joints	.19	ϕ Diameter or thickness	X		
	.20	ϕ Joint configuration	X		
	.21	ϕ Method or equip. used to minimize ID flash	X		
	.22	ϕ End preparation method	X		
QW-403 Base Metals	.24	ϕ Spec., type, or grade	X		
QW-406 Preheat	.7	ϕ $> 10\%$ Amperage or number of preheat cycles, or method, or $> 25^{\circ}\text{F}$ (15°C) temperature	X		
QW-407 PWHT	.8	ϕ PWHT, PWHT cycles, or separate PWHT time or temperature	X		
QW-408 Gas	.22	ϕ Shielding gas composition, pressure, or purge time	X		
QW-409 Electrical Characteristics	.27	ϕ $> 10\%$ Flashing time	X		
	.28	ϕ $> 10\%$ Upset current time	X		
QW-410 Technique	.17	ϕ Type or model of equipment	X		
	.54	ϕ $> 10\%$ Upset length or force	X		
	.55	ϕ $> 10\%$ Distance between clamping dies or preparation of clamping area	X		
	.56	ϕ Clamping force	X		
	.57	ϕ 10% Forward or reverse speed	X		
	.64	Use of thermal processes	X		

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand
			ϕ Change

Table QW-266
Welding Variables Procedure Specifications (WPS) — Diffusion Welding (DFW)

Paragraph	Brief of Variables		Essential	Supplementary Essential	Nonessential
QW-403 Base Metals	.28	Base metal grade	X		
	.29	ϕ Surface finish	X		
QW-404 Filler Metal	.53	± Filler metal and composition	X		
QW-407 PWHT	.10	± PWHT temperature, time, cooling rate	X		
QW-408 Gas	.25	ϕ Furnace Atmosphere	X		
QW-410 Technique	.70	ϕ Preassembly Cleaning	X		
	.71	< Block Compression	X		
	.72	< Welding time or temperature	X		

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand	ϕ Change
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand	

Table QW-267
Welding Variables Procedure Specifications — Friction Stir Welding (FSW)

Paragraph	Brief of Variables	Essential	Supplementary Essential	Nonessential
QW-402 Joints	.27 ϕ Fixed backing	X		
	.28 ϕ Joint design	X		
	.29 ϕ Joint spacing > 10%	X		
QW-403 Base Metals	.19 ϕ Type or grade	X		
	.30 ϕ T qualified > 20%	X		
QW-404 Filler Metals	.14 \pm Filler metal	X		
	.55 > Thickness or width of preplaced filler metal	X		
	.56 ϕ Type/grade	X		
QW-407 PWHT	.1 ϕ PWHT	X		
QW-408 Gas	.26 ϕ Shielding gas	X		
QW-410 Technique	.21 1-side vs. 2-side welding	X		
	.73 ϕ Joint restraint	X		
	.74 ϕ Control method	X		
	.75 ϕ Tool design	X		
	.76 ϕ Tool operation	X		

Legend:

+ Addition	> Increase or greater than	↑ Uphill	← Forehand
- Deletion	< Decrease or less than	↓ Downhill	→ Backhand

QW-283 WELDS WITH BUTTERING

QW-283.1 Scope. This paragraph only applies when the essential variables for the buttering process are different than the essential variables for the process used for subsequent completion of the joint. Common examples are

(a) the buttered member is heat treated and the completed weld is not heat treated after welding

(b) the filler metal used for buttering has a different F-Number from that used for the subsequent completion of the weld

QW-283.2 Tests Required. The procedure shall be qualified by buttering the test coupon (including heat treating of the buttered member when this will be done in production welding) and then making the subsequent weld joining the members. The variables for the buttering and for the subsequent weld shall be in accordance with [QW-250](#), except that [QW-409.1](#) shall be an essential variable for the welding process(es) used to complete the weld when the minimum buttering thickness is less than $\frac{3}{16}$ in. (5 mm). Mechanical testing of the completed weldment shall be in accordance with [QW-202.2\(a\)](#).

If the buttering is done with filler metal of the same composition as the filler metal used to complete the weld, one weld test coupon may be used to qualify the dissimilar metal joint by welding the first member directly to the second member in accordance with Section IX.

QW-283.3 Buttering Thickness. The thickness of buttering which shall remain on the production buttered member after all machining and grinding is completed and before subsequent completion of the joint shall be required by the WPS. When this thickness is less than $\frac{3}{16}$ in. (5 mm), the thickness of buttering on the test coupon shall be measured before the buttered member is welded to the second member. This thickness shall become the minimum qualified thickness of buttering.

QW-283.4 Qualification Alternative. When an essential variable is changed in the portion of the weld to be made after buttering or when a different organization is performing the portion of the weld to be made after buttering, a new qualification shall be performed in accordance with one of the following methods:

(a) Qualify in accordance with [QW-283.2](#) and [QW-283.3](#). When the original qualification buttering thickness is less than $\frac{3}{16}$ in. (5 mm), the buttering thickness shall not be greater, nor the heat input higher than was used on the original qualification.

(b) When the original qualification buttering thickness is $\frac{3}{16}$ in. (5 mm) or greater, qualify the portion of the weld to be made after buttering using any P-Number material that nominally matches the chemical analysis of the buttering weld metal for the buttered base metal of the test coupon.

QW-284 RESISTANCE WELDING MACHINE QUALIFICATION

Each resistance welding machine shall be tested to determine its ability to make welds consistently and reproducibly. A machine shall be requalified whenever it is rebuilt, moved to a new location requiring a change in power supply, when the power supply is changed, or any other significant change is made to the equipment. Spot and projection welding machine qualification testing shall consist of making a set of 100 consecutive welds. Every fifth of these welds shall be subjected to mechanical shear tests. Five welds, which shall include one of the first five and one of the last five of the set shall be metallographically examined. Seam welding machine qualification testing shall be the same as procedure qualification testing required per [QW-286](#). Maintenance or adjustment of the welding machine shall not be permitted during welding of a set of test welds. Qualification testing on any P-No. 21 through P-No. 26 aluminum alloy shall qualify the machine for all materials. Qualification on P-No. 1 through P-No. 15F iron-base alloys and any P-No. 41 through P-No. 49 nickel-base alloys shall qualify the machine for all P-No. 1 through P-No. 15F and P-No. 41 through P-No. 49 metals. Qualification testing of the machine using base metals assigned to P-No. 51 through P-No. 53, P-No. 61, or P-No. 62 qualifies the welding machine to weld all base metals assigned to P-No. 51 through P-No. 53, P-No. 61, and P-No. 62. Testing and acceptance criteria shall be in accordance with [QW-196](#).

QW-285 RESISTANCE SPOT AND PROJECTION WELD PROCEDURE QUALIFICATION

Procedure qualification testing for spot or projection welds shall be done following a Welding Procedure Specification, and it shall consist of making a set of ten consecutive welds. Five of these welds shall be subjected to mechanical shear tests and five to metallographic examination. Examination, testing, and acceptance criteria shall be in accordance with [QW-196](#).

QW-286 RESISTANCE SEAM WELD PROCEDURE QUALIFICATION

QW-286.1 Test coupons described below shall consist of the same number of members, orientation, material grades or types, and thicknesses to be used in production welding.

QW-286.2 A test coupon as shown in [Figure QW-462.7.1](#) shall be prepared by drilling a hole in the center of one of the outer coupon members. In the case of a test coupon containing more than two members, a hole shall be drilled in each member except for one of the outer members. A pipe nipple shall be welded or brazed to the outer member at the hole. The test coupon shall then be welded around the edges, sealing the space between the members as shown in [Figure QW-462.7.1](#). The coupon

shall be pressurized hydrostatically until failure occurs. The procedure qualification is acceptable if failure occurs in the base metal.

QW-286.3 A test coupon at least 10 in. (250 mm) long shall be made per Figure QW-462.7.2. This test coupon shall be cut transverse to the length of the weld into ten pieces, each approximately 1 in. (25 mm) long. Four transverse weld specimens and four longitudinal weld cross section specimens shall be cut and prepared as detailed in Figure QW-462.7.2. The specimens shall be metallurgically examined for compliance with the requirements of QW-196.

QW-287 VARIATION OF SETTINGS FOR ELECTRIC RESISTANCE WELDING

Settings for preheating cycles, electrode pressure, welding current, welding time cycle, or postheating cycles may be varied by $\pm 5\%$ from the values recorded on the PQR, or by $\pm 10\%$ when only one of the above settings is changed.

QW-288 TUBE-TO-TUBESHEET QUALIFICATION ESSENTIAL VARIABLES

Essential variables applicable to tube-to-tubesheet welding procedure qualifications in accordance with QW-193 are listed in Table QW-288.1 for all welding processes except explosion welding and Table QW-288.2 for explosion welding. Essential procedure qualification variables applicable for each welding process listed in QW-250 shall also be observed in addition to the variables of QW-288. A change in the welding process used shall require requalification.

**Table QW-288.1
Essential Variables for Procedure Qualification of Tube-to-Tubesheet Welding (All Welding Processes Except Explosion Welding)**

Paragraph	Brief of Variables
QW-402 Joints	.31 < Ligament size
	.32 ϕ Joint configuration
QW-403 Base Metals	.18 ϕ P-Number or A-Number
	.32 ϕ Tube thickness
QW-404 Filler Metals	.33 ϕ P-Number
	.3 ϕ Filler metal size
	.58 \pm Preplaced filler metal
QW-405 Positions	.59 ϕ A-number
	.3 ϕ $\uparrow\downarrow$ Vertical welding
QW-406 Preheat	.4 ϕ Position
	.1 Decrease $>100^{\circ}\text{F}$ (55°C)
QW-407 PWHT	.3 Increase $>100^{\circ}\text{F}$ (55°C) (IP)
	.1 ϕ PWHT

**Table QW-288.1
Essential Variables for Procedure Qualification of Tube-to-Tubesheet Welding (All Welding Processes Except Explosion Welding) (Cont'd)**

Paragraph	Brief of Variables
QW-409 Electrical Characteristics	.4 ϕ Polarity
	.10 ϕ Amperage
QW-410 Technique	.5 ϕ Method of cleaning
	.37 ϕ Single to multiple pass
	.81 + Tube expansion

Legend:

+ Addition ϕ Change
- Deletion < Decrease or less than

GENERAL NOTE: QW-403.32, QW-404.59, QW-405.3, QW-406.1, QW-406.3, QW-409.4, QW-409.10, QW-410.25, and QW-410.37 do not apply to explosion welding.

(21)

**Table QW-288.2
Essential Variables for Procedure Qualification of Tube-to-Tubesheet Welding (Explosion Welding)**

Paragraph	Brief of Variables
QW-403 Base Metals	.34 ϕ Tube thickness
QW-410 Technique	.82 ϕ Pressure application
	.83 ϕ Explosive
	.84 ϕ Distance charge to tubesheet
	.85 ϕ Specified clearance

Legend:
 ϕ Change

QW-289 LOW-ENERGY CAPACITOR DISCHARGE WELDING

The following requirements apply to low-energy capacitor discharge welding:

- (a) The energy output shall be limited to 125 W-sec.
- (b) A Welding Procedure Specification describing the capacitor discharge equipment, the combination of materials to be joined, and the technique of application shall be prepared; qualification of the welding procedure is not required.

(21) QW-290 TEMPER BEAD WELDING

When the referencing code, standard, or specification specifies the use of this paragraph for temper bead welding, [QW-290.1](#) through [QW-290.6](#) shall apply.

QW-290.1 Basic Qualification and Upgrading of Existing Welding Procedure Specifications (WPSs). All WPSs for temper bead welding of groove and fillet weld shall be qualified for groove welding in accordance with the rules in [QW-202](#) for qualification by groove welding or the rules in [QW-283](#) for welds with buttering. WPSs for overlay shall be qualified in accordance with [QW-214](#) or [QW-216](#). Once these requirements and any additional qualification requirements of the referencing code, standard, or specification have been satisfied, then it is necessary only to prepare an additional test coupon using the same procedure with the same essential variables and, when required, the same supplementary essential variables with the coupon long enough to obtain the required temper bead test specimens. Qualification for groove welding, welding with buttering or cladding, and temper bead welding may also be done in a single test coupon.

When a WPS has been previously qualified to satisfy all requirements including temper bead welding, but one or more temper bead welding variables are changed, then it is necessary only to prepare an additional test coupon using the same WPS with the same variables and new temper bead welding essential variable(s) with the coupon long enough to obtain the required test specimens.

QW-290.2 Welding Process Restrictions. Temper bead welding is limited to SMAW, GTAW, SAW, GMAW (including FCAW), LLBW, and PAW. Manual and semiautomatic GTAW and PAW are prohibited, except for the root pass of groove welds made from one side and as described for making repairs to temper bead welds in [QW-290.6](#). The variables listed in [Table QW-290.4](#) apply in addition to the variables applicable for the process(es) qualified as given in [QW-250](#). When toughness testing is required by the referencing code, standard, or specification for acceptance, the supplementary essential variables of [QW-250](#) applicable to the process being qualified shall apply. When the variables listed in [Table QW-290.4](#) conflict with or provide more stringent limitations than those of [QW-250](#), the variables listed in [Table QW-290.4](#) shall govern.

QW-290.3 Variables for Temper Bead Welding Qualifications. [Table QW-290.4](#) lists the additional essential and nonessential variables that apply when temper bead qualification is required. The essential variables listed in column A shall apply when the referencing code, standard, or specification specifies hardness criteria for temper bead qualification acceptance. The essential variables listed in column B shall apply when the referencing code, standard, or specification specifies toughness testing criteria for temper bead qualification acceptance. The essential variables listed in column C shall apply when the referencing code, standard, or specification specifies neither hardness nor toughness test criteria. The variables listed in the "Nonessential Variables" column apply in all cases.

Table QW-290.4
Welding Variables for Temper Bead Procedure Qualification

Paragraph	Brief of Variables	Essential Variables [Note (1)]			Nonessential Variables
		A	B	C	
<u>QW-402</u>	.23 + Fluid backing	X			
	.24 + Fluid backing		X	X	
<u>QW-403</u>	.25 ϕ P-No. or Gr. No.		X	X	
	.26 > Carbon equivalent	X			
<u>QW-404</u>	.27 > T	X		X	
	.51 Storage				X
<u>QW-406</u>	.52 Diffusible hydrogen	X	X	X	
	.9 < Preheat temperature	X			
<u>QW-408</u>	.10 Preheat soak time				X
	.11 Postweld bakeout				X
<u>QW-409</u>	.24 Gas moisture				X
<u>QW-410</u>	.29 ϕ Heat input ratio	X	X	X	
	.10 ϕ Single to multiple electrode	X	X	X	
	.58 - Surface temper beads	X	X	X	
	.59 ϕ Type of welding	X	X	X	
	.60 + Thermal preparation	X	X	X	
	.61 Surface bead placement	X	X	X	
	.62 Surface bead removal method				X
	.63 Bead overlap	X	X	X	
	.65 \pm Grinding	X	X	X	

Legend:

- + Addition > Increase or greater than ϕ Change
- Deletion < Decrease or less than

NOTE:

(1) Construction code or design specification requirements for Essential Variable columns:

- A = where maximum hardness is specified
- B = where toughness testing is specified
- C = where maximum hardness or toughness testing is not specified

QW-290.5 Test Coupon Preparation and Testing.

(a) The test coupon may be any geometry that is suitable for removal of the required specimens. It shall consist of a groove weld, a cavity in a plate, overlay, or other suitable geometry. The distance from each edge of the weld preparation to the edge of the test coupon shall be at least 3 in. measured transverse to the direction of welding. The depth of preparation shall be such that at least two layers of weld metal are deposited, one of which may be the surface temper bead layer and deep enough to remove the required test specimens.

(b) Only bend tests in accordance with QW-451 are required for the additional temper bead qualification when either hardness or toughness testing is also required. No qualified limitations or process essential or supplementary essential variables, if applicable, per QW-250 may be affected. Where neither maximum hardness nor toughness testing is specified by the referencing code, standard, or specification, all of the test requirements of QW-451 apply.

(c) When hardness testing is specified by a Construction Code or Design Specification, measurements shall be taken across the weld metal, heat-affected zone, and base metal using the Vickers method with a 10-kg load. Increments between measurements shall be as specified in ASTM E384. As an alternative to the Vickers method, Instrumented Indentation Testing in accordance with ASTM E2546 may be used with test forces in the macro range of 2.2 lbf to 265 lbf (1 kgf to 120 kgf) and increments between measurements as determined in accordance with ASTM E2546.

(1) Measurements shall be taken along a line at approximately mid-plane of the thickness of the test coupon weld metal. Along this line, there shall be

(-a) a minimum of two measurements in the weld metal fill layers.

(-b) at least one measurement on each: the weld beads against base metal, first-layer tempering beads, and the second-layer tempering beads.

(-c) a minimum of three measurements in the heat-affected zone. These measurements may be taken in a line approximately parallel to the HAZ when spacing between impressions does not allow for three measurements to be taken in a single line transverse to the HAZ.

(-d) a minimum of two measurements in the unaffected base metal.

(2) Additional measurements shall be taken along a line approximately 0.04 in. (1 mm) below the original base metal surface. Along this line, there shall be

(-a) a minimum of two measurements in the weld metal fill layers

(-b) at least one measurement on each: the weld beads against base metal, first-layer tempering beads, and the second-layer tempering beads

(-c) one measurement located immediately below the toe of the weld bead and at least one measurement on each side of that impression

(3) When the coupon is a full-penetration groove weld made from one side, additional measurements shall be taken along a line approximately 0.04 in. (1 mm) above the root side surface. Along this line, there shall be a minimum of two measurements in the weld metal, two in the heat-affected zone, and two in the unaffected base metal.

Full-penetration groove weld test coupons qualify full and partial penetration groove welds, fillet welds, and weld build-up. Partial penetration groove weld test coupons only qualify partial penetration groove welds, fillet welds, and build-up. Overlay test coupons only qualify overlay welds.

Hardness readings shall not exceed the hardness limits specified by the Construction Code or Design Specification.

(d) When toughness testing is specified by the applicable Construction Code or Design Specification, the test coupon shall be tested for toughness. The extent of testing (i.e., weld metal, HAZ, unaffected base metal), the testing temperature, and the acceptance criteria shall be as provided in the applicable Construction Code or Design Specification.

QW-290.6 In-Process Repair Welding.

(a) In-process repairs to welds made using temper bead welding are permitted. In-process repairs are defined as repairs in which a flaw is mechanically removed and a repair weld is made before welding of a joint is presented for final visual inspection. Examples of such repairs are areas of removal of porosity, incomplete fusion, etc., where sufficient metal has been mechanically removed that localized addition of weld metal is necessary in order to make the surface geometry suitable for continuation of normal welding.

(b) Surfaces to be repaired shall be prepared by mechanical removal of flaws and preparation of the surface to a suitable geometry.

(c) For processes other than manual and semiautomatic GTAW and PAW, repairs shall be made using the parameters given in the WPS for production temper bead welding. The approximate location of beads to be deposited relative to the original base metal surface shall be identified, and the applicable parameters shall be used for the layers to be deposited as specified by the WPS.

(d) When it is necessary to make repairs using manual or semiautomatic GTAW or PAW, a WPS shall be prepared based on PQRs developed for temper bead welding using machine or automatic GTAW or PAW, respectively. This WPS shall describe the size of the beads to be deposited and the volts, amps, and travel speed to be used for the beads against the base metal, for each temper bead layer and for the fill and surface temper bead layers corresponding to the locations where repair welding is to be done. These shall be within the equivalent power ratio for machine or automatic welding for the respective layers given in QW-409.29.

(e) Welders who will use manual and semiautomatic GTAW or PAW shall be qualified to use these welding processes as required by [QW-300](#). In addition, each welder shall complete a proficiency demonstration. For this demonstration, each welder shall deposit two or more weld beads using WPS parameters for each deposit layer. The test coupon size shall be sufficiently large to make the required weld bead passes. The minimum pass length shall be 4 in. (100 mm). The heat input used by the welder shall be measured for each pass, and the size of each weld bead

shall be measured for each pass, and they shall be as required by the WPS. The following essential variables shall apply for this demonstration:

- (1) a change from one welding procedure to another
- (2) a change from manual to semiautomatic welding and vice versa
- (3) a change in position based on a groove weld in either plate or pipe as shown in [Table QW-461.9](#)
- (4) continuity of qualification in accordance with [QW-322](#) shall be based on following the WPS that was demonstrated in addition to using the process as required by [QW-322](#)

ARTICLE III

WELDING PERFORMANCE QUALIFICATIONS

QW-300 GENERAL

QW-300.1 This Article lists the welding processes separately, with the essential variables that apply to welder and welding operator performance qualifications.

The welder qualification is limited by the essential variables given for each welding process. These variables are listed in [QW-350](#), and are defined in [Article IV](#) Welding Data. The welding operator qualification is limited by the essential variables given in [QW-360](#) for each type of weld.

A welder or welding operator may be qualified by volumetric NDE of a test coupon or their initial production welding within the limitations of [QW-304](#) and [QW-305](#) or by bend tests taken from a test coupon.

For the purpose of establishing performance qualification continuity, the welder's or welding operator's qualification continuity begins from the date welding of the test piece(s) was completed, provided the required testing was performed and the test results obtained were acceptable.

QW-301 TESTS

QW-301.1 Intent of Tests. The performance qualification tests are intended to determine the ability of welders and welding operators to make sound welds.

(21) QW-301.2 Qualification Tests. Each organization shall qualify each welder or welding operator for each welding process to be used in production welding. The performance qualification test shall be welded in accordance with qualified Welding Procedure Specifications (WPS), or Standard Welding Procedure Specifications (SWPS) listed in [Mandatory Appendix E](#), except that when performance qualification is done in accordance with a WPS or SWPS that requires a preheat or postweld heat treatment, these may be omitted. Changes beyond which requalification is required are given in [QW-350](#) for welders and in [QW-360](#) for welding operators. Allowable visual, mechanical, and radiographic examination requirements are described in [QW-304](#) and [QW-305](#). Tests and renewal of qualification are given in [QW-320](#).

The welder or welding operator who prepares the groove weld WPS qualification test coupons meeting the requirements of [QW-200](#) is also qualified within the limits of the performance qualifications, listed in [QW-304](#) for

welders and in [QW-305](#) for welding operators. The welder or welding operator is qualified only within the limits for positions specified in [QW-303](#).

The welder or welding operator who prepares the fillet weld WPS qualification test coupons meeting the requirements of [QW-200](#) is qualified to weld non-pressure-retaining fillet welds only within the limits of the performance qualifications listed in [QW-304](#) for welders and in [QW-305](#) for welding operators. The welder or welding operator is qualified only within the limits for positions specified in [QW-303](#).

QW-301.3 Identification of Welders and Welding Operators. Each qualified welder and welding operator shall be assigned an identifying number, letter, or symbol by the organization, which shall be used to identify the work of that welder or welding operator.

QW-301.4 Record of Tests. The record of Welder Performance Qualification (WPQ) tests shall include the essential variables ([QW-350](#)), the type of test and test results, and the ranges qualified in accordance with [QW-452](#) for each welder. The record of Welding Operator Performance Qualification (WOPQ) tests shall include the essential variables ([QW-360](#)) and the type of test and test results for each welding operator. Suggested forms for these records are given in [Forms QW-484A/QW-484B](#) (see [Nonmandatory Appendix B](#)).

QW-302 TYPE OF TEST REQUIRED

QW-302.1 Mechanical Tests. Except as may be specified for special processes ([QW-380](#)), the type and number of test specimens required for mechanical testing shall be in accordance with [QW-452](#). Groove weld test specimens shall be removed in a manner similar to that shown in [Figures QW-463.2\(a\)](#) through [QW-463.2\(g\)](#). Fillet weld test specimens shall be removed in a manner similar to that shown in [Figures QW-462.4\(a\)](#) through [QW-462.4\(d\)](#) and [Figure QW-463.2\(h\)](#).

All mechanical tests shall meet the requirements prescribed in [QW-160](#) or [QW-180](#), as applicable.

QW-302.2 Volumetric NDE. When the welder or welding operator is qualified by volumetric NDE, as permitted in [QW-304](#) for welders and [QW-305](#) for welding operators, the minimum length of coupon(s) to be examined shall be 6 in. (150 mm) and shall include the entire weld circumference for pipe(s), except that for small diameter pipe, multiple coupons of the same diameter pipe may be required, but the number need not exceed four

consecutively made test coupons. The examination technique and acceptance criteria shall be in accordance with [QW-191](#).

QW-302.3 Test Coupons in Pipe. For test coupons made on pipe in position 1G or 2G of [Figure QW-461.4](#), two specimens shall be removed as shown for bend specimens in [Figure QW-463.2\(d\)](#) or [Figure QW-463.2\(e\)](#), omitting the specimens in the upper-right and lower-left quadrants, and replacing the root-bend specimen in the upper-left quadrant of [Figure QW-463.2\(d\)](#) with a face-bend specimen. For test coupons made on pipe in position 5G or 6G of [Figure QW-461.4](#), specimens shall be removed in accordance with [Figure QW-463.2\(d\)](#) or [Figure QW-463.2\(e\)](#) and all four specimens shall pass the test. For test coupons made in both positions 2G and 5G on a single pipe test coupon, specimens shall be removed in accordance with [Figure QW-463.2\(f\)](#) or [Figure QW-463.2\(g\)](#).

QW-302.4 Visual Examination. For plate coupons all surfaces (except areas designated "discard") shall be examined visually per [QW-194](#) before cutting of bend specimens. Pipe coupons shall be visually examined per [QW-194](#) over the entire circumference, inside and outside.

QW-303 LIMITS OF QUALIFIED POSITIONS AND DIAMETERS (SEE [QW-461](#))

QW-303.1 Groove Welds — General. Welders and welding operators who pass the required tests for groove welds in the test positions of [Table QW-461.9](#) shall be qualified for the positions of groove welds, tack welds in joints to be groove or fillet welded, and fillet welds shown in [Table QW-461.9](#). In addition, welders and welding operators who pass the required tests for groove welds shall also be qualified to make fillet welds in all thicknesses and pipe diameters of any size within the limits of the welding variables of [QW-350](#) or [QW-360](#) and tack welds in joints to be groove or fillet welded as limited in [Table QW-461.9](#), as applicable.

QW-303.2 Fillet Welds — General. Welders and welding operators who pass the required tests for fillet welds in the test positions of [Table QW-461.9](#) shall be qualified for the positions of fillet welds, and tack welds in joints to be fillet welded, shown in [Table QW-461.9](#). Welders and welding operators who pass the tests for fillet welds shall be qualified to make tack welds in joints to be fillet welded as limited in [Table QW-461.9](#) and fillet welds only in the thicknesses of material, sizes of fillet welds, and diameters of pipe and tube $2\frac{7}{8}$ in. (73 mm) O.D. and over, as shown in [Table QW-452.5](#), within the applicable essential variables. Welders and welding operators who make fillet welds on pipe or tube less than $2\frac{7}{8}$ in. (73 mm) O.D. must pass the pipe fillet weld test per [Table QW-452.4](#) or the required mechanical tests in [QW-304](#) and [QW-305](#) as applicable.

QW-303.3 Special Positions. An organization who does production welding in a special orientation may make the tests for performance qualification in this specific orientation. Such qualifications are valid only for the flat position and for the special positions actually tested, except that an angular deviation of ± 15 deg is permitted in the inclination of the weld axis and the rotation of the weld face, as defined in [Figures QW-461.1](#) and [QW-461.2](#).

QW-303.4 Stud-Weld Positions. Qualification in the 4S position also qualifies for the 1S position. Qualification in the 4S and 2S positions qualifies for all positions.

QW-304 WELDERS

(21)

Except for the special requirements of [QW-380](#), each welder who welds under the rules of the Code shall have passed the mechanical and visual examinations prescribed in [QW-302.1](#) and [QW-302.4](#) respectively. Alternatively, welders may be qualified by volumetric NDE per [QW-191](#) when making a groove weld using SMAW, SAW, GTAW, PAW, and GMAW (except short-circuiting mode for radiographic examination) or a combination of these processes, except for P-No. 21 through P-No. 26, P-No. 51 through P-No. 53, and P-No. 61 through P-No. 62 metals. Welders making groove welds in P-No. 21 through P-No. 26, P-No. 51 through P-No. 53, P-No. 61, and P-No. 62 metals with the GTAW process may also be qualified by volumetric NDE per [QW-191](#). The Volumetric NDE shall be in accordance with [QW-302.2](#).

A welder qualified to weld in accordance with one qualified WPS is also qualified to weld in accordance with other qualified WPSs, using the same welding process, within the limits of the essential variables of [QW-350](#).

QW-304.1 Examination. Welds made in test coupons for performance qualification may be examined by visual and mechanical examinations ([QW-302.1](#), [QW-302.4](#)) or by volumetric NDE ([QW-302.2](#)) for the process(es) and mode of arc transfer specified in [QW-304](#). Alternatively, a minimum 6 in. (150 mm) length of the first production weld(s) made by a welder using the process(es) and/or mode of arc transfer specified in [QW-304](#) may be examined by volumetric NDE.

(a) For pipe(s) welded in the 5G, 6G, or special positions, the entire production weld circumference made by the welder shall be examined.

(b) For small diameter pipe where the required minimum length of weld cannot be obtained from a single production pipe circumference, additional consecutive circumferences of the same pipe diameter made by the welder shall be examined, except that the total number of circumferences need not exceed four.

(c) The examination technique and acceptance criteria for production welds shall be in accordance with [QW-191](#).

QW-304.2 Failure to Meet Examination Standards.

If a production weld is selected for welder performance qualification and it does not meet the examination standards, the welder has failed the test. In this event, the entire production weld made by this welder shall be examined and repaired by a qualified welder or welding operator. Alternatively, retests may be made as permitted in [QW-320](#).

(21) QW-305 WELDING OPERATORS

Except for the special requirements of [QW-380](#), each welding operator who welds under the rules of this Code shall have passed the mechanical and visual examinations prescribed in [QW-302.1](#) and [QW-302.4](#), respectively. Alternatively, welding operators may be qualified by volumetric NDE per [QW-191](#) when making a groove weld using SMAW, SAW, GTAW, PAW, EGW, LLBW, and GMAW (except short-circuiting mode for radiographic examination) or a combination of these processes, except for P-No. 21 through P-No. 26, P-No. 51 through P-No. 53, P-No. 61, and P-No. 62 metals. Welding operators making groove welds in P-No. 21 through P-No. 26, P-No. 51 through P-No. 53, P-No. 61, and P-No. 62 metals with the GTAW process may also be qualified by volumetric NDE. The volumetric NDE shall be in accordance with [QW-302.2](#).

A welding operator qualified to weld in accordance with one qualified WPS is also qualified to weld in accordance with other qualified WPSs within the limits of the essential variables of [QW-360](#).

QW-305.1 Examination. Welds made in test coupons may be examined by volumetric NDE ([QW-302.2](#)) or by visual and mechanical examinations ([QW-302.1](#), [QW-302.4](#)). Alternatively, a minimum 3 ft (1 m) length of the first production weld(s) made entirely by the welding operator in accordance with a qualified WPS may be examined by volumetric NDE.

(a) For pipe(s) welded in the 5G, 6G, or special positions, the entire production weld circumference made by the welding operator shall be examined.

(b) For small diameter pipe where the required minimum length of weld cannot be obtained from a single production pipe circumference, additional consecutive circumferences of the same pipe diameter made by the welding operator shall be examined except that the total number of circumferences need not exceed four.

(c) The examination technique and acceptance criteria for production welds shall be in accordance with [QW-191](#).

QW-305.2 Failure to Meet Examination Standards.

If a portion of a production weld is selected for welding operator performance qualification, and it does not meet the examination standards, the welding operator has failed the test. In this event, the entire production weld made by this welding operator shall be examined

completely and repaired by a qualified welder or welding operator. Alternatively, retests may be made as permitted in [QW-320](#).

QW-306 COMBINATION OF WELDING PROCESSES

Each welder or welding operator shall be qualified within the limits given in [QW-301](#) for the specific welding process(es) he will be required to use in production welding. A welder or welding operator may be qualified by making tests with each individual welding process in separate test coupons, or with a combination of welding processes in a single test coupon. Two or more welders or welding operators, each using the same or a different welding process, may be qualified in combination in a single test coupon. For combination qualifications in a single test coupon, the limits for thicknesses of deposited weld metal, and bend and fillet testing are given in [QW-452](#) and shall be considered individually for each welder or welding operator for each welding process or whenever there is a change in an essential variable. A welder or welding operator qualified in combination on a single test coupon is qualified to weld in production using any of his processes individually or in different combinations, provided he welds within his limits of qualification with each specific process.

Failure of any portion of a combination test in a single test coupon constitutes failure of the entire combination.

QW-310 QUALIFICATION TEST COUPONS

QW-310.1 Test Coupons. The test coupons may be plate, pipe, or other product forms. When all position qualifications for pipe are accomplished by welding one pipe assembly in both the 2G and 5G positions ([Figure QW-461.4](#)), NPS 6 (DN 150), NPS 8 (DN 200), NPS 10 (DN 250), or larger diameter pipe shall be employed to make up the test coupon as shown in [Figure QW-463.2\(f\)](#) for NPS 10 (DN 250) or larger pipe and in [Figure QW-463.2\(g\)](#) for NPS 6 (DN 150) or NPS 8 (DN 200) diameter pipe.

QW-310.2 Welding Groove With Backing. The dimensions of the welding groove on the test coupon used in making qualification tests for double-welded groove welds or single-welded groove welds with backing shall be the same as those for any Welding Procedure Specification (WPS) qualified by the organization, or shall be as shown in [Figure QW-469.1](#).

A single-welded groove-weld test coupon with backing or a double-welded groove-weld test coupon shall be considered welding with backing. Partial penetration groove welds and fillet welds are considered welding with backing.

QW-310.3 Welding Groove Without Backing. The dimensions of the welding groove of the test coupon used in making qualification tests for single-welded groove welds without backing shall be the same as those for any WPS qualified by the organization, or as shown in [Figure QW-469.2](#).

QW-320 RETESTS AND RENEWAL OF QUALIFICATION

QW-321 RETESTS

A welder or welding operator who fails one or more of the tests prescribed in [QW-304](#) or [QW-305](#), as applicable, may be retested under the following provisions.

QW-321.1 Immediate Retest Using Visual Examination. When the qualification coupon has failed the visual examination of [QW-302.4](#), retesting shall be by visual examination before conducting the mechanical testing.

When an immediate retest is made, the welder or welding operator shall make two consecutive test coupons for each position which he has failed, all of which shall pass the visual examination requirements.

The examiner may select one of the successful test coupons from each set of retest coupons which pass the visual examination for conducting the mechanical testing.

QW-321.2 Immediate Retest Using Mechanical Testing. When the qualification coupon has failed the mechanical testing of [QW-302.1](#), retesting shall be by mechanical testing.

When an immediate retest is made, the welder or welding operator shall make two consecutive test coupons for each position which he has failed, all of which shall pass the test requirements.

QW-321.3 Immediate Retest Using Volumetric NDE. When the qualification coupon has failed the volumetric NDE of [QW-302.2](#), the immediate retest shall be by the same examination method.

(a) For welders and welding operators the retest shall be to examine two 6 in. (150 mm) plate coupons; for pipe, to examine two or more pipe coupons of the same diameter for a total of 12 in. (300 mm) of weld, which shall include the entire weld circumference for pipe or pipes (for small diameter pipe the total number of consecutively made test coupons need not exceed eight).

(b) At the option of the organization, the welder who has failed the production weld alternative test may be retested by examining additional weld areas equal to twice the required length or number of pipe circumferences of the same or consecutively made production weld(s) specified in [QW-304.1](#). If this length of weld passes the test, the welder is qualified and the area of weld on which he had previously failed the test shall be repaired by him or another qualified welder. If this length does not meet the examination standards, the welder has failed

the retest and all of the production welds made by this welder shall be examined completely and repaired by a qualified welder or welding operator.

(c) At the option of the organization, the welding operator who has failed the production weld alternative test may be retested by examining additional weld areas equal to twice the required length or number of pipe circumferences of the same or consecutively made production weld(s) specified in [QW-305.1](#). If this length of weld passes the test, the welding operator is qualified and the area of weld on which he had previously failed the test shall be repaired by him or another qualified welder or welding operator. If this length does not meet the examination standards, the welding operator has failed the retest and all of the production welds made by this welding operator shall be examined completely and repaired by a qualified welder or welding operator.

QW-321.4 Further Training. When the welder or the welding operator has had further training or practice, a new test shall be made for each position on which he failed to meet the requirements.

QW-322 EXPIRATION, REVOCATION, AND RENEWAL OF QUALIFICATION (21)

QW-322.1 Expiration. The qualification of a welder or welding operator for a process remains valid provided no more than 6 months have passed since the welder or welding operator last used that process. Continuity of qualification shall be confirmed by the qualifying or participating organization(s) as identified in [QG-106.2](#) and [QG-106.3](#), respectively.

A welder using manual or semiautomatic welding prolongs qualification for both manual and semiautomatic welding for that process. A welding operator using machine or automatic welding prolongs qualification for machine or automatic welding for that process.

QW-322.2 Revocation. When there is a specific reason to question the welder's or the welding operator's ability to make welds that meet the specification, the qualifications that support the welding being performed shall be revoked. All other qualifications not questioned remain in effect.

QW-322.3 Renewal of Qualification.

(a) Renewal of qualification that has expired under the rules of [QW-322.1](#) may be achieved for any process by welding a single test coupon of either plate or pipe, of any material, thickness or diameter, in any position, as required by [QW-301](#) and successfully completing the testing required by [QW-302](#). This successful test renews the welder or welding operator's previous qualifications for that process for those materials, thicknesses, diameters, positions, and other variables for which he was previously qualified.

Providing the requirements of [QW-304](#) and [QW-305](#) are satisfied, renewal of qualification under [QW-322.1](#) may be done on production work.

(b) Welders and welding operators whose qualification(s) have been revoked under the provisions of QW-322.2 above shall requalify. Qualification shall utilize a test coupon appropriate for the revoked qualification(s). The coupon shall be welded as required by QW-301 and tested as required by QW-302. Successful completion of the qualification test restores the revoked qualification(s).

QW-350 WELDING VARIABLES FOR WELDERS

QW-351 GENERAL

A welder shall be requalified whenever a change is made in one or more of the essential variables listed for each welding process.

Where a combination of welding processes is required to make a weldment, each welder shall be qualified for the particular welding process or processes he will be required to use in production welding. A welder may be qualified by making tests with each individual welding process, or with a combination of welding processes in a single test coupon.

The limits of weld metal thickness for which he will be qualified are dependent upon the approximate thickness of the weld metal he deposits with each welding process, exclusive of any weld reinforcement; this thickness shall be considered the test coupon thickness as given in QW-452.

In any given production weldment, welders may not deposit a thickness greater than that permitted by QW-452 for each welding process in which they are qualified.

**Table QW-352
Oxyfuel Gas Welding (OFW)**

Essential Variables

Paragraph	Brief of Variables
QW-402 Joints	.7 + Backing
QW-403 Base Metals	.2 Maximum qualified
QW-404 Filler Metals	.18 ϕ P-Number
QW-405 Positions	.14 \pm Filler
QW-408 Gas	.15 ϕ F-Number
	.31 ϕ t Weld deposit
	.1 + Position
	.7 ϕ Type fuel gas

**Table QW-353
Shielded Metal-Arc Welding (SMAW)**

Essential Variables

Paragraph	Brief of Variables
QW-402 Joints	.4 - Backing
QW-403 Base Metals	.16 ϕ Pipe diameter
QW-404 Filler Metals	.18 ϕ P-Number
QW-405 Positions	.15 ϕ F-Number
	.30 ϕ t Weld deposit
	.1 + Position
	.3 ϕ $\uparrow\downarrow$ Vertical welding

**Table QW-354
Semiautomatic Submerged-Arc Welding (SAW)**

Essential Variables

Paragraph	Brief of Variables
QW-403 Base Metals	.16 ϕ Pipe diameter
QW-404 Filler Metals	.18 ϕ P-Number
QW-405 Positions	.15 ϕ F-Number
	.30 t Weld deposit
	.1 + Position

**Table QW-355
Semiautomatic Gas Metal-Arc Welding (GMAW)**

[This Includes Flux-Cored Arc Welding (FCAW)] Essential Variables

Paragraph	Brief of Variables
QW-402 Joints	.4 - Backing
QW-403 Base Metals	.16 ϕ Pipe diameter
QW-404 Filler Metals	.18 ϕ P-Number
QW-405 Positions	.15 ϕ F-Number
QW-408 Gas	.30 ϕ t Weld deposit
QW-409 Electrical	.32 t Limit (S. Cir. Arc.)
	.1 + Position
	.3 ϕ $\uparrow\downarrow$ Vertical welding
	.8 - Backing gas
	.2 ϕ Transfer mode

Table QW-356
Manual and Semiautomatic Gas
Tungsten-Arc Welding (GTAW)
Essential Variables

Paragraph	Brief of Variables
QW-402 Joints	.4 - Backing
QW-403 Base Metals	.16 ϕ Pipe diameter
	.18 ϕ P-Number
QW-404 Filler Metals	.14 \pm Filler
	.15 ϕ F-Number
	.22 \pm Inserts
	.23 ϕ Filler metal product form
	.30 ϕ t Weld deposit
QW-405 Positions	.1 + Position
	.3 ϕ $\uparrow\downarrow$ Vertical welding
QW-408 Gas	.8 - Backing gas
QW-409 Electrical	.4 ϕ Current or polarity

Legend:

ϕ Change
+ Addition
- Deletion

\uparrow Uphill
 \downarrow Downhill

Table QW-357
Manual and Semiautomatic Plasma-Arc
Welding (PAW)
Essential Variables

Paragraph	Brief of Variables
QW-402 Joints	.4 - Backing
QW-403 Base Metals	.16 ϕ Pipe diameter
	.18 ϕ P-Number
QW-404 Filler Metals	.14 \pm Filler
	.15 ϕ F-Number
	.22 \pm Inserts
	.23 ϕ Filler metal product form
	.30 ϕ t Weld deposit
QW-405 Positions	.1 + Position
	.3 ϕ $\uparrow\downarrow$ Vertical welding
QW-408 Gas	.8 - Backing gas

Legend:

ϕ Change
+ Addition
- Deletion

\uparrow Uphill
 \downarrow Downhill

QW-360 WELDING VARIABLES FOR WELDING OPERATORS

QW-361 GENERAL

A welding operator shall be requalified whenever a change is made in one of the following essential variables (QW-361.1 and QW-361.2). There may be exceptions or additional requirements for the processes of QW-362, QW-363, and the special processes of QW-380.

QW-361.1 Essential Variables — Automatic Welding.

- (a) A change from automatic to machine welding.
- (b) A change in the welding process.
- (c) For electron beam and laser welding, the addition or deletion of filler metal.
- (d) For laser welding and hybrid welding using lasers, a change in laser type (e.g., a change from CO₂ to YAG).
- (e) For friction welding, a change from continuous drive to inertia welding or vice versa.
- (f) For electron beam welding, a change from vacuum to out-of-vacuum equipment, and vice versa.

QW-361.2 Essential Variables — Machine Welding. (21)

- (a) A change in the welding process.
- (b) A change from direct visual control to remote visual control and vice-versa.
- (c) The deletion of an automatic arc voltage control system for GTAW.
- (d) The deletion of automatic joint tracking.
- (e) The addition of welding positions other than those already qualified (see QW-120, QW-130, and QW-303).
- (f) For GTAW, PAW, and LLBW, the deletion of consumable inserts, except that qualification with consumable inserts shall also qualify for fillet welds and welds with backing.
- (g) The deletion of backing. Double-welded groove welds are considered welding with backing.
- (h) A change from single pass per side to multiple passes per side but not the reverse.
- (i) For hybrid plasma-GMAW welding, the essential variable for welding operator qualification shall be in accordance with Table QW-357.

QW-362 ELECTRON BEAM WELDING (EBW), LASER BEAM WELDING (LBW), HYBRID WELDING, AND FRICTION WELDING (FRW)

The performance qualification test coupon shall be production parts or test coupons that have joint designs permitted by any qualified WPS. The coupon shall be mechanically tested in accordance with QW-452. Alternatively, when the part or coupon does not readily lend itself to the preparation of bend test specimens, the part may be cut so that at least two full-thickness weld cross sections are exposed. Those cross sections shall be smoothed and etched with a suitable etchant (see QW-470) to give a clear definition of the weld metal

and heat-affected zone. The weld metal and heat-affected zone shall exhibit complete fusion and freedom from cracks. The essential variables for welding operator qualification shall be in accordance with [QW-361](#).

QW-363 STUD WELDING

Stud welding operators shall be performance qualified in accordance with the test requirements of [QW-192.2](#) and the position requirements of [QW-303.4](#).

QW-380 SPECIAL PROCESSES

QW-381 CORROSION-RESISTANT WELD METAL OVERLAY

QW-381.1 The size of test coupons, limits of base metal thickness qualification, required examinations and tests, and test specimens shall be as specified in [QW-381.2](#) and [Table QW-453](#).

QW-381.2 The qualification test coupon for performance qualification shall consist of base metal not less than 6 in. (150 mm) × 6 in. (150 mm). The weld overlay cladding shall be a minimum of 1½ in. (38 mm) wide by approximately 6 in. (150 mm) long. For qualification on pipe, the pipe length shall be a minimum of 6 in. (150 mm) and the diameter shall be the minimum needed to allow the required number of test specimens. The weld overlay shall be continuous around the circumference of the test coupon. For processes depositing a weld bead width greater than ½ in. (13 mm) wide, the weld overlay shall consist of a minimum of three weld beads in the first layer.

(a) The test coupon shall be sectioned to make side-bend test specimens perpendicular to the direction of the welding in accordance with [QW-161](#). For coupons that are less than ⅜ in. (10 mm) thick, the width of the side-bend specimens may be reduced to the thickness of the test coupon. Test specimens shall be removed at locations specified in [Figure QW-462.5\(c\)](#) or [Figure QW-462.5\(d\)](#).

(b) Welders or welding operators who pass the tests for corrosion-resistant weld metal overlay cladding shall only be qualified to apply corrosion-resistant weld metal overlay portion of a groove weld joining clad materials or lined materials.

(c) The essential variables of [QW-350](#) and [QW-360](#) shall apply for welders and welding operators, respectively, except there is no limit on the maximum thickness of corrosion-resistant overlay that may be applied in production. When specified as essential variables, the limitations of position and diameter qualified for groove welds shall apply to overlay welds, except the limitations on diameter qualified shall apply only to welds deposited in the circumferential direction.

QW-381.3 Qualification on Clad Materials. A welder or welding operator who has qualified on clad material or lined material as provided in [QW-383.1\(b\)](#) is also qualified to deposit corrosion-resistant weld metal overlay.

QW-381.4 Alternative Qualification With Groove Weld Tests. When a chemical composition is not specified in the WPS, welders or welding operators who successfully complete a groove weld performance qualification test meeting the corrosion-resistant overlay bend test requirements of [QW-163](#) may be considered qualified for corrosion-resistant overlay welding within the ranges defined in [QW-350](#) or [QW-360](#).

QW-382 HARD-FACING WELD METAL OVERLAY (WEAR RESISTANT)

QW-382.1 Qualification Test.

(a) The test base metal coupon for performance qualification shall have minimum dimensions of 6 in. (150 mm) wide × approximately 6 in. (150 mm) long with a hard-faced layer a minimum of 1½ in. (38 mm) wide × 6 in. (150 mm) long. The minimum hard-faced thickness shall be as specified in the WPS. Alternatively, the qualification may be performed on a test base metal coupon that represents the size of the production part. For qualification on pipe, the pipe length shall be 6 in. (150 mm) minimum and the diameter shall be the minimum needed to allow the required number of test specimens. The weld overlay shall be continuous around the circumference of the test coupon.

(b) The base metal shall be sectioned transversely to the direction of the hard-facing overlay. The two faces of the hard facing exposed by sectioning shall be polished and etched with a suitable etchant and shall be visually examined with 5X magnification for cracks in the base metal or the heat-affected zone, lack of fusion, or other linear defects. The overlay and base metal shall meet the requirements specified in the WPS. All exposed faces shall be examined. See [Figure QW-462.5\(b\)](#) for pipe and [Figure QW-462.5\(e\)](#) for plate.

(c) At a thickness greater than or equal to the minimum thickness specified in the WPS, the weld surface shall be examined by the liquid penetrant method and shall meet the acceptance standards in [QW-195.2](#) or as specified in the WPS. Surface conditioning prior to liquid penetrant examination is permitted.

(d) The size of the test coupons, limits of base metal thickness qualification, required examinations and tests, and test specimens shall be as specified in [Table QW-453](#). Base material test coupons may be as permitted in [QW-423](#).

(e) Welders and welding operators who pass the tests for hard-facing weld metal overlay are qualified for hard-facing overlay only.

(f) The essential variable, of [QW-350](#) and [QW-360](#), shall apply for welders and welding operators, respectively, except there is no limit on the maximum thickness

of hard-facing overlay that may be applied in production. When specified as essential variables, the limitations of position and diameter qualified for groove welds shall apply to overlay welds except the limitations on diameter qualified shall apply only to welds deposited in the circumferential direction.

(g) Qualification with one AWS classification within an SFA specification qualifies for all other AWS classifications in that SFA specification.

(h) A change in welding process shall require welder and welding operator requalification.

QW-383 JOINING OF CLAD MATERIALS AND APPLIED LININGS

QW-383.1 Clad Materials.

(a) Welders and welding operators who will join the base material portion of clad materials shall be qualified for groove welding in accordance with [QW-301](#). Welders and welding operators who will apply the cladding portion of a weld between clad materials shall be qualified in accordance with [QW-381](#). Welders and welding operators need only be qualified for the portions of clad material welds that they will make in production.

(b) As an alternative to (a), welders and welding operators may be qualified using clad material test coupons. The test coupon shall be at least $\frac{3}{8}$ in. (10 mm) thick and of dimensions such that a groove weld can be made to join the base materials and the corrosion-resistant weld metal overlay can be applied to the completed groove weld. Four side-bend test specimens shall be removed from the completed test coupon and tested. The groove weld portion and the corrosion-resistant weld metal overlay portion of the test coupon shall be evaluated using the respective criteria in [QW-163](#). Welders and welding operators qualified using clad material test coupons are qualified to join base materials as provided by [QW-301](#), and they are qualified to apply corrosion-resistant weld metal overlay as provided by [QW-381](#).

QW-383.2 Applied Linings.

(a) Welders and welding operators shall be qualified following the rules for making groove or fillet welds in accordance with [QW-301](#). Plug welds for attaching applied linings shall be considered equivalent to fillet welds for the purpose of performance qualification.

(b) An alternate test coupon shall consist of the geometry to be welded, except the base material need not exceed 1 in. (25 mm) in thickness. The welded test coupon shall be sectioned and etched to reveal the weld and heat-affected zone. The weld shall show penetration into the base metal.

QW-384 RESISTANCE WELDING OPERATOR QUALIFICATION

Each welding operator shall be tested on each machine type which he will use. Qualification testing on any P-No. 21 through P-No. 26 metal shall qualify the operator for

all metals. Qualification on any P-No. 1 through P-No. 15F or any P-No. 41 through P-No. 49 metals shall qualify the operator for all P-No. 1 through P-No. 15F and P-No. 41 through P-No. 49 metals. Qualification testing on any P-No. 51 through P-No. 53, P-No. 61, or P-No. 62 metal shall qualify the operator for all P-No. 51 through P-No. 53, P-No. 61, and P-No. 62 metals.

(a) Qualification for spot and projection welding shall consist of making a set of ten consecutive welds, five of which shall be subjected to mechanical shear tests or peel tests, and five to macro-examination. Examination, testing, and acceptance criteria shall be in accordance with [QW-196](#).

(b) Qualification for seam welding shall consist of that testing specified in [QW-286.3](#), except that only one transverse cross section and one longitudinal cross section are required.

QW-385 FLASH WELDING OPERATOR QUALIFICATION

Each welding operator shall be tested by welding a test coupon following any WPS. The test coupon shall be welded and tested in accordance with [QW-199](#). Qualification following any flash welding WPS qualifies the operator to follow all flash welding WPSs.

Production weld sampling tests required by other Sections may be used to qualify welding operators. The test method, extent of tests, and acceptance criteria of the other Sections and [QW-199.2](#) shall be met when this is done.

QW-386 DIFFUSION WELDING OPERATOR QUALIFICATION

Each welding operator shall be tested by welding a procedure qualification test coupon in accordance with [QW-185.1](#). The coupon shall be metallographically examined in accordance with [QW-185.3](#).

QW-387 TUBE-TO-TUBESHEET WELDER AND WELDING OPERATOR QUALIFICATION

(21)

(a) When the applicable Code Section requires the use of [QW-193](#) for tube-to-tubesheet demonstration mockup qualification tests, [QW-193.2](#) shall apply.

(b) Essential performance qualification variables applicable for each welding process listed in [QW-350](#) or [QW-360](#) shall apply, in addition to any applicable variables shown in [Table QW-388](#).

(c) If specific qualification test requirements are not invoked by the applicable Code Section, welders and welding operators shall be qualified with one of the following methods:

(1) a demonstration mockup per the requirements of [QW-193.2](#), except that for welding operators

(-a) the hole pattern does not need to be duplicated

(-b) the type or model of equipment is an essential variable

(2) a groove-weld qualification per the requirements of [QW-303.1](#)

(3) a fillet weld qualification per the requirements of [QW-303.2](#) when a tube-to-tubesheet joint is made with a fillet weld

QW-389 CAPACITOR DISCHARGE WELDING OPERATOR QUALIFICATION

Welding operators using low-energy capacitor discharge welding in accordance with [QW-289](#) are not required to be qualified.

(21)

Table QW-388 Essential Variables for Tube-to-Tubesheet Performance Qualification (All Welding Processes)		
Paragraph	Brief of Variables	
QW-402 Joints	.31	\leq Ligament size
	.32	ϕ Joint configuration
QW-403 Base Metals	.16	ϕ Tube diameter
	.32	ϕ Tube thickness
QW-404 Filler Metals	.58	\pm Preplaced filler metal
QW-409 Electrical	.10	ϕ Amperage

Legend:

ϕ Change	\leq Less than or equal to
\pm Addition or deletion	

ARTICLE IV

WELDING DATA

QW-400 VARIABLES

QW-401 GENERAL

Each welding variable described in this Article is applicable as an essential, supplementary essential, or nonessential variable for procedure qualification when referenced in [QW-250](#) for each specific welding process. Essential variables for performance qualification are referenced in [QW-350](#) for each specific welding process. A change from one welding process to another welding process is an essential variable and requires requalification.

- (21) **QW-401.1 Supplementary Essential Variable (Procedure).** Supplementary essential variables are in addition to the essential variables for each welding process.

When a procedure has been previously qualified to satisfy all requirements other than toughness, it is then necessary only to prepare an additional test coupon using the same procedure with the same essential variables, but additionally with all of the required supplementary essential variables, with the coupon long enough to provide the necessary toughness specimens.

When a procedure has been previously qualified to satisfy all requirements including toughness, but one or more supplementary essential variables are changed, then it is only necessary to prepare an additional test coupon using the same welding procedure and the new supplementary essential variable(s), with the coupon long enough to provide the necessary toughness specimens. If a previously qualified welding procedure has satisfactory toughness values in the weld metal, then it is necessary only to test toughness specimens from the heat-affected zone when such is required.

When essential variables are qualified by one or more PQRs and supplementary essential variables are qualified by other PQRs, the ranges of essential variables established by the former PQRs are only affected by the latter to the extent specified in the applicable supplementary essential variable (e.g., essential variable [QW-403.8](#) governs the minimum and maximum thickness of base metal qualified. When supplementary essential variable [QW-403.6](#) applies, it modifies only the minimum thickness qualified, not the maximum).

- QW-401.2** The welding data includes the welding variables grouped as joints, base metals, filler metals, position, preheat, postweld heat treatment, gas, electrical

characteristics, and technique. For convenience, variables for each welding process are summarized in [Table QW-416](#) for performance qualification.

QW-402 JOINTS

QW-402.1 A change in the type of groove (Vee-groove, U-groove, single-bevel, double-bevel, etc.).

QW-402.2 The addition or deletion of a backing.

QW-402.3 A change in the nominal composition of the backing.

QW-402.4 The deletion of the backing in single-welded groove welds. Double-welded groove welds are considered welding with backing.

QW-402.5 The addition of a backing or a change in its nominal composition.

QW-402.6 An increase in the fit-up gap, beyond that initially qualified.

QW-402.7 The addition of backing.

QW-402.8 A change in nominal size or shape of the stud at the section to be welded.

QW-402.9 In stud welding, a change in shielding as a result of ferrule or flux type.

QW-402.10 A change in the specified root spacing.

QW-402.11 The addition or deletion of nonmetallic retainers or nonfusing metal retainers.

QW-402.12 The welding procedure qualification test shall duplicate the joint configuration to be used in production within the limits listed, except that pipe or tube to pipe or tube may be used for qualification of a pipe or tube to other shapes, and solid round to solid round may be used for qualification of a solid round to other shapes

(a) any change exceeding ± 10 deg in the angle measured for the plane of either face to be joined, to the axis of rotation

(b) a change in cross-sectional area of the weld joint greater than 10%

(c) a change in the outside diameter of the cylindrical weld interface of the assembly greater than $\pm 10\%$

(d) a change from solid to tubular cross section at the joint or vice versa regardless of (b)

QW-402.13 A change in the method of joining from spot to projection to seam or vice versa.

QW-402.14 An increase or decrease of more than 10% in the spacing of the welds when they are within two diameters of each other.

QW-402.15 A change in the size or shape of the projection in projection welding.

QW-402.16 A decrease in the distance between the approximate weld interface and the final surface of the production corrosion-resistant or hard-facing weld metal overlay below the minimum thickness qualified as shown in Figures QW-462.5(a) through QW-462.5(e). There is no limit on the maximum thickness for corrosion-resistant or hard-facing weld metal overlay that may be used in production.

QW-402.17 An increase in the thickness of the production spray fuse hard-facing deposit above the thickness deposited on the procedure qualification test coupon.

QW-402.18 For lap joints,

- (a) a decrease of more than 10% in the distance to the edge of the material
- (b) an increase in the number of layers of material
- (c) a change in surface preparation or finish from that qualified

QW-402.19 A change in the nominal diameter or nominal thickness for tubular cross sections, or an increase in the total cross section area beyond that qualified for all nontubular cross sections.

(21) **QW-402.20** A change in the joint configuration.

QW-402.21 A change in the method or equipment used to minimize internal flash.

QW-402.22 A change in the end preparation method.

QW-402.23 For test coupons less than $1\frac{1}{2}$ in. (38 mm) thick, the addition of a cooling medium (water, flowing gas, etc.) to the back side of the weld. Qualification on test coupons less than $1\frac{1}{2}$ in. (38 mm) thick with a cooling medium on the back side of the weld qualifies base metal thickness equal to or greater than the test coupon thickness with and without coolant.

QW-402.24 Qualification with a cooling medium (water, flowing gas, etc.) on the root side of a test coupon weld that is welded from one side qualifies all thicknesses of base metal with cooling medium down to the thickness of the test coupon at the root or $\frac{1}{2}$ in. (13 mm), whichever is less.

QW-402.25 A change from lap joint to groove welding, and vice versa.

QW-402.26 A reduction of more than 5 deg in the edge preparation bevel angle for groove welds.

QW-402.27 A change in material of fixed backing anvils (when used). A change in backing anvil design that affects the weld cooling rate (e.g., a change from air-cooled to water-cooled, and vice versa). This variable is not

applicable to tube-to-tubesheet or double-sided welds with overlapping fusion zones, or welds completed using self-reacting pins.

QW-402.28 A change in joint design from that qualified, including edge preparation geometry (e.g., a change from square butt edge to beveled edge), reductions in the smallest joint path radius to less than the shoulder radius, or joint paths crossing themselves or another HAZ.

QW-402.29 A change in joint spacing greater than $\pm 10\%$ of the qualification test coupon thickness. For WPSs qualified using intimate edge contact, the maximum allowable joint spacing is $\frac{1}{16}$ in. (1.5 mm).

QW-402.31 A decrease of 10% or more in the specified width of the ligament between tube holes when the specified width of the ligament is less than the greater of $\frac{3}{8}$ in. (10 mm) or three times the specified tube wall thickness. (21)

QW-402.32 For tube-to-tubesheet welding: an increase in the depth by more than 10%, an increase or decrease in the preparation angle of the weld groove by more than 5 deg, or a change in the groove type. (21)

QW-403 BASE METALS

QW-403.1 A change from a base metal listed under one P-Number in Table QW/QB-422 to a metal listed under another P-Number or to any other base metal. When joints are made between two base metals that have different P-Numbers, a procedure qualification shall be made for the applicable combination of P-Numbers, even though qualification tests have been made for each of the two base metals welded to itself.

QW-403.2 The maximum thickness qualified is the thickness of the test coupon.

QW-403.3

(a) For full penetration single-sided welds without backing where the verification of penetration can be made, an increase of more than 20% in base metal thickness when the test coupon thickness is less than or equal to 1 in. (25 mm), and more than 10% in base metal thickness when the test coupon thickness is greater than 1 in. (25 mm).

(b) For all other welds, an increase of more than 10% in base metal thickness when the test coupon thickness is less than or equal to 1 in. (25 mm), and more than 5% in base metal thickness when the test coupon thickness is greater than 1 in. (25 mm).

QW-403.4 Welding procedure qualifications shall be made using a base metal of the same type or grade or another base metal listed in the same group (see Table QW/QB-422) as the base metal to be used in production welding. When joints are to be made between base metals from two different groups, a procedure qualification must

be made for the applicable combination of base metals, even though procedure qualification tests have been made for each of the two base metals welded to itself.

- (21) **QW-403.5** Welding procedure specifications shall be qualified using one of the following:

- (a) the same base metal (including type or grade) to be used in production welding
- (b) for ferrous materials, a base metal listed in the same P-Number Group Number in [Table QW/QB-422](#) as the base metal to be used in production welding
- (c) for nonferrous materials, a base metal listed with the same P-Number UNS Number in [Table QW/QB-422](#) as the base metal to be used in production welding

For ferrous materials in [Table QW/QB-422](#), a procedure qualification shall be made for each P-Number Group Number combination of base metals, even though procedure qualification tests have been made for each of the two base metals welded to itself. If, however, two or more qualification records have the same essential and supplementary essential variables, except that the base metals are assigned to different Group Numbers within the same P-Number, then the combination of base metals is also qualified. In addition, when base metals of two different Group Numbers within the same P-Number are qualified using a single test coupon, that coupon qualifies the welding of those two Group Numbers within the same P-Number to themselves as well as to each other using the variables qualified.

This variable does not apply when toughness testing of the heat-affected zone is not required by the referencing code, standard, or specification.

- (21) **QW-403.6** The minimum base metal thickness qualified is the thickness of the test coupon T or $\frac{5}{8}$ in. (16 mm), whichever is less. However, where T is $\frac{1}{4}$ in. (6 mm) or less, the minimum thickness qualified is $\frac{1}{2}T$. This variable does not apply for any of the following conditions:

- (a) WPS is qualified with a heat treatment above the upper transformation temperature.
- (b) WPS is for welding austenitic or P-10H material and is qualified with a solution heat treatment.
- (c) Base metals are assigned to P-No. 8, P-Nos. 21 through 26, and P-Nos. 41 through 49.

QW-403.8 A change in base metal thickness beyond the range qualified in [QW-451](#), except as otherwise permitted by [QW-202.4\(b\)](#).

QW-403.9 For single-pass or multipass welding in which any pass is greater than $\frac{1}{2}$ in. (13 mm) thick, an increase in base metal thickness beyond 1.1 times that of the qualification test coupon.

QW-403.10 For the short-circuiting transfer mode of the gas metal-arc process, when the qualification test coupon thickness is less than $\frac{1}{2}$ in. (13 mm), an increase in

thickness beyond 1.1 times that of the qualification test coupon. For thicknesses of $\frac{1}{2}$ in. (13 mm) and greater, use [Table QW-451.1](#) or [Table QW-451.2](#), as applicable.

QW-403.11 Base metals specified in the WPS shall be qualified by a procedure qualification test that was made using base metals in accordance with [QW-424](#).

QW-403.12 A change from a base metal listed under one P-Number of [Table QW/QB-422](#) to a base metal listed under another P-Number. When joints are made between two base metals that have different P-Numbers, requalification is required even though the two base metals have been independently qualified using the same procedure. When the melt-in technique is used for joining P-No. 1, P-No. 3, P-No. 4, and P-No. 5A, a procedure qualification test with one P-Number metal shall also qualify for that P-Number metal welded to each of the lower P-Number metals, but not vice versa.

QW-403.15 Welding procedure qualifications for electron beam welding shall be made using a base metal of the same type or grade or another base metal listed in the same P-Number (and the same group where given — see [Table QW/QB-422](#)) as the base metal to be used in production welding. When joints are to be made between base metals from two different P-Numbers (or two different groups), a procedure qualification must be made for the applicable combination of base metals even though procedure qualification tests have been made for each of the two base metals welded to itself.

QW-403.16 A change in the pipe diameter beyond the range qualified in [QW-452](#), except as otherwise permitted in [QW-303.1](#), [QW-303.2](#), [QW-381.2\(c\)](#), or [QW-382.1\(f\)](#). For tube-to-tubesheet welding: an increase or decrease greater than 10% of the specified tube diameter.

(a) For a groove weld attaching a set-on nozzle or branch (with the weld preparation on the nozzle or branch), the range qualified from [Table QW-452.3](#) shall be based on the nozzle or branch pipe O.D.

(b) For a groove weld attaching a set-in nozzle or branch (with the weld preparation on the shell, head, or run pipe), the range qualified from [Table QW-452.3](#) shall be based on the shell, head, or run pipe O.D.

QW-403.17 In stud welding, a change in combination of base metal listed under one P-Number in [Table QW/QB-422](#) and stud metal P-Number (as defined in the following Note), or to any other base metal and stud metal combination.

NOTE: Stud metal shall be classified by nominal chemical composition and can be assigned a P-Number when it meets the nominal composition of any one of the P-Number metals.

QW-403.18 A change from one P-Number to any other P-Number or to a base metal not listed in [Table QW/QB-422](#), except as permitted in [QW-423](#), and in

QW-420. For tube-to-tubesheet welding: a change in the P-Number or A-Number of the tubesheet cladding material (if the cladding material is part of the weld).

QW-403.19 A change to another base material type or grade (type or grade are materials of the same nominal chemical analysis and mechanical property range, even though of different product form), or to any other base material type or grade. When joints are made between two different types or grades of base material, a procedure qualification must be made for the applicable combinations of materials, even though procedure qualification tests have been made for each of the two base materials welded to itself.

QW-403.20 If the chemical composition of the weld metal overlay is specified in the WPS, a change in the P-Number listed in [Table QW/QB-422](#) to another P-Number or unlisted base metal, or a change in Group Number for P-No. 10 or P-No. 11 base metals.

If the chemical composition of the weld metal overlay is not specified in the WPS, qualification on P-No. 5A or any lower P-Number base metal also qualifies for weld metal overlay on all lower P-Number base metals.

QW-403.21 The addition or deletion of a coating, plating or cladding, or a change in the nominal chemical analysis or thickness range of the plating or cladding, or a change in type of coating as specified in the WPS.

QW-403.22 A change in the base metal thickness exceeding 10% of the thickness of the total joint from that qualified.

QW-403.23 A change in base metal thickness beyond the range qualified in [Table QW-453](#).

QW-403.24 A change in the specification, type, or grade of the base metal. When joints are to be made between two different base metals, a procedure qualification must be made for the applicable combination even though procedure qualifications have been made for each of the two base metals welded to themselves.

QW-403.25 Welding procedure qualifications shall be made using a base metal of the same P-Number and Group Number as the base metal to be temper bead welded. When joints are to be made between base metals from two different P-Number and Group Number combinations, a temper bead procedure qualification must be made for each base metal P-Number and Group Number combination to be used in production; this may be done in separate test coupons or in combination on a single test coupon. When base metals of different P-Number and Group Number combinations are tested in the same coupon, the welding variables utilized and test results on each member of the coupon shall be documented independently but may be reported on the same qualification record. Where temper bead welding is to be applied to only one member of a joint (e.g., on the P-No. 1 member of a joint between P-No. 1 and P-No. 8 metals) or where

cladding is being applied or repaired using temper bead techniques, qualification in accordance with [QW-290](#) is required only for the portion of the WPS that applies to welding on the member to be temper bead welded.

QW-403.26 An increase in the base metal carbon equivalent using the following equation:

$$\text{CE} = \text{C} + \frac{\text{Mn}}{6} + \frac{\text{Cr} + \text{Mo} + \text{V}}{5} + \frac{\text{Ni} + \text{Cu}}{15}$$

QW-403.27 The maximum thickness qualified is the thickness of the test coupon, T , or it is unlimited if the test coupon is $1\frac{1}{2}$ in. (38 mm) thick or thicker. However, where T is $\frac{1}{4}$ in. (6 mm) or less, the maximum thickness qualified is $2T$. This limitation applies to fillet welds as well as to groove welds.

QW-403.28 A change to another base metal type, grade, or UNS number.

QW-403.29 A change in the surface finish as defined by the material specification or established surface roughness range as measured in accordance with ASME B46.1-2006.

QW-403.30 A change in base metal thickness greater than 20%

(a) of the test coupon thickness for fixed-pin and retracting-pin rotating tools

(b) beyond the minimum and maximum thickness or thickness transition slopes of the test coupon for self-reacting rotating tools

QW-403.32 For tubes of specified wall thickness of 0.100 in. (2.5 mm) or less, a change in tube wall thickness to increase it to more than $2T$ or to decrease it to less than $\frac{1}{2}T$. For tubes of specified wall thickness greater than 0.100 in. (2.5 mm), only one qualification test is required. (21)

QW-403.33 A change in the P-Number of either the tube or tubesheet material. Where the cladding or overlay material is part of the weld, a change in the P-Number or A-Number or in the nominal composition of the tubesheet cladding or overlay material when a P-Number or A-Number is not assigned. (21)

QW-403.34 A change in the specified tube wall thickness or diameter greater than 10% for all diameters and wall thicknesses. (21)

QW-404 FILLER METALS

QW-404.1 An increase of greater than 10% in the cross-sectional area of the filler metal added (excluding buttering) or in the wire-feed speed beyond that qualified.

QW-404.2 A decrease in the thickness or change in nominal specified chemical analysis of weld metal buttering beyond that qualified. (Buttering or surfacing is the

deposition of weld metal on one or both faces of the joint prior to preparation of the joint for final electron beam welding.)

QW-404.3 A change in the size of the filler metal.

QW-404.4 A change from one F-Number in [Table QW-432](#) to any other F-Number or to any other filler metal not listed in [Table QW-432](#).

- (21) **QW-404.5** (Applicable only to ferrous metals.) A change in the chemical composition of the weld deposit from one A-Number to any other A-Number in [Table QW-442](#). Qualification with A-No. 1 shall qualify for A-No. 2 and vice versa.

The weld metal chemical composition may be determined by any of the following:

(a) For all welding processes — from the chemical analysis of the weld deposit taken from the procedure qualification test coupon.

(b) For SMAW — from the chemical analysis of an undiluted weld deposit such as that prepared according to SFA-5.5 filler metal specification, including the chemical composition as reported either in the filler metal specification or the manufacturer's or supplier's certificate of conformance.

(c) For GTAW, LBW, and PAW — from the chemical analysis of an undiluted weld deposit such as that prepared according to SFA-5.28 GTAW filler metal specification or from the chemical composition of a fully metallic solid welding consumable as reported in either the filler metal specification or the manufacturer's or supplier's certificate of conformance.

(d) For GMAW and EGW — from the chemical analysis of an undiluted weld deposit such as that prepared according to SFA-5.28 filler metal specification, including the manufacturer's or supplier's certificate of conformance when the shielding gas used was the same as that used to weld the procedure qualification test coupon.

(e) For SAW — from the chemical analysis of an undiluted weld deposit such as that prepared according to SFA-5.23 multiple pass filler metal specification, including the manufacturer's or supplier's certificate of conformance when the flux used was the same as that used to weld the procedure qualification test coupon.

In lieu of an A-Number designation, the nominal chemical composition of the weld deposit shall be indicated on the WPS and on the PQR. Designation of nominal chemical composition may also be by reference to the AWS classification except for the "G" suffix classification, by the manufacturer's trade name, or by other established procurement documents.

QW-404.6 A change in the nominal size of the electrode or electrodes specified in the WPS.

- (21) **QW-404.7**

DELETED

QW-404.8 Addition or deletion, or a change of more than 10% in the nominal amount or composition of supplementary deoxidation material (in addition to filler metal) beyond that qualified.

QW-404.9

(a) A change in the indicator for minimum tensile strength (e.g., the 7 in F7A2-EM12K) when the flux wire combination is classified in Section II, Part C.

(b) A change in either the flux trade name or wire trade name when neither the flux nor the wire is classified in Section II, Part C.

(c) A change in the flux trade name when the wire is classified in Section II, Part C but the flux is not classified. A change in the wire classification within the requirements of [QW-404.5](#) does not require requalification.

(d) A change in the flux trade name for A-No. 8 deposits.

QW-404.10 Where the alloy content of the weld metal is largely dependent upon the composition of the flux used, any change in any part of the welding procedure which would result in the important alloying elements in the weld metal being outside of the specification range of chemistry given in the Welding Procedure Specification.

QW-404.12 A change in the filler metal classification within an SFA specification, or for a filler metal not covered by an SFA specification or a filler metal with a "G" suffix within an SFA specification, a change in the trade name of the filler metal.

When a filler metal conforms to a filler metal classification, within an SFA specification, except for the "G" suffix classification, requalification is not required if a change is made in any of the following:

(a) from a filler metal that is designated as moisture-resistant to one that is not designated as moisture-resistant and vice versa (i.e., from E7018R to E7018)

(b) from one diffusible hydrogen level to another (i.e., from E7018-H8 to E7018-H16)

(c) for carbon, low alloy, and stainless steel filler metals having the same minimum tensile strength and the same nominal chemical composition, a change from one low hydrogen coating type to another low hydrogen coating type (i.e., a change among EXX15, 16, or 18 or EXXX15, 16, or 17 classifications)

(d) from one position-usability designation to another for flux-cored electrodes (i.e., a change from E70T-1 to E71T-1 or vice versa)

(e) from a classification that requires toughness testing to the same classification which has a suffix which indicates that toughness testing was performed at a lower temperature or exhibited greater toughness at the required temperature or both, as compared to the classification which was used during procedure qualification (i.e., a change from E7018 to E7018-1)

(f) from the classification qualified to another filler metal within the same SFA specification when the weld metal is exempt from toughness testing by other Sections

This exemption does not apply to hard-facing and corrosion-resistant overlays

QW-404.14 The deletion or addition of filler metal.

QW-404.15 A change from one F-Number in [Table QW-432](#) to any other F-Number or to any other filler metal, except as permitted in [QW-433](#).

QW-404.17 A change in the type of flux or composition of the flux.

QW-404.18 A change from wire to plate electrodes, and vice versa.

QW-404.19 A change from consumable guide to non-consumable guide, and vice versa.

QW-404.20 Any change in the method by which filler metal is added, such as preplaced shim, top strip, wire, wire feed, or prior weld metal buttering of one or both joint faces.

QW-404.21 For filler metal additions, any change from the nominal specified analysis of the filler metal qualified.

QW-404.22 The omission or addition of consumable inserts. Qualification in a single-welded butt joint, with or without consumable inserts, qualifies for fillet welds and single-welded butt joints with backing or double-welded butt joints. Consumable inserts that conform to SFA-5.30 , except that the chemical analysis of the insert conforms to an analysis for any bare wire given in any SFA specification or AWS Classification, shall be considered as having the same F-Number as that bare wire as given in [Table QW-432](#).

QW-404.23 A change from one of the following filler metal product forms to another:

- (a) bare (solid or metal cored)
- (b) flux cored
- (c) flux coated (solid or metal cored)
- (d) powder

QW-404.24 The addition, deletion, or change of more than 10% in the volume of supplemental filler metal.

QW-404.27 Where the alloy content of the weld metal is largely dependent upon the composition of the supplemental filler metal (including powder filler metal for PAW), any change in any part of the welding procedure that would result in the important alloying elements in the weld metal being outside of the specification range of chemistry given in the Welding Procedure Specification.

QW-404.29 A change in the flux trade name and designation.

QW-404.30 A change in deposited weld metal thickness beyond that qualified in accordance with [QW-451](#) for procedure qualification or [QW-452](#) for performance qualification, except as otherwise permitted in [QW-303.1](#) and [QW-303.2](#). When a welder is qualified using volumetric examination, the maximum thickness stated in [Table QW-452.1\(b\)](#) applies.

QW-404.31 The maximum thickness qualified is the thickness of the test coupon.

QW-404.32 For the low voltage short-circuiting type of gas metal-arc process when the deposited weld metal thickness is less than $\frac{1}{2}$ in. (13 mm), an increase in deposited weld metal thickness beyond 1.1 times that of the qualification test deposited weld metal thickness. For weld metal thicknesses of $\frac{1}{2}$ in. (13 mm) and greater, use [Table QW-451.1](#), [Table QW-451.2](#), or [Tables QW-452.1\(a\)](#) and [QW-452.1\(b\)](#), as applicable.

QW-404.33 A change in the filler metal classification within an SFA specification, or, if not conforming to a filler metal classification within an SFA specification, a change in the manufacturer's trade name for the filler metal. When optional supplemental designators, such as those which indicate moisture resistance (i.e., XXXXR), diffusible hydrogen (i.e., XXXX H16, H8, etc.), and supplemental toughness testing (i.e., XXXX-1 or EXXXXM), are specified on the WPS, only filler metals which conform to the classification with the optional supplemental designator(s) specified on the WPS shall be used.

QW-404.34 A change in flux type (i.e., neutral to active or vice versa) for multilayer deposits in P-No. 1 materials.

QW-404.35 A change in the flux-wire classification or a change in either the electrode or flux trade name when the flux-wire combination is not classified to an SFA specification. Requalification is not required when a flux-wire combination conforms to an SFA specification and the change in classification is

(a) from one diffusible hydrogen level to another (e.g., a change from F7A2-EA1-A1-H4 to F7A2-EA1-A1-H16), or

(b) to a larger number in the indicator for toughness, indicating classification at a lower toughness testing temperature (e.g., a change from F7A2-EM12K to F7A4-EM12K)

This variable does not apply when the weld metal is exempt from toughness testing by other Sections. This exemption does not apply to hard-facing and corrosion-resistant overlays.

QW-404.36 When flux from recrushed slag is used, (21) each batch or blend, as defined in SFA-5.01, shall be tested in accordance with Section II, Part C by either the manufacturer or the user.

QW-404.37 A change in the composition of the deposited weld metal from one A-Number in [Table QW-442](#) to any other A-Number, or to an analysis not

listed in the table. A change in the UNS number for each AWS classification of A-No. 8 or A-No. 9 analysis of [Table QW-442](#), or each nonferrous alloy in [Table QW-432](#), shall require separate WPS qualification. **A-Numbers may be determined in accordance with QW-404.5.**

QW-404.38 A change in the nominal electrode diameter used for the first layer of deposit.

QW-404.39 For submerged-arc welding and electro-slag welding, a change in the nominal composition or type of flux used. Requalification is not required for a change in flux particle size.

QW-404.41 A change of more than 10% in the powdered metal feed rate recorded on the PQR.

QW-404.42 A change of more than 5% in the particle size range of the powder.

QW-404.43 A change in the powdered metal particle size range recorded on the PQR.

QW-404.44 A change from a homogeneous powdered metal to a mechanical mixed powdered metal or vice versa.

QW-404.46 A change in the powder feed rate range qualified.

QW-404.47 A change of more than 10% in the filler metal size and/or powder metal particle size.

QW-404.48 A change of more than 10% in the powder metal density.

QW-404.49 A change of more than 10% in the filler metal or powder metal feed rate.

QW-404.50 The addition or deletion of flux to the face of a weld joint for the purpose of affecting weld penetration.

QW-404.51 The method of control of moisture pick-up during storage and distribution for SMAW and GMAW-FC electrodes and flux for SAW (e.g., purchasing in hermetically sealed containers and storage in heated ovens, controlled distribution time, high-temperature baking prior to use).

QW-404.52 An increase in the diffusible hydrogen designator (e.g., from E7018-H8 to E7018-H16) or to no diffusible hydrogen designator.

QW-404.53 The addition or deletion of filler metal and, when used, a change in the filler metal nominal composition.

QW-404.55 An increase in the thickness or width of preplaced filler metal.

QW-404.56 A change to another type or grade of preplaced filler metal (type or grade are materials of the same nominal chemical analysis and mechanical property range, even though of different product form).

QW-404.57 An increase in the nominal thickness or width of the electrode for strip filler metals used with the SAW and ESW processes for corrosion-resistant and hard-facing weld metal overlay.

QW-404.58 The addition or deletion of preplaced filler metal.

QW-404.59 If filler metal is added, a change in the A-Number of the weld deposit or a change in the nominal composition of the deposited weld metal when an A-Number is not assigned.

QW-405 POSITIONS

QW-405.1 The addition of other welding positions than those already qualified. see [QW-120](#), [QW-130](#), [QW-203](#), and [QW-303](#).

QW-405.3 A change from upward to downward, or from downward to upward, in the progression specified for any pass of a vertical weld, except that the cover or wash pass may be up or down. The root pass may also be run either up or down when the root pass is removed to sound weld metal in the preparation for welding the second side.

QW-405.4 Except as specified below, the addition of other welding positions than already qualified.

(a) Qualification in the horizontal, vertical, or overhead position shall also qualify for the flat position. Qualification in the horizontal fixed position, 5G, shall qualify for the flat, vertical, and overhead positions. Qualification in the horizontal, vertical, and overhead positions shall qualify for all positions. Qualification in the inclined fixed position, 6G, shall qualify for all positions.

(b) An organization who does production welding in a particular orientation may make the tests for procedure qualification in this particular orientation. Such qualifications are valid only for the positions actually tested, except that an angular deviation of ± 15 deg is permitted in the inclination of the weld axis and the rotation of the weld face as defined in [Figure QW-461.1](#). A test specimen shall be taken from the test coupon in each special orientation.

(c) For hard-facing and corrosion-resistant weld metal overlay, qualification in the 3G, 5G, or 6G positions, where 5G or 6G pipe coupons include at least one vertical segment completed utilizing the up-hill progression or a 3G plate coupon is completed utilizing the up-hill progression, shall qualify for all positions. Chemical analysis, hardness, macro-etch, and at least two of the bend tests, as required in [Table QW-453](#), shall be removed from the vertical uphill overlaid segment as shown in [Figure QW-462.5\(b\)](#).

(d) A change from the vertical down to vertical up-hill progression shall require requalification.

QW-406 PREHEAT

QW-406.1 A decrease of more than 100°F (55°C) in the preheat temperature qualified. The minimum temperature for welding shall be specified in the WPS.

QW-406.2 A change in the maintenance or reduction of preheat upon completion of welding prior to any required postweld heat treatment.

(21) **QW-406.3** An increase of more than 100°F (55°C) in the maximum interpass temperature recorded on the PQR. This variable does not apply for any of the following conditions:

(a) WPS is qualified with a heat treatment above the upper transformation temperature.

(b) WPS is for welding austenitic or P-10H material and is qualified with a solution heat treatment.

(c) Base metals are assigned to P-No. 8, P-Nos. 21 through 26, and P-Nos. 41 through 49.

QW-406.4 A decrease of more than 100°F (55°C) in the preheat temperature qualified or an increase in the maximum interpass temperature recorded on the PQR. The minimum temperature for welding shall be specified in the WPS.

QW-406.5 A change in the maintenance or reduction of preheat upon completion of spraying and prior to fusing.

QW-406.7 A change of more than 10% in the amplitude or number of preheating cycles from that qualified, or if other preheating methods are employed, a change in the preheating temperature of more than 25°F (15°C).

QW-406.9 A decrease in the preheat temperature from that achieved on the test coupon and recorded on the PQR.

QW-406.10 The minimum preheating soaking time prior to the start of welding.

QW-406.11 The addition or deletion of a postweld hydrogen bakeout. When specified, the minimum soaking temperature and time shall be specified.

QW-407 POSTWELD HEAT TREATMENT

QW-407.1 A separate procedure qualification is required for each of the following:

(a) For P-Numbers 1 through 6 and 9 through 15F materials, the following postweld heat treatment conditions apply:

(1) no PWHT

(2) PWHT below the lower transformation temperature

(3) PWHT above the upper transformation temperature (e.g., normalizing)

(4) PWHT above the upper transformation temperature followed by heat treatment below the lower transformation temperature (e.g., normalizing or quenching followed by tempering)

(5) PWHT between the upper and lower transformation temperatures

(b) For all other materials, the following postweld heat treatment conditions apply:

(1) no PWHT

(2) PWHT within a specified temperature range

QW-407.2 A change in the postweld heat treatment (21) (see **QW-407.1**) temperature and time range

The procedure qualification test shall be subjected to PWHT essentially equivalent to that encountered in the fabrication of production welds, including at least 80% of the aggregate times at temperature(s). The PWHT total time(s) at temperature(s) may be applied in one heating cycle. This variable does not apply to a WPS qualified for welding base metals that are assigned to P-No. 8, P-Nos. 21 through 26, and P-Nos. 41 through 49.

QW-407.6 A change in postweld heat treatment condition in **QW-407.1** or an increase of 25% or more in total time at postweld heat treating temperature.

QW-407.7 A change in the heat treatment temperature range qualified if heat treatment is applied after fusing.

QW-407.8 A separate PQR is required for each of the following:

(a) no PWHT

(b) a change of more than 10% in the number of PWHT heating current cycles following the welding cycle

(c) PWHT within a specified temperature and time range if heat treatment is performed separately from the welding operation

QW-407.9 A separate procedure qualification is required for each of the following:

(a) For weld corrosion-resistant overlay of A-No. 8 on all base materials, a change in postweld heat treatment condition in **QW-407.1**, or when the total time at postweld heat treatment encountered in fabrication exceeds 20 hr, an increase of 25% or more in total time at postweld heat treating temperature.

(b) For weld corrosion-resistant overlay of A-No. 9 on all base materials, a change in postweld heat treatment condition in **QW-407.1**, or an increase of 25% or more in total time at postweld heat treating temperature.

(c) For all other weld corrosion-resistant overlays on all base materials, a change in postweld heat treatment condition in **QW-407.1**.

QW-407.10 The addition or deletion of PWHT, or a change of $\pm 45^{\circ}\text{F}$ ($\pm 25^{\circ}\text{C}$) in PWHT temperature or an increase in the holding time by more than 25% or change in the method of cooling (e.g., furnace, air, quench).

QW-408 GAS

QW-408.1 The addition or deletion of trailing gas and/or a change in its composition.

QW-408.2 A separate procedure qualification is required for each of the following:

- (a) a change from a single shielding gas to any other single shielding gas
- (b) a change from a single shielding gas to a mixture of shielding gasses, and vice versa
- (c) a change in the specified percentage composition of a shielding gas mixture
- (d) the addition or omission of shielding gas

The AWS classification of SFA-5.32 may be used to specify the shielding gas composition.

QW-408.3 A change in the specified flow rate range of the shielding gas or mixture of gases.

QW-408.4 A change in the composition of the orifice or shielding gas.

QW-408.5 The addition or deletion of backing gas, a change in backing gas composition, or a change in the specified flow rate range of the backing gas.

QW-408.6 A change of environment shielding such as from vacuum to an inert gas, or vice versa.

QW-408.7 A change in the type of fuel gas.

QW-408.8 The omission of backing gas except that requalification is not required when welding a single-welded butt joint with a backing strip or a double-welded butt joint or a fillet weld. This exception does not apply to P-No. 51 through P-No. 53, P-No. 61 through P-No. 62, and P-No. 10I metals.

QW-408.9 For groove welds in P-No. 41 through P-No. 49 and all welds of P-No. 10I, P-No. 10J, P-No. 10K, P-No. 51 through P-No. 53, and P-No. 61 through P-No. 62 metals, the deletion of backing gas or a change in the nominal composition of the backing gas from an inert gas to a mixture including non-inert gas(es).

QW-408.10 For P-No. 10I, P-No. 10J, P-No. 10K, P-No. 51 through P-No. 53, and P-No. 61 through P-No. 62 metals, the deletion of trailing gas, or a change in the nominal composition of the trailing gas from an inert gas to a mixture including non-inert gas(es), or a decrease of 10% or more in the trailing gas flow rate.

QW-408.11 The addition or deletion of one or more of the following:

- (a) shielding gas
- (b) trailing gas
- (c) backing gas
- (d) plasma-removing gas

QW-408.12 A decrease of more than 10% in the flow rate of one or more of the following: shielding gas, trailing gas, backing gas, and plasma-removing gas.

QW-408.14 A change in the oxygen or fuel gas pressure beyond the range qualified.

QW-408.16 A change of more than 5% in the flow rate of the plasma-arc gas or powdered metal feed gas recorded on the PQR.

QW-408.17 A change in the plasma-arc gas, shielding gas, or powdered metal feed gas from a single gas to any other single gas, or to a mixture of gases, or vice versa.

QW-408.18 A change of more than 10% in the gas mixture composition of the plasma-arc gas, shielding gas, or powdered metal feed gas recorded on the PQR.

QW-408.19 A change in the nominal composition of the powder feed gas or (plasma-arc spray) plasma gas qualified.

QW-408.20 A change of more than 5% in the plasma gas flow rate range qualified.

QW-408.21 A change in the flow rate of the orifice or shielding gas.

QW-408.22 A change in the shielding gas type, gas pressure, or purging time.

QW-408.23 For titanium, zirconium, and their alloys, the deletion of one or more of the following:

- (a) shielding gas
- (b) trailing gas
- (c) backing gas

QW-408.24 For gas-shielded processes, the maximum moisture content (dew point) of the shielding gas. Moisture control may be by specification of shielding gas classifications in SFA-5.32.

QW-408.25 A change in the furnace atmosphere from that qualified.

QW-408.26 For friction stir welding of P-No. 6, P-No. 7, P-No. 8, P-No. 10H, P-No. 10I, P-No. 41 through P-No. 47, P-No. 51 through P-No. 53, and P-No. 61 through P-No. 62, the addition or deletion of trailing or tool shielding gas, or a change in gas composition or flow rate.

QW-409 ELECTRICAL CHARACTERISTICS

QW-409.1 An increase in heat input, or an increase in volume of weld metal deposited per unit length of weld, for each process recorded on the PQR. For arc welding, the increase shall be determined by (a), (b), or (c) for non-waveform controlled welding, or by (b) or (c) for waveform controlled welding. See [Nonmandatory Appendix H](#). For low-power density laser beam welding (LLBW), the increase shall be determined by (d). (21)

(a) Heat input [J/in. (J/mm)]

$$= \frac{\text{Voltage} \times \text{Amperage} \times 60}{\text{Travel Speed} [\text{in/min (mm/min)}]}$$

(b) Volume of weld metal measured by

(1) an increase in bead size (width \times thickness), or

(2) a decrease in length of weld bead per unit length of electrode

(c) Heat input determined using instantaneous energy or power by

(1) for instantaneous energy measurements in joules (J) *Heat input [J/in. (J/mm)]*

$$= \frac{\text{Energy (J)}}{\text{Weld Bead Length [in. (mm)]}}$$

(2) for instantaneous power measurements in joules per second (J/s) or Watts (W) *Heat input [J/in. (J/mm)]*

$$= \frac{\text{Power (J/s or W)} \times \text{arc time (s)}}{\text{Weld Bead Length [in. (mm)]}}$$

(d) LLBW Heat input [J/in. (J/mm)]

$$= \frac{\text{Power (W)} \times 60}{\text{Travel Speed [in./min (mm/min)]}}$$

where Power is the power delivered to the work surface as measured by calorimeter or other suitable methods.

This variable does not apply for any of the following conditions:

- WPS is qualified with a heat treatment above the upper transformation temperature.
- WPS is for welding austenitic or P-10H material and is qualified with a solution heat treatment.
- Base metals are assigned to P-No. 8, P-Nos. 21 through 26, and P-Nos. 41 through 49.

QW-409.2 A change from globular, spray or pulsed spray transfer welding to short-circuiting transfer welding or vice versa.

QW-409.3 The addition or deletion of pulsing current to dc power source.

(21) **QW-409.4** A change from AC to DC, or vice versa; and in DC welding, a change from electrode negative (straight polarity) to electrode positive (reverse polarity), or vice versa. This variable does not apply to a WPS qualified for welding base metals that are assigned to P-No. 8, P-Nos. 21 through 26, and P-Nos. 41 through 49.

QW-409.5 A change of $\pm 15\%$ in the amperage or voltage range.

QW-409.6 A change in the beam current of more than $\pm 5\%$, voltage of more than $\pm 2\%$, welding speed of more than $\pm 2\%$, beam focus current of more than $\pm 5\%$, gun-to-work distance of more than $\pm 5\%$, or a change in oscillation length or width of more than $\pm 20\%$.

QW-409.7 Any change in the beam pulsing frequency duration.

QW-409.8 A change in the range of amperage, or except for SMAW, GTAW, or waveform controlled welding, a change in the range of voltage. A change in the range of electrode wire feed speed may be used as an alternative to amperage. See Nonmandatory Appendix H.

QW-409.9 A change in the arc timing of more than $\pm 1/10$ sec.

QW-409.10 A change in amperage of more than $\pm 10\%$.

QW-409.11 A change in the power source from one model to another.

QW-409.12 A change in type or size of tungsten electrode.

QW-409.13 A change from one Resistance Welding Manufacturer's Association (RWMA) electrode class to another. In addition, a change in the following:

(a) for spot and projection welding, a change in the nominal shape or more than 10% of the contact area of the welding electrode

(b) for seam welding, a change of thickness, profile, orientation, or diameter of electrodes exceeding 10%

QW-409.14 Addition or deletion of upslope or down-slope current control, or a change of more than 10% in the slope current time or amplitude.

QW-409.15

(a) A change of more than 5% in any of the following:

- (1) preheating current
- (2) preheating current amplitude
- (3) preheating current time duration
- (4) electrode pressure
- (5) welding current
- (6) welding current time duration

(b) A change from AC to DC or vice versa.

(c) The addition or deletion of pulsing current to a DC power source.

(d) When using pulsing DC current, a change of more than 5% in the pulse amplitude, frequency, or number of pulses per cycle.

(e) A change of more than 5% in the post-heating current time duration.

QW-409.17 A change in the power supply primary voltage or frequency, or in the transformer turns ratio, tap setting, choke position, secondary open circuit voltage or phase control setting.

QW-409.18 A change in the procedure or frequency of tip cleaning.

QW-409.19 Any change of more than $\pm 10\%$ in the beam pulsing frequency and pulse duration.

QW-409.20 For LBW and LLBW, a change in the following variables: mode of operation (from pulsed to continuous and vice versa), energy distribution across the beam (i.e., multimode or Gaussian). For LBW, a change of more than $\pm 10\%$ in the spatial profile [e.g., M^2 (beam quality factor) or uniformity] of the focused or unfocused beam.

QW-409.21 For LBW, a decrease of more than 5% in the power delivered to the work surface as measured by calorimeter or other suitable methods. For LLBW and

special process LBW, a decrease of more than 10% in the power delivered to the work surface as measured by calorimeter or other suitable methods.

QW-409.22 An increase of more than 10% in the amperage used in application for the first layer.

QW-409.23 A change of more than 10% in the ranges of amperage or voltage.

QW-409.24 A change of more than 10% in the filler wire wattage recorded on the PQR. Wattage is a function of current voltage, and stickout dimension.

QW-409.25 A change of more than 10% in the plasma-arc current or voltage recorded on the PQR.

QW-409.26 For the first layer only, an increase in heat input of more than 10% or an increase in volume of weld metal deposited per unit length of weld of more than 10%. The increase shall be determined by the methods of [QW-409.1](#).

When using strip filler metal, the heat input shall be calculated as follows:

$$\text{Heat Input } [\text{J/in.}^2 (\text{J/mm}^2)] = \frac{\text{Voltage} \times \text{Amperage} \times 60}{\text{Travel Speed } [\text{in./min (mm/min)}] \times \text{Strip Width } [\text{in. (mm)}]}$$

QW-409.27 A change in the flashing time of more than 10%.

QW-409.28 A change in the upset current time by more than 10%.

QW-409.29

(a) A change in heat input beyond the following (see [Figure QW-462.12](#)):

(1) An increase or decrease in the ratio of heat input between the first tempering bead layer and the weld beads deposited against the base metal of more than 20% for P-No. 1 and P-No. 3 metals and 10% for all other P-Number metals.

(2) An increase or decrease in the ratio of heat input between the second tempering bead layer and the first tempering bead layer of more than 20% for P-No. 1 and P-No. 3 metals and 10% for all other P-Number metals.

(3) The ratio of heat input between subsequent layers shall be maintained until a minimum of $\frac{3}{16}$ in. (5 mm) of weld metal has been deposited over the base metal.

(4) Where the basis for acceptance is toughness testing and the filler metal is exempt from temper bead qualification, the heat input may not exceed 50% above the heat input qualified for the remaining fill passes.

(5) Where the basis for acceptance is hardness testing, a decrease of more than 20% in heat input for the remainder of the fill passes.

(b) Heat input shall be determined using the following methods:

(1) For machine or automatic GTAW or PAW, an increase or decrease of 10% in the power ratio measured as:

$$\text{Power Ratio} = \frac{\text{Amperage} \times \text{Voltage}}{[(\text{WFS} / \text{TS}) \times A_f]}$$

where

A_f = cross-section area of the filler metal wire

TS = welding travel speed

WFS = filler metal wire feed speed

(2) For processes other than machine or automatic GTAW or PAW, heat input shall be determined by the method of [QW-409.1](#).

(3) If manual GTAW or PAW is used for making in-process repairs in accordance with [QW-290.5](#), a record of bead size shall be made.

QW-410 TECHNIQUE

QW-410.1 For manual or semiautomatic welding, a change from the stringer bead technique to the weave bead technique, or vice versa.

QW-410.2 A change in the nature of the flame, oxidizing to reducing, or vice versa.

QW-410.3 A change in the orifice, cup, or nozzle size.

QW-410.4 A change in the welding technique, forehand to backhand, or vice versa.

QW-410.5 A change in the method of initial and interpass cleaning (brushing, grinding, etc.).

QW-410.6 A change in the method of back gouging.

QW-410.7 For the machine or automatic welding process, a change in width, frequency, or dwell time of oscillation technique. (21)

QW-410.8 A change in the contact tube to work distance.

QW-410.9 A change from multipass per side to single pass per side. This variable does not apply for any of the following conditions: (21)

(a) WPS is qualified with a heat treatment above the upper transformation temperature.

(b) WPS is for welding austenitic or P-10H material and is qualified with a solution heat treatment.

(c) Base metals are assigned to P-No. 8, P-Nos. 21 through 26, and P-Nos. 41 through 49.

QW-410.10 A change from single electrode to multiple electrode, or vice versa, for machine or automatic welding only. This variable does not apply when a WPS

is qualified with a PWHT above the upper transformation temperature or when an austenitic or P-No. 10H material is solution annealed after welding.

QW-410.11 A change from closed chamber to out-of-chamber conventional torch welding in P-No. 51 through P-No. 53 metals, but not vice versa.

(21) **QW-410.12**

DELETED

(21) **QW-410.14** For LBW, a change of more than ± 5 deg in the relative angle between the axis of the beam and the workpiece. For EBW, a change of more than ± 10 deg in the relative angle between the axis of the beam and the workpiece.

QW-410.15 A change in the spacing of multiple electrodes for machine or automatic welding.

QW-410.17 A change in the type or model of the welding equipment.

QW-410.18 An increase in the absolute pressure of the vacuum welding environment beyond that qualified.

QW-410.19 Any change in filament type, size, or shape.

QW-410.20 The addition of a wash pass.

QW-410.21 For full penetration groove welds, a change of welding from both sides to welding from one side only, but not vice versa.

QW-410.22 A change in either of the following stud welding parameters: a change of stud gun model; a change in the lift more than $\pm \frac{1}{32}$ in. (0.8 mm).

QW-410.25 A change from manual or semiautomatic to machine or automatic welding and vice versa.

QW-410.26 The addition or deletion of peening.

QW-410.27 A change in the rotational speed producing a change in the outside surface velocity [ft/min (m/min)] greater than $\pm 10\%$ of the outside surface velocity qualified.

QW-410.28 A change in the thrust load greater than $\pm 10\%$ of the thrust load qualified.

QW-410.29 A change in the rotational energy greater than $\pm 10\%$ of the rotational energy qualified.

QW-410.30 Any change in upset dimension (overall loss in length of parts being joined) greater than $\pm 10\%$ of the upset qualified.

QW-410.31 A change in the method of preparing the base metal prior to welding (e.g., changing from mechanical cleaning to chemical cleaning or to abrasive cleaning, or vice versa).

QW-410.32 A change of more than 10% in the holding (forging) pressure prior to or after welding. A change of more than 10% in the electrode holding time (electrode duration sequence).

QW-410.33 A change from one welding type to another, or modification of equipment, including Manufacturer, control panel, model number, electrical rating or capacity, type of electrical energy source, or method of applying pressure.

QW-410.34 Addition or deletion of an electrode cooling medium and where it is used.

QW-410.35 A change in the distance between arms or a change in the throat depth.

QW-410.37 A change from single to multiple pass or vice versa.

QW-410.38 A change from multiple-layer to single layer cladding/hardsurfacing, or vice versa.

QW-410.39 A change in the torch type or tip size.

QW-410.40 For submerged-arc welding and electro-slag welding, the deletion of a supplementary device for controlling the magnetic field acting on the weld puddle.

QW-410.41 A change of more than 15% in the travel speed range recorded on the PQR.

QW-410.43 For the torch or workpiece, a change of more than 10% in the travel speed range qualified.

QW-410.44 A change of more than 15% in the spray-torch to workpiece distance qualified.

QW-410.45 A change in the method of surface preparation of the base metal to be hard-faced (example: sandblasting versus chemical cleaning).

QW-410.46 A change in the spray-torch model or tip orifice size.

QW-410.47 A change of more than 10% in the fusing temperature range qualified. A change in the rate of cooling from the fusing temperature of more than 50°F/hr (28°C/h), a change in the fusing method (e.g., torch, furnace, induction).

QW-410.48 A change in the constricted arc from transferable to nontransferable or vice versa.

QW-410.49 A change in the diameter of the plasma torch-arc constricting orifice.

QW-410.50 A change in the number of electrodes acting on the same welding puddle.

QW-410.52 A change in the method of delivering the filler metal to the molten pool, such as from the leading or trailing edge of the torch, the sides of the torch, or through the torch.

QW-410.53 A change of more than 20% in the center-to-center weld bead distance.

QW-410.54 A change in the upset length or force of more than 10%.

QW-410.55 A change in the distance between the clamping dies of more than 10% or a change in the surface preparation of the clamping area.

QW-410.56 A change in the clamping force by more than 10%.

QW-410.57 A change in more than 10% of the forward or reverse speed.

QW-410.58 The deletion of surface temper beads (see [Figure QW-462.12](#)) or a change from surface temper beads that cover the weld surface to beads that are only deposited along the toes of the weld.

QW-410.59 A change from machine or automatic welding to manual or semiautomatic welding.

QW-410.60 The addition of thermal methods to prepare the surface to be welded unless the WPS requires that the metal be ground to bright metal before welding.

QW-410.61 The distance, S , from the toe of the weld to the edge of any tempering bead shall be limited to the distance measured on the test coupon $\pm \frac{1}{16}$ in. (± 1.5 mm) (see [Figure QW-462.12](#)). Alternatively, a range for S may be established by locating temper beads at various distances from the toe of the weld followed by hardness traverses or toughness testing, as applicable. Temper reinforcing beads shall not be permitted to touch the toe of the weld. In addition, the ratios of heat input described in [QW-409.29](#) shall apply to temper beads.

QW-410.62 The method of removal of surface temper bead reinforcing layer when it will be removed, including provisions to prevent overheating of the weld surface.

QW-410.63 For weld beads against the base metal and for each tempering bead layer, the range of bead width, b , relative to overlap of the previous bead width, a , as shown in [Figure QW-462.13](#), shall be specified on the WPS. Overlap between 25% and 75% does not require qualification.

(a) Overlap greater than 75% shall be qualified by welding a test coupon using the desired overlap. The overlap qualified shall be the maximum overlap permitted and the minimum overlap shall be 50%.

(b) Overlap less than 25% shall be qualified by welding a test coupon using the desired overlap. The overlap qualified shall be the minimum overlap permitted and the maximum overlap shall be 50%.

QW-410.64 For vessels or parts of vessels constructed with P-No. 11A and P-No. 11B base metals, weld grooves for thicknesses less than $\frac{5}{8}$ in. (16 mm) shall be prepared by thermal processes when such processes are to be employed during fabrication. This groove preparation shall also include back gouging, back grooving, or removal of unsound weld metal by thermal processes when these processes are to be employed during fabrication.

QW-410.65 The addition or deletion of grinding beyond that required to clean the surface or remove minor surface flaws (i.e., use or nonuse of half-bead technique or similar technique).

QW-410.66 A change of more than $\pm 10\%$ in the travel speed, the ratio of the beam diameter to focal length, or the lens to work distance.

QW-410.67 A change in the optical technique used to focus the welding energy from that qualified.

QW-410.68 A change in welding equipment type (e.g., YAG, TAG, etc.).

QW-410.70 A change in the method of preparing the base metal surface prior to insertion into the furnace.

QW-410.71 A decrease in the percentage of block compression (original stack height compared to height after welding) from that of the test coupon.

QW-410.72 A decrease in the welding temperature or time from that used on the procedure qualification test coupon.

QW-410.73 A change in joint restraint fixtures from that qualified (e.g., fixed anvil to self-reacting, and vice versa) or from single-sided to two-sided welding, and vice versa.

QW-410.74 A change in the welding control method from that qualified (e.g., force control method to position control method, or vice versa, in the plunge direction; and force control method to travel control method, or vice versa, in the travel direction).

QW-410.75 A change in the rotating tool

(a) type or design from the qualified "family" to another (i.e., threaded pin, smooth pin, fluted, self-reacting, retracting-pin, or other tool types)

(b) configuration or dimensions from that qualified beyond the following limits (as applicable):

(1) shoulder diameter greater than 10%

(2) shoulder scroll pitch greater than 10%

(3) shoulder profile (e.g., addition or deletion of shoulder feature)

(4) pin diameter greater than 5%

(5) pin length greater than the lesser of 5% of qualified pin length or 1% of base metal thickness (not minimum pin length for retracting-pin tools, and not applicable for self-reacting rotating tools)

(6) pin taper angle greater than 5 deg

(7) flute pitch greater than 5%

(8) pin tip geometry or shape

(9) thread pitch greater than 10% (as applicable)

(10) flat design resulting in a change of the total flat surface area greater than 20%

(11) number of flats

(12) cooling characteristics of the rotating pin (e.g., change from water-cooled to air-cooled, and vice versa)

(c) pin material specification, nominal chemical composition, and minimum hardness

QW-410.76 A change in the rotating tool operation from that qualified beyond the following limits (as applicable):

- (a) decrease in rotation speed, or increase greater than 10%
- (b) direction of rotation
- (c) plunge force greater than 10% or plunge position set point greater than 5% when controlling the plunge direction (except during ramp-up and ramp-down when starting and stopping)
- (d) angular tilt greater than 1 deg in any direction
- (e) travel force or travel speed greater than 10% when controlling travel direction (except during ramp-up and ramp-down when starting and stopping)
- (f) range of relative motion between tool components when using self-reacting or retractable-pin tools
- (g) reduction in the smallest radius of travel path curvature that results in reversing the travel direction of the pin or the shoulder
- (h) manner or angle of intersection, or number of coincident intersections, within the same weld or between the weld and the HAZ of other welds

QW-410.77 A change in the laser wavelength (e.g., CO₂, Nd:YAG, fiber, disk, diode) from that qualified.

QW-410.80 A change of $\pm 5\%$ in the diameter of the focused spot size.

QW-410.81 The addition of tube expansion prior to welding.

QW-410.82 A change in the method of pressure application.

QW-410.83 A change in the type of explosive or a change in the energy content greater than $\pm 10\%$.

QW-410.84 A change in the distance between the explosive charge and the tubesheet face greater than $\pm 10\%$.

QW-410.85 A change in the specified clearance between the tube and the tubesheet greater than $\pm 10\%$.

QW-410.86 For the machine or automatic welding process, a change of more than $\pm 10\%$ in width, frequency, or dwell time of oscillation technique. (21)

Table QW-416
Welding Variables
Welder Performance

Paragraph [Note (1)]	Brief of Variables	Essential					
		OFW Table QW-352	SMAW Table QW-353	SAW Table QW-354	GMAW [Note (2)] Table QW-355	GTAW Table QW-356	PAW Table QW-357
QW-402 Joints	.4 - Backing		X		X	X	X
	.7 + Backing	X					
QW-403 Base Metal	.2 Maximum qualified	X					
	.16 ϕ Pipe diameter		X	X	X	X	X
	.18 ϕ P-Number	X	X	X	X	X	X
QW-404 Filler Metals	.14 \pm Filler	X				X	X
	.15 ϕ F-Number	X	X	X	X	X	X
	.22 \pm Inserts					X	X
	.23 ϕ Filler metal product form					X	X
	.30 ϕ t Weld deposit		X	X	X	X	X
	.31 ϕ t Weld deposit	X					
QW-405 Positions	.32 t Limit (s. cir. arc)				X		
	.1 + Position	X	X	X	X	X	X
QW-408 Gas	.3 ϕ $\uparrow\downarrow$ Vert. welding		X		X	X	X
	.7 ϕ Type fuel gas	X					
QW-409 Electrical	.8 - Inert backing				X	X	X
	.2 ϕ Transfer mode				X		
	.4 ϕ Current or polarity					X	

Welding Processes:

OFW	Oxyfuel gas welding
SMAW	Shielded metal-arc welding
SAW	Submerged-arc welding
GMAW	Gas metal-arc welding
GTAW	Gas tungsten-arc welding
PAW	Plasma-arc welding

Legend:

ϕ Change
+ Addition
- Deletion

t Thickness
 \uparrow Uphill
 \downarrow Downhill

NOTES:

(1) For description, see Article IV.

(2) Flux-cored arc welding as shown in Table QW-355, with or without additional shielding from an externally supplied gas or gas mixture, is included.

(21) QW-420 P-NUMBERS

QW-421 P-NUMBERS AND GROUP NUMBERS

(a) *P-Numbers.* P-Numbers (P-No.) are assigned to base metals for the purpose of reducing the number of welding and brazing procedure qualifications required.

P-Numbers are alphanumeric designations; accordingly, each P-Number designation shall be considered a separate P-Number (e.g., base metals assigned P-No. 5A are considered a separate P-Number from those assigned P-No. 5B or P-No. 5C).

(b) *Group Numbers.* Ferrous base metals have been assigned Group Numbers creating subsets of P-Numbers that are used when WPSs are required to be qualified by toughness testing by other Sections or Codes.

QW-421.1 Assignments of P-Numbers and Group Numbers.

(a) P-Number and Group Number assignments are listed in [Table QW/QB-422](#). If an unlisted base metal has the same UNS number designation as a base metal listed in [Table QW/QB-422](#), that base metal is also assigned that P-Number or P-Number plus Group Number.

These assignments are based essentially on comparable base metal characteristics, such as composition, weldability, brazeability, and mechanical properties, where this can logically be done. These assignments do not imply that base metals may be indiscriminately substituted for a base metal that was used in the qualification test without consideration of compatibility from the standpoint of metallurgical properties, postweld heat treatment, design, mechanical properties, and service requirements.

[Table QW/QB-422](#) shows the assignment groups for various alloy systems.

(b) Material produced under an ASTM specification shall have the same P-Number or P-Number plus Group Number and minimum specified tensile strength value as that of the corresponding ASME specification. These materials are listed in [Table QW/QB-422](#) with prefix A/SA- or B/SB- (e.g., listed under A/SA-240, SA-240 Type 304 is assigned P-No. 8, Group No. 1; and A240 Type 304 is also P-No. 8, Group No. 1).

(c) Material produced to material specifications other than ASTM specifications that have been adopted by ASME for use in the ASME Boiler and Pressure Vessel Code is provided the prefix SA or SB (e.g., SA/GB 713 Grade Q345R), and P-Numbers are assigned per [Table QW/QB-422](#).

Material produced to the source material specification (e.g., GB 713 Grade Q345R) is unassigned unless separately classified in [Table QW/QB-422](#).

**Table QW/QB-421.2
Base Metal Assignment Groups**

Base Metal	Welding	Brazing
Steel and steel alloys	P-No. 1 through P-No. 15F	P-No. 101 through P-No. 103
Aluminum and aluminum-base alloys	P-No. 21 through P-No. 26	P-No. 104 and P-No. 105
Copper and copper- base alloys	P-No. 31 through P-No. 35	P-No. 107 and P-No. 108
Nickel and nickel- base alloys	P-No. 41 through P-No. 49	P-No. 110 through P-No. 112
Titanium and titanium- base alloys	P-No. 51 through P-No. 53	P-No. 115
Zirconium and zirconium-base alloys	P-No. 61 and P-No. 62	P-No. 117

QW-421.3 Other Groupings. [Table QW/QB-422](#) contains other groupings.

(a) The column "AWS B2.2 BM" in [Table QW/QB-422](#) is a listing of the assignments of materials in accordance with the brazing grouping criteria of AWS B2.2/B2.2M, *Specification for Brazing Procedure and Performance Qualification*. The use of either P-Numbers, BM-Numbers, or both are permitted for brazing procedure and performance qualifications, and brazing procedure specifications.

(b) The column "ISO/TR 15608 Group" in [Table QW/QB-422](#) is a listing of the assignments of materials in accordance with the grouping criteria of ISO/TR 15608, *Welding — Guidelines for a metallic materials grouping system*, and it is consistent with the assignments found in ISO/TR 20173, *Grouping systems for materials — American materials*. While this listing is provided as a convenience to users worldwide, it is provided for information only. Section IX does not refer to this grouping as a basis for establishing the range of base metals qualified for either procedure or performance qualification.

(c) In 2009, S-Numbers were removed from [Table QW/QB-422](#). S-Numbers were assigned to materials that were acceptable for use by the ASME B31 Code for Pressure Piping, or by selected Boiler and Pressure Vessel Code Cases, but which were not included within ASME Boiler and Pressure Vessel Code Material Specifications (Section II). Base metals previously assigned S-Numbers were reassigned the corresponding P-Numbers or P-Numbers plus Group Numbers.

QW-421.4 Reassignments of P-Numbers and Group Numbers. There are instances where materials assigned to one P- or S-Number or Group Number have been reassigned to a different P- or S-Number or Group Number in later editions. Procedure and performance qualifications that were qualified under the previous P- or S-Numbers

or Group Number assignment may continue to be used under the new P-Number or Group Number assignment [see [QW-200.2\(c\)](#), provided the WPS is revised to limit the materials qualified for welding to those assigned to the new P- or S-number(s) and Group number(s) for the specific material(s) originally used for the procedure qualification test coupon. Other materials from the original P- or S-Number and Group Number must be reassigned to the same P- or S-Number or Group Number to be considered qualified for welding under the revised WPS.

QW-421.5 Acceptance Tensile Values.

(a) *Base Metals Listed in Table QW/QB-422.* The column "Minimum Specified Tensile" in Table QW/QB-422 lists the acceptance values for the tensile tests of the welding or brazing procedure qualification, except as otherwise allowed in [QW-153](#) or [QB-153](#).

Base metals listed with minimum specified tensile values may be used for procedure qualification.

Base metals listed without a minimum specified tensile value shall not be used for the purpose of groove weld procedure qualification.

(b) *Base Metals Not Listed in Table QW/QB-422.* If an unlisted base metal having the same UNS number of a listed base metal is used for procedure qualification, the minimum tensile value of the listed base metal shall apply for the tension test specimens.

For unassigned unlisted base metals, the minimum tensile strength definition requirements of [QW-424.1](#) apply.

(21)

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous											
A/SA-36	58 (400)	1	1	101	100	11.1	C-Mn-Si	Plate, bar & shapes	...
A/SA-53	E, A	K02504	48 (330)	1	1	101	100	1.1	C	Resistance welded pipe	...
A/SA-53	S, A	K02504	48 (330)	1	1	101	100	1.1	C	Smis. pipe	...
A/SA-53	E, B	K03005	60 (415)	1	1	101	100	11.1	C-Mn	Resistance welded pipe	...
A/SA-53	F	K03005	48 (330)	1	1	101	100	11.1	C	Furnace welded pipe	...
A/SA-53	S, B	K03005	60 (415)	1	1	101	100	11.1	C-Mn	Smis. pipe	...
A/SA-105	...	K03504	70 (485)	1	2	101	100	11.1	C	Flanges & fittings	...
A/SA-106	A	K02501	48 (330)	1	1	101	100	1.1	C-Si	Smis. pipe	...
A/SA-106	B	K03006	60 (415)	1	1	101	100	11.1	C-Mn-Si	Smis. pipe	...
A/SA-106	C	K03501	70 (485)	1	2	101	100	11.1	C-Mn-Si	Smis. pipe	...
A108	1015	G10150	...	1	1	101	100	1.1	C	Bar	...
A108	1018	G10180	...	1	1	101	100	1.1	C	Bar	...
A108	1020	G10200	...	1	1	101	100	1.1	C	Bar	...
A108	8620	G86200	...	3	3	102	100	4.1	0.5Ni-0.5Cr-Mo	Bar	...
A/SA-134	SA283 A	K01400	45 (310)	1	1	101	100	1.1	C	Welded pipe	...
A/SA-134	SA285 A	K01700	45 (310)	1	1	101	100	1.1	C	Welded pipe	...
A/SA-134	SA283 B	K01702	50 (345)	1	1	101	100	1.1	C	Welded pipe	...
A/SA-134	SA285 B	K02200	50 (345)	1	1	101	100	1.1	C	Welded pipe	...
A/SA-134	SA283 C	K02401	55 (380)	1	1	101	100	1.1	C	Welded pipe	...
A/SA-134	SA283 D	K02702	60 (415)	1	1	101	100	11.1	C	Welded pipe	...
A/SA-134	SA285 C	K02801	55 (380)	1	1	101	100	11.1	C	Welded pipe	...
A/SA-135	A	K02509	48 (330)	1	1	101	100	1.1	C	E.R.W. pipe	...
A/SA-135	B	K03018	60 (415)	1	1	101	100	11.1	C	E.R.W. pipe	...
A139	A	K02508	48 (330)	1	1	101	100	1.1	C	Welded pipe	...
A139	B	K03003	60 (415)	1	1	101	100	11.1	C	Welded pipe	...
A139	C	K03004	60 (415)	1	1	101	100	11.1	C	Welded pipe	...
A139	D	K03010	60 (415)	1	1	101	100	11.1	C	Welded pipe	...
A139	E	K03012	66 (455)	1	1	101	100	11.1	C	Welded pipe	...
A167	302B	S30215	75 (515)	8	1	102	130	8.1	18Cr-8Ni-2Si	Plate, sheet & strip	...
A167	308	S30800	75 (515)	8	2	102	130	8.2	20Cr-10Ni	Plate, sheet & strip	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing					Typical Product Form	Nominal Thickness Limits, in. (mm)	
				P-No.	Group No.	AWS P-No.	B2.2 BM Group	ISO 15608 Nominal Composition					
Ferrous (Cont'd)													
A167	309	S30900	75 (515)	8	2	102	130	8.2	23Cr-12Ni		Plate, sheet & strip	...	
A167	310	S31000	75 (515)	8	2	102	130	8.2	25Cr-20Ni		Plate, sheet & strip	...	
A/SA-178	A	K01200	47 (325)	1	1	101	100	1.1	C		E.R.W. tube	...	
A/SA-178	D	K02709	70 (485)	1	2	101	100	11.1	C-Mn-Si		E.R.W. tube	...	
A/SA-178	C	K03503	60 (415)	1	1	101	100	11.1	C		E.R.W. tube	...	
A/SA-179	...	K01200	47 (325)	1	1	101	100	1.1	C		Smls. tube	...	
A/SA-181	Cl. 60	K03502	60 (415)	1	1	101	100	11.1	C-Si		Pipe flange & fittings	...	
A/SA-181	Cl. 70	K03502	70 (485)	1	2	101	100	11.1	C-Si		Pipe flange & fittings	...	
A/SA-182	F12, Cl. 1	K11562	60 (415)	4	1	102	110	5.1	1Cr-0.5Mo		Forgings	...	
A/SA-182	F12, Cl. 2	K11564	70 (485)	4	1	102	110	5.1	1Cr-0.5Mo		Forgings	...	
A/SA-182	F11, Cl. 2	K11572	70 (485)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si		Forgings	...	
A/SA-182	F11, Cl. 3	K11572	75 (515)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si		Forgings	...	
A/SA-182	F11, Cl. 1	K11597	60 (415)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si		Forgings	...	
A/SA-182	F2	K12122	70 (485)	3	2	101	100	4.2	0.5Cr-0.5Mo		Forgings	...	
A/SA-182	F1	K12822	70 (485)	3	2	101	100	1.1	C-0.5Mo		Forgings	...	
A/SA-182	F22, Cl. 1	K21590	60 (415)	5A	1	102	110	5.2	2.25Cr-1Mo		Forgings	...	
A/SA-182	F22, Cl. 3	K21590	75 (515)	5A	1	102	110	5.2	2.25Cr-1Mo		Forgings	...	
A/SA-182	FR	K22035	63 (435)	9A	1	101	100	9.1	2Ni-1Cu		Forgings	...	
A/SA-182	F3VCb	K31390	85 (585)	5C	1	102	110	6.2	3Cr-1Mo-0.25V-Cb-Ca		Forgings	...	
A/SA-182	F21	K31545	75 (515)	5A	1	102	110	5.2	3Cr-1Mo		Forgings	...	
A/SA-182	F3V	K31830	85 (585)	5C	1	102	120	6.2	3Cr-1Mo-V-Ti-B		Forgings	...	
A/SA-182	F22V	K31835	85 (585)	5C	1	102	110	6.2	2.25Cr-1Mo-V		Forgings	...	
A/SA-182	F5	K41545	70 (485)	5B	1	102	110	5.3	5Cr-0.5Mo		Forgings	...	
A/SA-182	F5a	K42544	90 (620)	5B	1	102	110	5.3	5Cr-0.5Mo		Forgings	...	
A/SA-182	F91	K90901	90 (620)	15E	1	102	110	6.4	9Cr-1Mo-V		Forgings	...	
A/SA-182	F9	K90941	85 (585)	5B	1	102	110	5.4	9Cr-1Mo		Forgings	...	
A/SA-182	F92	K92460	90 (620)	15E	1	102	110	6.4	9Cr-2W		Forgings	...	
A/SA-182	...	N08367	95 (655)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N		Forgings	...	
A/SA-182	F904L	N08904	71 (490)	45	...	111	420	8.2	44Fe-25Ni-21Cr-Mo		Forgings	...	
A/SA-182	FXM-19	S20910	100 (690)	8	3	102	130	8.3	22Cr-13Ni-5Mn		Forgings	...	
A/SA-182	FXM-11	S21904	90 (620)	8	3	102	130	8.3	21Cr-6Ni-9Mn		Forgings	...	
A/SA-182	F304	S30400	70 (485)	8	1	102	130	8.1	18Cr-8Ni		Forgings	>5 in. (125)	
A/SA-182	F304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni		Forgings	...	
A/SA-182	F304L	S30403	65 (450)	8	1	102	130	8.1	18Cr-8Ni		Forgings	>5 in. (125)	

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A/SA-182	F304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Forgings	...
A/SA-182	F304H	S30409	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Forgings	>5 in. (125)
A/SA-182	F304H	S30409	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Forgings	...
A/SA-182	F304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N	Forgings	...
A/SA-182	F304LN	S30453	70 (485)	8	1	102	130	8.1	18Cr-8Ni-N	Forgings	>5 in. (125)
A/SA-182	F304LN	S30453	75 (515)	8	1	102	130	8.1	18Cr-8Ni-N	Forgings	...
A/SA-182	F46	S30600	78 (540)	8	1	102	130	8.1	18Cr-15Ni-4Si	Forgings	...
A/SA-182	F45	S30815	87 (600)	8	2	102	130	8.2	21Cr-11Ni-N	Forgings	...
A/SA-182	F310	S31000	70 (485)	8	2	102	130	8.2	25Cr-20Ni	Forgings	>5 in. (125)
A/SA-182	F310	S31000	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Forgings	...
A/SA-182	F310H	S31009	70 (485)	8	2	102	130	8.2	25Cr-20Ni	Forgings	>5 in. (125)
A/SA-182	F310H	S31009	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Forgings	...
A/SA-182	F310MoLN	S31050	78 (540)	8	2	102	130	8.2	25Cr-22Ni-2Mo-N	Forgings	...
A/SA-182	F50	S31200	100 (690)	10H	1	102	145	10.2	25Cr-6Ni-Mo-N	Forgings	...
A/SA-182	F44	S31254	94 (650)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Forgings	...
A/SA-182	F58	S31266	109 (750)	45	...	102	420	8.2	24Cr-22Ni-6Mo-3Mn-Cu-W-N	Forgings	...
A/SA-182	F316	S31600	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Forgings	>5 in. (125)
A/SA-182	F316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Forgings	...
A/SA-182	F316L	S31603	65 (450)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Forgings	>5 in. (125)
A/SA-182	F316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Forgings	...
A/SA-182	F316H	S31609	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Forgings	>5 in. (125)
A/SA-182	F316H	S31609	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Forgings	...
A/SA-182	F316H	S31609	78 (540)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Forgings	>5 in. (125)
A/SA-182	F316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Forgings	...
A/SA-182	F316LN	S31653	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Forgings	>5 in. (125)
A/SA-182	F316LN	S31653	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Forgings	...
A/SA-182	F317	S31700	70 (485)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Forgings	>5 in. (125)
A/SA-182	F317	S31700	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Forgings	...
A/SA-182	F317L	S31703	65 (450)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Forgings	>5 in. (125)
A/SA-182	F317L	S31703	70 (485)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Forgings	...
A/SA-182	F51	S31803	90 (620)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Forgings	...
A/SA-182	...	S32053	93 (640)	8	4	102	130	8.2	23Cr-25Ni-5.5Mo-N	Forgings	...
A/SA-182	F321	S32100	70 (485)	8	1	102	140	8.1	18Cr-10Ni-Ti	Forgings	>5 in. (125)
A/SA-182	F321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Forgings	...
A/SA-182	F321H	S32109	70 (485)	8	1	102	140	8.1	18Cr-10Ni-Ti	Forgings	>5 in. (125)
A/SA-182	F321H	S32109	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Forgings	...
A/SA-182	...	S32202	94 (650)	10H	1	102	145	10.3	22Cr-2Ni-Mo-N	Forgings	...
A/SA-182	F60	S32205	95 (655)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Forgings	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	AWS P-No.	B2.2 BM Group	ISO 15608 Nominal Composition			
Ferrous (Cont'd)											
A/SA-182	...	S32506	90 (620)	10H	1	102	145	10.2	25Cr-6Ni-Mo-N	Forgings	...
A/SA-182	F53	S32750	116 (800)	10H	1	102	145	10.2	25Cr-7Ni-4Mo-N	Forgings	...
A/SA-182	F55	S32760	109 (750)	10H	1	102	145	10.2	25Cr-8Ni-3Mo-W-Cu-N	Forgings	...
A/SA-182	F10	S33100	80 (550)	8	2	102	130	8.1	20Ni-8Cr	Forgings	...
A/SA-182	F49	S34565	115 (795)	8	4	102	130	8.3	24Cr-17Ni-6Mn-4.5Mo-N	Forgings	...
A/SA-182	F347	S34700	70 (485)	8	1	102	130	8.1	18Cr-10Ni-Cb	Forgings	>5 in. (125)
A/SA-182	F347	S34700	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Forgings	...
A/SA-182	F347H	S34709	70 (485)	8	1	102	130	8.1	18Cr-10Ni-Cb	Forgings	>5 in. (125)
A/SA-182	F347H	S34709	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Forgings	...
A/SA-182	F348	S34800	70 (485)	8	1	102	130	8.1	18Cr-10Ni-Cb	Forgings	>5 in. (125)
A/SA-182	F348	S34800	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Forgings	...
A/SA-182	F348H	S34809	70 (485)	8	1	102	130	8.1	18Cr-10Ni-Cb	Forgings	>5 in. (125)
A/SA-182	F348H	S34809	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Forgings	...
A/SA-182	F54	S39274	116 (800)	10H	1	102	145	10.2	25Cr-7Ni-3Mo-2W-Cu-N	Forgings	...
A/SA-182	F6a, Cl. 1	S41000	70 (485)	6	1	102	150	7.2	13Cr	Forgings	...
A/SA-182	F6a, Cl. 2	S41000	85 (585)	6	3	102	150	7.2	13Cr	Forgings	...
A/SA-182	F6a, Cl. 3	S41000	110 (760)	6	3	102	150	7.2	13Cr	Forgings	...
A/SA-182	F6a, Cl. 4	S41000	130 (895)	6	3	102	150	7.2	13Cr	Forgings	...
A/SA-182	F6b	S41026	110 (760)	6	3	102	150	7.2	13Cr-0.5Mo	Forgings	...
A/SA-182	F6NM	S41500	115 (795)	6	4	102	150	7.2	13Cr-4.5Ni-Mo	Forgings	...
A/SA-182	F429	S42900	60 (415)	6	2	102	150	7.2	15Cr	Forgings	...
A/SA-182	F430	S43000	60 (415)	7	2	102	150	7.1	17Cr	Forgings	...
A/SA-182	FXM-27Cb	S44627	60 (415)	10I	1	102	150	7.1	27Cr-1Mo	Forgings	...
A/SA-192	...	K01201	47 (325)	1	1	101	100	1.1	C-Si	Smls. tube	...
A199	T11	K11597	60 (415)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Smls. tube	...
A199	T22	K21590	60 (415)	5A	1	102	110	5.2	2.25Cr-1Mo	Smls. tube	...
A199	T21	K31545	60 (415)	5A	1	102	110	...	3Cr-1Mo	Smls. tube	...
A199	T5	K41545	60 (415)	5B	1	102	110	5.3	5Cr-0.5Mo	Smls. tube	...
A199	T9	K81590	60 (415)	5B	1	102	110	5.4	9Cr-1Mo	Smls. tube	...
A/SA-203	F	...	75 (515)	9B	1	101	100	9.2	3.5Ni	Plate	>2 (50)
A/SA-203	F	...	80 (550)	9B	1	101	100	9.2	3.5Ni	Plate	≤2 (50)
A/SA-203	A	K21703	65 (450)	9A	1	101	100	9.1	2.25Ni	Plate	...
A/SA-203	B	K22103	70 (485)	9A	1	101	100	9.1	2.25Ni	Plate	...
A/SA-203	D	K31718	65 (450)	9B	1	101	100	9.2	3.5Ni	Plate	...
A/SA-203	E	K32018	70 (485)	9B	1	101	100	9.2	3.5Ni	Plate	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)		
				P-No.	Group No.	AWS B2.2 BM P-No.	ISO 15608 Group		Nominal Composition				
Ferrous (Cont'd)													
A/SA-204	A	K11820	65 (450)	3	1	101	100	1.1	C-0.5Mo	Plate	...		
A/SA-204	B	K12020	70 (485)	3	2	101	100	1.1	C-0.5Mo	Plate	...		
A/SA-204	C	K12320	75 (515)	3	2	101	100	1.2	C-0.5Mo	Plate	...		
A/SA-209	T1b	K11422	53 (365)	3	1	101	100	1.1	C-0.5Mo	Smls. tube	...		
A/SA-209	T1	K11522	55 (380)	3	1	101	100	1.1	C-0.5Mo	Smls. tube	...		
A/SA-209	T1a	K12023	60 (415)	3	1	101	100	1.1	C-0.5Mo	Smls. tube	...		
A/SA-210	A-1	K02707	60 (415)	1	1	101	100	11.1	C-Si	Smls. tube	...		
A/SA-210	C	K03501	70 (485)	1	2	101	100	11.1	C-Mn-Si	Smls. tube	...		
A211	A570-30	K02502	49 (340)	1	1	101	100	1.1	C	Welded pipe	...		
A211	A570-33	K02502	52 (360)	1	1	101	100	1.1	C	Welded pipe	...		
A211	A570-40	K02502	55 (380)	1	1	101	100	1.1	C	Welded pipe	...		
A/SA-213	T2	K11547	60 (415)	3	1	101	100	4.2	0.5Cr-0.5Mo	Smls. tube	...		
A/SA-213	T12	K11562	60 (415)	4	1	102	110	5.1	1Cr-0.5Mo	Smls. tube	...		
A/SA-213	T11	K11597	60 (415)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Smls. tube	...		
A/SA-213	T17	K12047	60 (415)	10B	1	102	110	4.1	1Cr-V	Smls. tube	...		
A/SA-213	T22	K21590	60 (415)	5A	1	102	110	5.2	2.25Cr-1Mo	Smls. tube	...		
A/SA-213	T21	K31545	60 (415)	5A	1	102	110	5.2	3Cr-1Mo	Smls. tube	...		
A/SA-213	T5c	K41245	60 (415)	5B	1	102	120	5.3	5Cr-0.5Mo-Ti	Smls. tube	...		
A/SA-213	T5	K41545	60 (415)	5B	1	102	110	5.3	5Cr-0.5Mo	Smls. tube	...		
A/SA-213	T5b	K51545	60 (415)	5B	1	102	110	5.3	5Cr-0.5Mo-Si	Smls. tube	...		
A/SA-213	T91	K90901	85 (585)	15E	1	102	110	6.4	9Cr-1Mo-V	Smls. tube	...		
A/SA-213	T9	K90941	60 (415)	5B	1	102	110	5.4	9Cr-1Mo	Smls. tube	...		
A/SA-213	T92	K92460	90 (620)	15E	1	102	110	6.4	9Cr-2W	Smls. tube	...		
A/SA-213	TP201	S20100	95 (655)	8	3	102	130	8.3	17Cr-4Ni-6Mn	Smls. tube	...		
A/SA-213	TP202	S20200	90 (620)	8	3	102	130	8.3	18Cr-5Ni-9Mn	Smls. tube	...		
A/SA-213	XM-19	S20910	100 (690)	8	3	102	130	8.3	22Cr-13Ni-5Mn	Smls. tube	...		
A/SA-213	TP304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Smls. tube	...		
A/SA-213	TP304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Smls. tube	...		
A/SA-213	TP304H	S30409	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Smls. tube	...		
A/SA-213	...	S30432	86 (595)	8	1	102	130	8.1	18Cr-9Ni-3Cu-Cb-N	Smls. tube	...		
A/SA-213	TP304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N	Smls. tube	...		
A/SA-213	TP304LN	S30453	75 (515)	8	1	102	130	8.1	18Cr-8Ni-N	Smls. tube	...		
A/SA-213	S30815	S30815	87 (600)	8	2	102	130	8.2	21Cr-11Ni-N	Smls. tube	...		
A/SA-213	TP309S	S30908	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Smls. tube	...		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing					Typical Product Form	Nominal Thickness Limits, in. (mm)	
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition				
Ferrous (Cont'd)													
A/SA-213	TP309H	S30909	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Smls. tube	...		
A/SA-213	TP309Cb	S30940	75 (515)	8	2	102	130	8.2	23Cr-12Ni-Cb	Smls. tube	...		
A/SA-213	TP309HCb	S30941	75 (515)	8	2	102	130	8.2	23Cr-12Ni-Cb	Smls. tube	...		
A/SA-213	TP310S	S31008	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Smls. tube	...		
A/SA-213	TP310H	S31009	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Smls. tube	...		
A/SA-213	TP310Cb	S31040	75 (515)	8	2	102	130	8.2	25Cr-20Ni-Cb	Smls. tube	...		
A/SA-213	TP310HCb	S31041	75 (515)	8	2	102	130	8.2	25Cr-20Ni-Cb	Smls. tube	...		
A/SA-213	TP310HCbN	S31042	95 (655)	8	3	102	130	8.2	25Cr-20Ni-Cb-N	Smls. tube	...		
A/SA-213	TP310MoLN	S31050	78 (540)	8	2	102	130	8.2	25Cr-22Ni-2Mo-N	Smls. tube	>0.25 (6)		
A/SA-213	TP310MoLN	S31050	84 (580)	8	2	102	130	8.2	25Cr-22Ni-2Mo-N	Smls. tube	≤0.25 (6)		
A/SA-213	...	S31254	95 (655)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Smls. tube	>0.187 (5)		
A/SA-213	...	S31254	98 (675)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Smls. tube	≤0.187 (5)		
A/SA-213	TP316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Smls. tube	...		
A/SA-213	TP316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Smls. tube	...		
A/SA-213	TP316H	S31609	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Smls. tube	...		
A/SA-213	TP316Ti	S31635	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-Ti	Smls. tube	...		
A/SA-213	TP316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Smls. tube	...		
A/SA-213	TP316LN	S31653	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Smls. tube	...		
A/SA-213	TP317	S31700	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Smls. tube	...		
A/SA-213	TP317L	S31703	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Smls. tube	...		
A/SA-213	TP317LM	S31725	75 (515)	8	4	102	130	8.1	19Cr-15Ni-4Mo	Smls. tube	...		
A/SA-213	TP317LMN	S31726	80 (550)	8	4	102	130	8.1	19Cr-15.5Ni-4Mo	Smls. tube	...		
A/SA-213	TP321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Smls. tube	...		
A/SA-213	TP321H	S32109	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Smls. tube	...		
A/SA-213	S32615	S32615	80 (550)	8	1	102	130	8.1	18Cr-20Ni-5.5Si	Smls. tube	...		
A/SA-213	S34565	S34565	115 (795)	8	4	102	130	8.3	24Cr-17Ni-6Mn-4.5Mo-N	Smls. tube	...		
A/SA-213	TP347	S34700	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Smls. tube	...		
A/SA-213	TP347H	S34709	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Smls. tube	...		
A/SA-213	TP347HFG	S34710	80 (550)	8	1	102	130	8.1	18Cr-10Ni-Cb	Smls. tube	...		
A/SA-213	TP347LN	S34751	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb-N	Smls. tube	...		
A/SA-213	TP348	S34800	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Smls. tube	...		
A/SA-213	TP348H	S34809	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Smls. tube	...		
A/SA-213	XM-15	S38100	75 (515)	8	1	102	130	8.1	18Cr-18Ni-2Si	Smls. tube	...		
A/SA-213	...	S38815	78 (540)	8	1	102	130	8.1	14Cr-16Ni-6Si-Cu-Mo	Smls. tube	...		
A/SA-214	...	K01807	47 (325)	1	1	101	100	1.1	C	E.R.W. tube	...		
A/SA-216	WCA	J02502	60 (415)	1	1	101	100	1.1	C-Si	Castings	...		

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)		
				P-No.	Group No.	AWS B2.2 BM P-No.	ISO 15608 Group		Nominal Composition				
							101	100	1.1				
Ferrous (Cont'd)													
A/SA-216	WCC	J02503	70 (485)	1	2	101	100	1.1	C-Mn-Si	Castings	...		
A/SA-216	WCB	J03002	70 (485)	1	2	101	100	1.1	C-Si	Castings	...		
A/SA-217	WC6	J12072	70 (485)	4	1	102	110	5.1	1.25Cr-0.5Mo	Castings	...		
A/SA-217	WC4	J12082	70 (485)	4	1	101	100	9.1	1Ni-0.5Cr-0.5Mo	Castings	...		
A/SA-217	WC1	J12524	65 (450)	3	1	101	100	1.1	C-0.5Mo	Castings	...		
A/SA-217	WC9	J21890	70 (485)	5A	1	102	110	5.2	2.25Cr-1Mo	Castings	...		
A/SA-217	WC5	J22000	70 (485)	4	1	101	100	4.2	0.75Ni-1Mo-0.75Cr	Castings	...		
A/SA-217	C5	J42045	90 (620)	5B	1	102	110	5.3	5Cr-0.5Mo	Castings	...		
A/SA-217	C12	J82090	90 (620)	5B	1	102	110	5.4	9Cr-1Mo	Castings	...		
A/SA-217	C12A	J84090	85 (585)	15E	1	102	110	6.4	9Cr-1Mo-V	Castings	...		
A/SA-217	CA15	J91150	90 (620)	6	3	102	150	7.2	13Cr	Castings	...		
A/SA-225	D	K12004	75 (515)	10A	1	101	100	2.1	Mn-0.5Ni-V	Plate	>3 (75)		
A/SA-225	D	K12004	80 (550)	10A	1	101	100	2.1	Mn-0.5Ni-V	Plate	≤3 (75)		
A/SA-225	C	K12524	105 (725)	10A	1	101	100	4.1	Mn-0.5Ni-V	Plate	...		
A/SA-234	WP11, Cl. 1	...	60 (415)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Piping fittings	...		
A/SA-234	WP11, Cl. 3	...	75 (515)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Piping fittings	...		
A/SA-234	WPB	K03006	60 (415)	1	1	101	100	11.1	C-Mn-Si	Piping fittings	...		
A/SA-234	WPC	K03501	70 (485)	1	2	101	100	11.1	C-Mn-Si	Piping fittings	...		
A/SA-234	WP12, Cl. 1	K12062	60 (415)	4	1	101	110	5.1	1Cr-0.5Mo	Piping fittings	...		
A/SA-234	WP12, Cl. 2	K12062	70 (485)	4	1	101	110	5.1	1Cr-0.5Mo	Piping fittings	...		
A/SA-234	WP1	K12821	55 (380)	3	1	101	100	11.2	C-0.5Mo	Piping fittings	...		
A/SA-234	WP22, Cl. 1	K21590	60 (415)	5A	1	102	110	5.2	2.25Cr-1Mo	Piping fittings	...		
A/SA-234	WP22, Cl. 3	K21590	75 (515)	5A	1	102	110	5.2	2.25Cr-1Mo	Piping fittings	...		
A/SA-234	WPR	K22035	63 (435)	9A	1	101	100	9.1	2Ni-1Cu	Piping fittings	...		
A/SA-234	WP5, Cl. 1	K41545	60 (415)	5B	1	102	110	5.3	5Cr-0.5Mo	Piping fittings	...		
A/SA-234	WP5, Cl. 3	K41545	75 (515)	5B	1	102	110	5.3	5Cr-0.5Mo	Piping fittings	...		
A/SA-234	WP91	K90901	85 (585)	15E	1	102	110	6.4	9Cr-1Mo-V	Piping fittings	...		
A/SA-234	WP9, Cl. 1	K90941	60 (415)	5B	1	102	110	5.4	9Cr-1Mo	Piping fittings	...		
A/SA-234	WP9, Cl. 3	K90941	75 (515)	5B	1	102	110	5.4	9Cr-1Mo	Piping fittings	...		
A/SA-234	WP92	K92460	90 (620)	15E	1	102	110	6.4	9Cr-2W	Piping fittings	...		
A/SA-240	...	N08367	95 (655)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Plate	≥0.187 (5)		
A/SA-240	...	N08367	100 (690)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Sheet & strip	<0.187 (5)		
A/SA-240	904L	N08904	71 (490)	45	...	111	420	8.2	44Fe-25Ni-21Cr-Mo	Plate, sheet & strip	...		
A/SA-240	201-1	S20100	75 (515)	8	3	102	130	8.3	17Cr-4Ni-6Mn	Plate, sheet & strip	...		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A/SA-240	201-2	S20100	95 (655)	8	3	102	130	8.3	17Cr-4Ni-6Mn	Plate, sheet & strip	...
A/SA-240	201LN	S20153	95 (655)	8	3	...	130	8.3	16Cr-4Ni-6Mn	Plate, sheet & strip	...
A/SA-240	202	S20200	90 (620)	8	3	102	130	8.3	18Cr-5Ni-9Mn	Plate, sheet & strip	...
A/SA-240	...	S20400	95 (655)	8	3	102	130	8.3	16Cr-9Mn-2Ni-N	Plate, sheet & strip	...
A/SA-240	XM-19	S20910	100 (690)	8	3	102	130	8.3	22Cr-13Ni-5Mn	Plate	...
A/SA-240	XM-19	S20910	105 (725)	8	3	102	130	8.3	22Cr-13Ni-5Mn	Sheet & strip	...
A/SA-240	XM-17	S21600	90 (620)	8	3	102	130	8.3	19Cr-8Mn-6Ni-Mo-N	Plate	...
A/SA-240	XM-17	S21600	100 (690)	8	3	102	130	8.3	19Cr-8Mn-6Ni-Mo-N	Sheet & strip	...
A/SA-240	XM-18	S21603	90 (620)	8	3	102	130	8.3	19Cr-8Mn-6Ni-Mo-N	Plate	...
A/SA-240	XM-18	S21603	100 (690)	8	3	102	130	8.3	19Cr-8Mn-6Ni-Mo-N	Sheet & strip	...
A/SA-240	S21800	S21800	95 (655)	8	3	102	130	8.1	18Cr-8Ni-8Mn-4Si-N	Plate, sheet & strip	...
A/SA-240	XM-29	S24000	100 (690)	8	3	102	130	8.3	18Cr-3Ni-12Mn	Plate, sheet & strip	...
A/SA-240	301	S30100	75 (515)	8	1	102	130	8.1	17Cr-7Ni	Plate, sheet & strip	...
A/SA-240	302	S30200	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Plate, sheet & strip	...
A/SA-240	304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Plate, sheet & strip	...
A/SA-240	304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Plate, sheet & strip	...
A/SA-240	304H	S30409	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Plate, sheet & strip	...
A/SA-240	304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N	Plate, sheet & strip	...
A/SA-240	XM-21	S30452	85 (585)	8	1	102	130	8.1	18Cr-8Ni-N	Plate	...
A/SA-240	XM-21	S30452	90 (620)	8	1	102	130	8.1	18Cr-8Ni-N	Sheet & strip	...
A/SA-240	304LN	S30453	75 (515)	8	1	102	130	8.1	18Cr-8Ni-N	Plate, sheet & strip	...
A/SA-240	305	S30500	70 (485)	8	1	102	130	8.1	18Cr-11Ni	Plate, sheet & strip	...
A/SA-240	S30600	S30600	78 (540)	8	1	102	130	8.1	18Cr-15Ni-4Si	Plate, sheet & strip	...
A/SA-240	S30601	S30601	78 (540)	8	1	102	130	8.1	17.5Cr-17.5Ni-5.3Si	Plate, sheet & strip	...
A/SA-240	S30815	S30815	87 (600)	8	2	102	130	8.2	21Cr-11Ni-N	Plate, sheet & strip	...
A/SA-240	309S	S30908	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Plate, sheet & strip	...
A/SA-240	309H	S30909	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Plate, sheet & strip	...
A/SA-240	309Cb	S30940	75 (515)	8	2	102	130	8.2	23Cr-12Ni-Cb	Plate, sheet & strip	...
A/SA-240	309HCB	S30941	75 (515)	8	2	102	130	8.2	23Cr-12Ni-Cb	Plate, sheet & strip	...
A/SA-240	310S	S31008	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Plate, sheet & strip	...
A/SA-240	310H	S31009	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Plate, sheet & strip	...
A/SA-240	310Cb	S31040	75 (515)	8	2	102	130	8.2	25Cr-20Ni-Cb	Plate, sheet & strip	...
A/SA-240	310HCB	S31041	75 (515)	8	2	102	130	8.2	25Cr-20Ni-Cb	Plate, sheet & strip	...
A/SA-240	310MoLN	S31050	78 (540)	8	2	102	130	8.2	25Cr-22Ni-2Mo-N	Plate, sheet & strip	>0.25 (6)
A/SA-240	310MoLN	S31050	84 (580)	8	2	102	130	8.2	25Cr-22Ni-2Mo-N	Plate, sheet & strip	≤0.25 (6)
A/SA-240	S31200	S31200	100 (690)	10H	1	102	145	10.2	25Cr-6Ni-Mo-N	Plate, sheet & strip	...
A/SA-240	S31254	S31254	95 (655)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Plate	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A/SA-240	S31254	S31254	100 (690)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Sheet & strip	...
A/SA-240	S31260	S31260	100 (690)	10H	1	102	145	10.2	25Cr-6.5Ni-3Mo-N	Plate, sheet & strip	...
A/SA-240	...	S31266	109 (750)	45	...	102	420	8.2	24Cr-22Ni-6Mo-3Mn-Cu-W-N	Plate, sheet & strip	...
A/SA-240	S31277	S31277	112 (770)	45	...	111	420	8.2	27Ni-22Cr-7Mo-Mn-Cu	Plate, sheet & strip	...
A/SA-240	316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Plate, sheet & strip	...
A/SA-240	316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Plate, sheet & strip	...
A/SA-240	316H	S31609	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Plate, sheet & strip	...
A/SA-240	316Ti	S31635	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-Ti	Plate, sheet & strip	...
A/SA-240	316Cb	S31640	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-Cb	Plate, sheet & strip	...
A/SA-240	316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Plate, sheet & strip	...
A/SA-240	316LN	S31653	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Plate, sheet & strip	...
A/SA-240	...	S31655	92 (635)	8	3	102	130	8.2	20.5Cr-8.8Ni-Mo-N	Plate, sheet & strip	...
A/SA-240	317	S31700	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Plate, sheet & strip	...
A/SA-240	317L	S31703	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Plate, sheet & strip	...
A/SA-240	S31725	S31725	75 (515)	8	4	102	130	8.1	19Cr-15Ni-4Mo	Plate, sheet & strip	...
A/SA-240	S31726	S31726	80 (550)	8	4	102	130	8.1	19Cr-15.5Ni-4Mo	Plate, sheet & strip	...
A/SA-240	S31753	S31753	80 (550)	8	1	102	130	8.1	18Cr-13Ni-3Mo-N	Plate, sheet & strip	...
A/SA-240	S31803	S31803	90 (620)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Plate, sheet & strip	...
A/SA-240	...	S32003	90 (620)	10H	1	102	145	10.3	21Cr-3.5Ni-Mo-N	Plate, sheet & strip	...
A/SA-240	...	S32053	93 (640)	8	4	102	130	8.2	23Cr-25Ni-5.5Mo-N	Plate, sheet & strip	...
A/SA-240	321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Plate, sheet & strip	...
A/SA-240	...	S32101	95 (655)	10H	1	102	145	10.3	21Cr-5Mn-1.5Ni-Cu-N	Plate, sheet & strip	>0.187 (5)
A/SA-240	...	S32101	101 (700)	10H	1	102	145	10.3	21Cr-5Mn-1.5Ni-Cu-N	Plate, sheet & strip	≤0.187 (5)
A/SA-240	321H	S32109	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Plate, sheet & strip	...
A/SA-240	...	S32202	94 (650)	10H	1	102	145	10.3	22Cr-2Ni-Mo-N	Plate, sheet & strip	...
A/SA-240	2205	S32205	95 (655)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Plate, sheet & strip	...
A/SA-240	...	S32304	87 (600)	10H	1	102	145	10.1	23Cr-4Ni-Mo-Cu-N	Plate, sheet & strip	...
A/SA-240	...	S32506	90 (620)	10H	1	102	145	10.2	25Cr-6Ni-Mo-N	Plate, sheet & strip	...
A/SA-240	S32550	S32550	110 (760)	10H	1	102	145	10.2	25Cr-5Ni-3Mo-2Cu	Plate, sheet & strip	...
A/SA-240	S32615	S32615	80 (550)	8	1	102	130	8.1	18Cr-20Ni-5.5Si	Plate, sheet & strip	...
A/SA-240	...	S32654	109 (750)	8	4	102	130	8.2	24Cr-22Ni-7Mo-3Mn	Plate, sheet & strip	...
A/SA-240	S32750	S32750	116 (800)	10H	1	102	145	10.2	25Cr-7Ni-4Mo-N	Plate, sheet & strip	...
A/SA-240	S32760	S32760	108 (745)	10H	1	102	145	10.2	25Cr-8Ni-3Mo-W-Cu-N	Plate, sheet & strip	...
A/SA-240	329	S32900	90 (620)	10H	1	102	145	10.2	26Cr-4Ni-Mo	Plate, sheet & strip	...
A/SA-240	S32906	S32906	109 (750)	10H	1	102	145	10.2	29Cr-6.5Ni-2Mo-N	Plate, sheet & strip	≥0.40 (10)
A/SA-240	S32906	S32906	116 (800)	10H	1	102	145	10.2	29Cr-6.5Ni-2Mo-N	Plate, sheet & strip	<0.40 (10)
A/SA-240	S32950	S32950	100 (690)	10H	1	102	145	10.2	26Cr-4Ni-Mo-N	Plate, sheet & strip	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	AWS P-No.	B2.2 BM Group	ISO 15608 Nominal Composition			
Ferrous (Cont'd)											
A/SA-240	S34565	S34565	115 (795)	8	4	102	130	8.3	24Cr-17Ni-6Mn-4.5Mo-N	Plate, sheet & strip	...
A/SA-240	347	S34700	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Plate, sheet & strip	...
A/SA-240	347H	S34709	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Plate, sheet & strip	...
A/SA-240	348	S34800	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Plate, sheet & strip	...
A/SA-240	348H	S34809	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Plate, sheet & strip	...
A/SA-240	XM-15	S38100	75 (515)	8	1	102	130	8.1	18Cr-18Ni-2Si	Plate, sheet & strip	...
A/SA-240	...	S38815	78 (540)	8	1	102	130	8.1	14Cr-16Ni-6Si-Cu-Mo	Plate, sheet & strip	...
A/SA-240	405	S40500	60 (415)	7	1	102	160	7.1	12Cr-Al	Plate, sheet & strip	...
A/SA-240	409	S40910	55 (380)	7	1	102	150	7.1	11Cr-Ti	Plate, sheet & strip	...
A/SA-240	409	S40920	55 (380)	7	1	102	150	7.1	11Cr-Ti	Plate, sheet & strip	...
A/SA-240	409	S40930	55 (380)	7	1	102	150	7.1	11Cr-Ti	Plate, sheet & strip	...
A/SA-240	410	S41000	65 (450)	6	1	102	150	7.2	13Cr	Plate, sheet & strip	...
A/SA-240	410S	S41008	60 (415)	7	1	102	150	7.2	13Cr	Plate, sheet & strip	...
A/SA-240	S41500	S41500	115 (795)	6	4	102	150	7.2	13Cr-4.5Ni-Mo	Plate, sheet & strip	...
A/SA-240	429	S42900	65 (450)	6	2	102	150	7.2	15Cr	Plate, sheet & strip	...
A/SA-240	430	S43000	65 (450)	7	2	102	150	7.1	17Cr	Plate, sheet & strip	...
A/SA-240	439	S43035	60 (415)	7	2	102	150	7.1	18Cr-Ti	Plate, sheet & strip	...
A/SA-240	S43932	S43932	60 (415)	7	2	102	150	7.1	18Cr-Ti-Cb	Plate, sheet & strip	...
A/SA-240	S43940	S43940	62 (425)	7	2	102	150	7.1	18Cr-Ti-Cb	Plate, sheet & strip	...
A/SA-240	...	S44100	60 (415)	7	2	102	150	7.1	18Cr-Cb-Ti	Plate, sheet & strip	...
A/SA-240	S44400	S44400	60 (415)	7	2	102	150	7.1	18Cr-2Mo	Plate, sheet & strip	...
A/SA-240	XM-33	S44626	68 (470)	10I	1	102	150	7.1	27Cr-1Mo-Ti	Plate, sheet & strip	...
A/SA-240	XM-27	S44627	65 (450)	10I	1	102	150	7.1	27Cr-1Mo	Plate, sheet & strip	...
A/SA-240	S44635	S44635	90 (620)	10I	1	102	150	7.1	25Cr-4Ni-4Mo-Ti	Plate, sheet & strip	...
A/SA-240	S44660	S44660	85 (585)	10K	1	102	150	7.1	26Cr-3Ni-3Mo	Plate, sheet & strip	...
A/SA-240	S44700	S44700	80 (550)	10J	1	102	150	7.1	29Cr-4Mo	Plate, sheet & strip	...
A/SA-240	S44800	S44800	80 (550)	10K	1	102	150	7.1	29Cr-4Mo-2Ni	Plate, sheet & strip	...
A/SA-240	...	S82012	94 (650)	10H	1	102	145	10.3	20Cr-1Ni-Mo-N	Plate, sheet & strip	>0.187 (5)
A/SA-240	...	S82012	102 (705)	10H	1	102	145	10.3	20Cr-1Ni-Mo-N	Plate, sheet & strip	≤0.187 (5)
A/SA-240	...	S82031	94 (650)	10H	1	102	145	10.3	21Cr-3Ni-1Mo-N	Plate, sheet & strip	>0.187 (5)
A/SA-240	...	S82031	102 (705)	10H	1	102	145	10.3	21Cr-3Ni-1Mo-N	Plate, sheet & strip	≤0.187 (5)
A/SA-240	...	S82441	99 (680)	10H	1	102	145	10.1	24Cr-4Ni-3Mn-1.5Mo-N	Plate, sheet & strip	≥0.40 (10)
A/SA-240	...	S82441	107 (740)	10H	1	102	145	10.1	24Cr-4Ni-3Mn-1.5Mo-N	Plate, sheet & strip	<0.40 (10)
A/SA-249	...	N08367	95 (655)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Welded tube	>0.187 (5)
A/SA-249	...	N08367	100 (690)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Welded tube	≤0.187 (5)
A/SA-249	...	N08904	71 (490)	45	...	111	420	8.2	44Fe-25Ni-21Cr-Mo	Welded tube	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A/SA-249	TP 201	S20100	95 (655)	8	3	102	130	8.3	17Cr-4Ni-6Mn	Welded tube	...
A/SA-249	TP 202	S20200	90 (620)	8	3	102	130	8.3	18Cr-5Ni-9Mn	Welded tube	...
A/SA-249	TP XM-19	S20910	100 (690)	8	3	102	130	8.3	22Cr-13Ni-5Mn	Welded tube	...
A/SA-249	TP XM-29	S24000	100 (690)	8	3	102	130	8.3	18Cr-3Ni-12Mn	Welded tube	...
A/SA-249	TP304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Welded tube	...
A/SA-249	TP304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Welded tube	...
A/SA-249	TP304H	S30409	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Welded tube	...
A/SA-249	TP304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N	Welded tube	...
A/SA-249	TP304LN	S30453	75 (515)	8	1	102	130	8.1	18Cr-8Ni-N	Welded tube	...
A/SA-249	S30815	S30815	87 (600)	8	2	102	130	8.2	21Cr-11Ni-N	Welded tube	...
A/SA-249	TP309S	S30908	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Welded tube	...
A/SA-249	TP309H	S30909	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Welded tube	...
A/SA-249	TP309Cb	S30940	75 (515)	8	2	102	130	8.2	23Cr-12Ni-Cb	Welded tube	...
A/SA-249	TP309HCb	S30941	75 (515)	8	2	102	130	8.2	23Cr-12Ni-Cb	Welded tube	...
A/SA-249	TP310S	S31008	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Welded tube	...
A/SA-249	TP310H	S31009	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Welded tube	...
A/SA-249	TP310Cb	S31040	75 (515)	8	2	102	130	8.2	25Cr-20Ni-Cb	Welded tube	...
A/SA-249	TP310HCb	S31041	75 (515)	8	2	102	130	8.2	25Cr-20Ni-Cb	Welded tube	...
A/SA-249	TP310MoLN	S31050	78 (540)	8	2	102	130	8.2	25Cr-22Ni-2Mo-N	Welded tube	>0.25 (6)
A/SA-249	TP310MoLN	S31050	84 (580)	8	2	102	130	8.2	25Cr-22Ni-2Mo-N	Welded tube	≤0.25 (6)
A/SA-249	S31254	S31254	95 (655)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Welded tube	>0.187 (5)
A/SA-249	S31254	S31254	98 (675)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Welded tube	≤0.187 (5)
A/SA-249	TP316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Welded tube	...
A/SA-249	TP316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Welded tube	...
A/SA-249	TP316H	S31609	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Welded tube	...
A/SA-249	TP316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Welded tube	...
A/SA-249	TP316LN	S31653	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Welded tube	...
A/SA-249	...	S31655	92 (635)	8	3	102	130	8.2	20.5Cr-8.8Ni-Mo-N	Welded tube	...
A/SA-249	TP317	S31700	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Welded tube	...
A/SA-249	TP317L	S31703	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Welded tube	...
A/SA-249	S31725	S31725	75 (515)	8	4	102	130	8.1	19Cr-15Ni-4Mo	Welded tube	...
A/SA-249	S31726	S31726	80 (550)	8	4	102	130	8.1	19Cr-15.5Ni-4Mo	Welded tube	...
A/SA-249	...	S32053	93 (640)	8	4	102	130	8.2	23Cr-25Ni-5.5Mo-N	Welded tube	...
A/SA-249	TP321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Welded tube	...
A/SA-249	TP321H	S32109	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Welded tube	...
A/SA-249	TP347	S34700	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Welded tube	...
A/SA-249	TP347H	S34709	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Welded tube	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	AWS P-No.	B2.2 BM Group	Nominal Composition			
Ferrous (Cont'd)											
A/SA-249	TP348	S34800	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Welded tube	...
A/SA-249	TP348H	S34809	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Welded tube	...
A/SA-249	TP XM-15	S38100	75 (515)	8	1	102	130	8.1	18Cr-18Ni-2Si	Welded tube	...
A/SA-249	...	S38815	78 (540)	8	1	102	130	8.1	14Cr-16Ni-6Si-Cu-Mo	Welded tube	...
A/SA-250	T1b	K11422	53 (365)	3	1	101	100	1.1	C-0.5Mo	E.R.W. tube	...
A/SA-250	T1	K11522	55 (380)	3	1	101	100	1.1	C-0.5Mo	E.R.W. tube	...
A/SA-250	T2	K11547	60 (415)	3	1	101	100	4.2	0.5Cr-0.5Mo	E.R.W. tube	...
A/SA-250	T12	K11562	60 (415)	4	1	102	110	5.1	1Cr-0.5Mo	E.R.W. tube	...
A/SA-250	T11	K11597	60 (415)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	E.R.W. tube	...
A/SA-250	T1a	K12023	60 (415)	3	1	101	100	1.1	C-0.5Mo	E.R.W. tube	...
A/SA-250	T22	K21590	60 (415)	5A	1	102	110	5.2	2.25Cr-1Mo	E.R.W. tube	...
A254	Cl. 1	K01001	42 (290)	101	100	NA	C	Cu brazed tube	...
A254	Cl. 2	K01001	42 (290)	101	100	NA	C	Cu brazed tube	...
A/SA-266	4	K03017	70 (485)	1	2	101	100	11.1	C-Mn-Si	Forgings	...
A/SA-266	1	K03506	60 (415)	1	1	101	100	11.1	C-Si	Forgings	...
A/SA-266	2	K03506	70 (485)	1	2	101	100	11.1	C-Si	Forgings	...
A/SA-266	3	K05001	75 (515)	1	2	101	100	11.2	C-Si	Forgings	...
A/SA-268	TP405	S40500	60 (415)	7	1	102	160	7.1	12Cr-Al	Smls. & welded tube	...
A/SA-268	S40800	S40800	55 (380)	7	1	102	150	7.1	12Cr-Ti	Smls. & welded tube	...
A/SA-268	TP409	S40900	55 (380)	7	1	102	150	7.1	11Cr-Ti	Smls. & welded tube	...
A/SA-268	TP410	S41000	60 (415)	6	1	102	150	7.2	13Cr	Smls. & welded tube	...
A/SA-268	S41500	S41500	115 (795)	6	4	102	150	7.2	13Cr-4.5Ni-Mo	Smls. & welded tube	...
A/SA-268	TP429	S42900	60 (415)	6	2	102	150	7.2	15Cr	Smls. & welded tube	...
A/SA-268	TP430	S43000	60 (415)	7	2	102	150	7.1	17Cr	Smls. & welded tube	...
A/SA-268	TP439	S43035	60 (415)	7	2	102	150	7.1	18Cr-Ti	Smls. & welded tube	...
A/SA-268	TP430Ti	S43036	60 (415)	7	2	102	160	7.1	18Cr-Ti	Smls. & welded tube	...
A/SA-268	18Cr-2Mo	S44400	60 (415)	7	2	102	150	7.1	18Cr-2Mo	Smls. & welded tube	...
A/SA-268	TP446-1	S44600	70 (485)	10I	1	102	150	7.1	27Cr	Smls. & welded tube	...
A/SA-268	TP446-2	S44600	65 (450)	10I	1	102	150	7.1	27Cr	Smls. & welded tube	...
A/SA-268	TPXM-33	S44626	68 (470)	10I	1	102	150	7.1	27Cr-1Mo-Ti	Smls. & welded tube	...
A/SA-268	TPXM-27	S44627	65 (450)	10I	1	102	150	7.1	27Cr-1Mo	Smls. & welded tube	...
A/SA-268	25-4-4	S44635	90 (620)	10I	1	102	150	7.1	25Cr-4Ni-4Mo-Ti	Smls. & welded tube	...
A/SA-268	26-3-3	S44660	85 (585)	10K	1	102	150	7.1	26Cr-3Ni-3Mo	Smls. & welded tube	...
A/SA-268	29-4	S44700	80 (550)	10J	1	102	150	7.1	29Cr-4Mo	Smls. & welded tube	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)		
				P-No.	Group No.	AWS B2.2 BM	ISO 15608 Group						
							P-No.	B2.2 BM	Nominal Composition				
Ferrous (Cont'd)													
A/SA-268	S44735	S44735	75 (515)	10J	1	102	150	7.1	29Cr-4Mo-Ti	Smls. & welded tube	...		
A/SA-268	29-4-2	S44800	80 (550)	10K	1	102	150	7.1	29Cr-4Mo-2Ni	Smls. & welded tube	...		
A269	TP304	S30400	...	8	1	102	130	8.1	18Cr-8Ni	Smls. & welded tube	...		
A269	TP304L	S30403	...	8	1	102	130	8.1	18Cr-8Ni	Smls. & welded tube	...		
A269	TP316	S31600	...	8	1	102	130	8.1	16Cr-12Ni-2Mo	Smls. & welded tube	...		
A269	TP316L	S31603	...	8	1	102	130	8.1	16Cr-12Ni-2Mo	Smls. & welded tube	...		
A/SA-276	304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Bars & shapes	...		
A/SA-276	304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Bars & shapes	...		
A/SA-276	314	S31400	...	8	2	102	130	8.2	24Cr-20Ni-Si	Bars & shapes	...		
A/SA-276	316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Bars & shapes	...		
A/SA-276	316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Bars & shapes	...		
A/SA-276	410	S41000	70 (485)	6	1	102	150	7.2	13Cr	Bars & shapes	...		
A/SA-283	A	K01400	45 (310)	1	1	101	100	1.1	C	Plate	...		
A/SA-283	B	K01702	50 (345)	1	1	101	100	1.1	C	Plate	...		
A/SA-283	C	K02401	55 (380)	1	1	101	100	1.1	C	Plate	...		
A/SA-283	D	K02702	60 (415)	1	1	101	100	1.1	C	Plate	...		
A/SA-285	A	K01700	45 (310)	1	1	101	100	1.1	C	Plate	...		
A/SA-285	B	K02200	50 (345)	1	1	101	100	1.1	C	Plate	...		
A/SA-285	C	K02801	55 (380)	1	1	101	100	11.1	C	Plate	...		
A/SA-299	A	K02803	75 (515)	1	2	101	100	11.1	C-Mn-Si	Plate	...		
A/SA-299	B	K02803	80 (550)	1	3	101	100	11.1	C-Mn-Si	Plate	...		
A/SA-302	A	K12021	75 (515)	3	2	101	100	1.1	Mn-0.5Mo	Plate	...		
A/SA-302	B	K12022	80 (550)	3	3	101	100	1.2	Mn-0.5Mo	Plate	...		
A/SA-302	C	K12039	80 (550)	3	3	101	100	...	Mn-0.5Mo-0.5Ni	Plate	...		
A/SA-302	D	K12054	80 (550)	3	3	101	100	...	Mn-0.5Mo-0.75Ni	Plate	...		
A/SA-312	N08367	N08367	95 (655)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Smls. & welded pipe	> 0.187 (5)		
A/SA-312	N08367	N08367	100 (690)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Smls. & welded pipe	≤ 0.187 (5)		
A/SA-312	...	N08904	71 (490)	45	...	111	420	8.2	44Fe-25Ni-21Cr-Mo	Smls. & welded pipe	...		
A/SA-312	TPXM-19	S20910	100 (690)	8	3	102	130	8.3	22Cr-13Ni-5Mn	Smls. & welded pipe	...		
A/SA-312	TPXM-11	S21904	90 (620)	8	3	102	130	8.3	21Cr-6Ni-9Mn	Smls. & welded pipe	...		
A/SA-312	TPXM-29	S24000	100 (690)	8	3	102	130	8.3	18Cr-3Ni-12Mn	Smls. & welded pipe	...		
A/SA-312	TP304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Smls. & welded pipe	...		
A/SA-312	TP304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Smls. & welded pipe	...		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A/SA-312	TP304H	S30409	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Smls. & welded pipe	...
A/SA-312	TP304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N	Smls. & welded pipe	...
A/SA-312	TP304LN	S30453	75 (515)	8	1	102	130	8.1	18Cr-8Ni-N	Smls. & welded pipe	...
A/SA-312	S30600	S30600	78 (540)	8	1	102	130	8.1	18Cr-15Ni-4Si	Smls. & welded pipe	...
A/SA-312	S30815	S30815	87 (600)	8	2	102	130	8.2	21Cr-11Ni-N	Smls. & welded pipe	...
A/SA-312	TP309S	S30908	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Smls. & welded pipe	...
A/SA-312	TP309H	S30909	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Smls. & welded pipe	...
A/SA-312	TP309Cb	S30940	75 (515)	8	2	102	130	8.2	23Cr-12Ni-Cb	Smls. & welded pipe	...
A/SA-312	TP309HCb	S30941	75 (515)	8	2	102	130	8.2	23Cr-12Ni-Cb	Smls. & welded pipe	...
A/SA-312	TP310S	S31008	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Smls. & welded pipe	...
A/SA-312	TP310H	S31009	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Smls. & welded pipe	...
A/SA-312	TP310Cb	S31040	75 (515)	8	2	102	130	8.2	25Cr-20Ni-Cb	Smls. & welded pipe	...
A/SA-312	TP310HCb	S31041	75 (515)	8	2	102	130	8.2	25Cr-20Ni-Cb	Smls. & welded pipe	...
A/SA-312	TP310MoLN	S31050	78 (540)	8	2	102	130	8.2	25Cr-22Ni-2Mo-N	Smls. & welded pipe	>0.25 (6)
A/SA-312	TP310MoLN	S31050	84 (580)	8	2	102	130	8.2	25Cr-22Ni-2Mo-N	Smls. & welded pipe	≤0.25 (6)
A/SA-312	S31254	S31254	95 (655)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Smls. & welded pipe	>0.187 (5)
A/SA-312	S31254	S31254	98 (675)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Smls. & welded pipe	≤0.187 (5)
A/SA-312	TP316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Smls. & welded pipe	...
A/SA-312	TP316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Smls. & welded pipe	...
A/SA-312	TP316H	S31609	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Smls. & welded pipe	...
A/SA-312	TP316Ti	S31635	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-Ti	Smls. & welded pipe	...
A/SA-312	TP316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Smls. & welded pipe	...
A/SA-312	TP316LN	S31653	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Smls. & welded pipe	...
A/SA-312	TP317	S31700	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Smls. & welded pipe	...
A/SA-312	TP317L	S31703	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Smls. & welded pipe	...
A/SA-312	S31725	S31725	75 (515)	8	4	102	130	8.1	19Cr-15Ni-4Mo	Smls. & welded pipe	...
A/SA-312	S31726	S31726	80 (550)	8	4	102	130	8.1	19Cr-15.5Ni-4Mo	Smls. & welded pipe	...
A/SA-312	...	S32053	93 (640)	8	4	102	130	8.2	23Cr-25Ni-5.5Mo-N	Smls. & welded pipe	...
A/SA-312	TP321	S32100	70 (485)	8	1	102	140	8.1	18Cr-10Ni-Ti	Smls. pipe	>0.375 (10) NPS
A/SA-312	TP321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Smls. pipe	≤0.375 (10) NPS
A/SA-312	TP321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Welded pipe	...
A/SA-312	TP321H	S32109	70 (485)	8	1	102	140	8.1	18Cr-10Ni-Ti	Smls. pipe	>0.375 (10) NPS
A/SA-312	TP321H	S32109	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Smls. pipe	≤0.375 (10) NPS
A/SA-312	TP321H	S32109	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Welded pipe	...
A/SA-312	S32615	S32615	80 (550)	8	1	102	130	8.1	18Cr-20Ni-5.5Si	Smls. & welded pipe	...
A/SA-312	S34565	S34565	115 (795)	8	4	102	130	8.3	24Cr-17Ni-6Mn-4.5Mo-N	Smls. & welded pipe	...
A/SA-312	TP347	S34700	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Smls. & welded pipe	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)		
				P-No.	Group No.	AWS P-No.	ISO 15608 Group		Nominal Composition				
							B2.2 BM	Group					
Ferrous (Cont'd)													
A/SA-312	TP347H	S34709	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Smls. & welded pipe	...		
A/SA-312	TP347LN	S34751	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb-N	Smls. & welded pipe	...		
A/SA-312	TP348	S34800	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Smls. & welded pipe	...		
A/SA-312	TP348H	S34809	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Smls. & welded pipe	...		
A/SA-312	TPXM-15	S38100	75 (515)	8	1	102	130	8.1	18Cr-18Ni-2Si	Smls. & welded pipe	...		
A/SA-333	10	...	80 (550)	1	3	101	100	11.1	C-Mn-Si	Smls. & welded pipe	...		
A/SA-333	6	K03006	60 (415)	1	1	101	100	11.1	C-Mn-Si	Smls. & welded pipe	...		
A/SA-333	1	K03008	55 (380)	1	1	101	100	11.1	C-Mn	Smls. & welded pipe	...		
A/SA-333	4	K11267	60 (415)	4	2	102	120	4.1	0.75Cr-0.75Ni-Cu-Al	Smls. & welded pipe	...		
A/SA-333	7	K21903	65 (450)	9A	1	101	100	9.1	2.5Ni	Smls. & welded pipe	...		
A/SA-333	9	K22035	63 (435)	9A	1	101	100	9.1	2Ni-1Cu	Smls. & welded pipe	...		
A/SA-333	3	K31918	65 (450)	9B	1	101	100	9.2	3.5Ni	Smls. & welded pipe	...		
A/SA-333	8	K81340	100 (690)	11A	1	101	100	9.3	9Ni	Smls. & welded pipe	...		
A/SA-334	6	K03006	60 (415)	1	1	101	100	11.1	C-Mn-Si	Welded tube	...		
A/SA-334	1	K03008	55 (380)	1	1	101	100	11.1	C-Mn	Welded tube	...		
A/SA-334	7	K21903	65 (450)	9A	1	101	100	9.1	2.5Ni	Welded tube	...		
A/SA-334	9	K22035	63 (435)	9A	1	101	100	9.1	2Ni-1Cu	Welded tube	...		
A/SA-334	3	K31918	65 (450)	9B	1	101	100	9.2	3.5Ni	Welded tube	...		
A/SA-334	8	K81340	100 (690)	11A	1	101	100	9.3	9Ni	Welded tube	...		
A/SA-335	P1	K11522	55 (380)	3	1	101	100	1.1	C-0.5Mo	Smls. pipe	...		
A/SA-335	P2	K11547	55 (380)	3	1	101	100	4.2	0.5Cr-0.5Mo	Smls. pipe	...		
A/SA-335	P12	K11562	60 (415)	4	1	102	110	5.1	1Cr-0.5Mo	Smls. pipe	...		
A/SA-335	P15	K11578	60 (415)	3	1	101	100	...	1.5Si-0.5Mo	Smls. pipe	...		
A/SA-335	P11	K11597	60 (415)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Smls. pipe	...		
A/SA-335	P22	K21590	60 (415)	5A	1	102	110	5.2	2.25Cr-1Mo	Smls. pipe	...		
A/SA-335	P21	K31545	60 (415)	5A	1	102	110	5.2	3Cr-1Mo	Smls. pipe	...		
A/SA-335	P5c	K41245	60 (415)	5B	1	102	120	5.3	5Cr-0.5Mo-Ti	Smls. pipe	...		
A/SA-335	P5	K41545	60 (415)	5B	1	102	110	5.3	5Cr-0.5Mo	Smls. pipe	...		
A/SA-335	P5b	K51545	60 (415)	5B	1	102	110	5.3	5Cr-0.5Mo-Si	Smls. pipe	...		
A/SA-335	P91	K90901	85 (585)	15E	1	102	110	6.4	9Cr-1Mo-V	Smls. pipe	...		
A/SA-335	P9	K90941	60 (415)	5B	1	102	110	5.4	9Cr-1Mo	Smls. pipe	...		
A/SA-335	P92	K92460	90 (620)	15E	1	102	110	6.4	9Cr-2W	Smls. pipe	...		
A/SA-336	F12	K11564	70 (485)	4	1	102	110	5.1	1Cr-0.5Mo	Forgings	...		
A/SA-336	F11, Cl. 2	K11572	70 (485)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Forgings	...		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	AWS P-No.	B2.2 BM Group	ISO 15608 Nominal Composition			
Ferrous (Cont'd)											
A/SA-336	F11, Cl. 3	K11572	75 (515)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Forgings	...
A/SA-336	F11, Cl. 1	K11597	60 (415)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Forgings	...
A/SA-336	F1	K12520	70 (485)	3	2	101	100	1.1	C-0.5Mo	Forgings	...
A/SA-336	F22, Cl. 1	K21590	60 (415)	5A	1	102	110	5.2	2.25Cr-1Mo	Forgings	...
A/SA-336	F22, Cl. 3	K21590	75 (515)	5A	1	102	110	5.2	2.25Cr-1Mo	Forgings	...
A/SA-336	F3VCb	K31390	85 (585)	5C	1	102	110	6.2	3Cr-1Mo-0.25V-Cb-Ca	Forgings	...
A/SA-336	F21, Cl. 1	K31545	60 (415)	5A	1	102	110	5.2	3Cr-1Mo	Forgings	...
A/SA-336	F21, Cl. 3	K31545	75 (515)	5A	1	102	110	5.2	3Cr-1Mo	Forgings	...
A/SA-336	F3V	K31830	85 (585)	5C	1	102	120	6.2	3Cr-1Mo-V-Ti-B	Forgings	...
A/SA-336	F22V	K31835	85 (585)	5C	1	102	110	6.2	2.25Cr-1Mo-V	Forgings	...
A/SA-336	F5	K41545	60 (415)	5B	1	102	110	5.3	5Cr-0.5Mo	Forgings	...
A/SA-336	F5A	K42544	80 (550)	5B	1	102	110	5.3	5Cr-0.5Mo	Forgings	...
A/SA-336	F91	K90901	90 (620)	15E	1	102	110	6.4	9Cr-1Mo-V	Forgings	...
A/SA-336	F9	K90941	85 (585)	5B	1	102	110	5.4	9Cr-1Mo	Forgings	...
A/SA-336	F92	K92460	90 (620)	15E	1	102	110	6.4	9Cr-2W	Forgings	...
A/SA-336	F6	S41000	85 (585)	6	3	102	150	7.2	13Cr	Forgings	...
A/SA-350	LF1	K03009	60 (415)	1	1	101	100	11.1	C-Mn-Si	Forgings	...
A/SA-350	LF2	K03011	70 (485)	1	2	101	100	11.1	C-Mn-Si	Forgings	...
A/SA-350	LF6, Cl. 2	K12202	75 (515)	1	3	101	100	4.1	C-Mn-Si-V	Forgings	...
A/SA-350	LF5 Cl. 1	K13050	60 (415)	9A	1	101	100	9.1	1.5Ni	Forgings	...
A/SA-350	LF5 Cl. 2	K13050	70 (485)	9A	1	101	100	9.1	1.5Ni	Forgings	...
A/SA-350	LF9	K22036	63 (435)	9A	1	101	100	9.1	2Ni-1Cu	Forgings	...
A/SA-350	LF3	K32025	70 (485)	9B	1	101	100	9.2	3.5Ni	Forgings	...
A/SA-351	CF3	J92500	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Castings	...
A/SA-351	CF3A	J92500	77 (530)	8	1	102	130	8.1	18Cr-8Ni	Castings	...
A/SA-351	CF10	J92590	70 (485)	8	1	102	130	8.1	19Cr-9Ni-0.5Mo	Castings	...
A/SA-351	CF8	J92600	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Castings	...
A/SA-351	CF8A	J92600	77 (530)	8	1	102	130	8.1	18Cr-8Ni	Castings	...
A/SA-351	CF8C	J92710	70 (485)	8	1	102	130	8.1	18Cr-10Ni-Cb	Castings	...
A/SA-351	CF3M	J92800	70 (485)	8	1	102	130	8.1	18Cr-12Ni-2Mo	Castings	...
A/SA-351	CE20N	J92802	80 (550)	8	2	102	130	8.2	25Cr-8Ni-N	Castings	...
A/SA-351	CF8M	J92900	70 (485)	8	1	102	130	8.1	18Cr-12Ni-2Mo	Castings	...
A/SA-351	CF10M	J92901	70 (485)	8	1	102	130	8.1	19Cr-9Ni-2Mo	Castings	...
A/SA-351	CF10MC	J92971	70 (485)	8	1	102	130	8.1	16Cr-14Ni-2Mo	Castings	...
A/SA-351	CG8M	J93000	75 (515)	8	1	102	130	8.1	19Cr-10Ni-3Mo	Castings	...
A/SA-351	CK3MCuN	J93254	80 (550)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Castings	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A/SA-351	CD3MWCuN	J93380	100 (690)	10H	1	102	145	10.2	25Cr-8Ni-3Mo-W-Cu-N	Castings	...
A/SA-351	CH8	J93400	65 (450)	8	2	102	130	8.2	25Cr-12Ni	Castings	...
A/SA-351	CH10	J93401	70 (485)	8	2	102	130	8.2	25Cr-12Ni	Castings	...
A/SA-351	CH20	J93402	70 (485)	8	2	102	130	8.2	25Cr-12Ni	Castings	...
A/SA-351	CG6MMN	J93790	85 (585)	8	3	102	130	8.3	22Cr-12Ni-5Mn	Castings	...
A/SA-351	CK20	J94202	65 (450)	8	2	102	130	8.2	25Cr-20Ni	Castings	...
A/SA-351	HK30	J94203	65 (450)	8	2	102	130	8.2	25Cr-20Ni-0.5Mo	Castings	...
A/SA-351	HK40	J94204	62 (425)	8	2	102	130	8.2	25Cr-20Ni-0.5Mo	Castings	...
A/SA-351	CN3MN	J94651	80 (550)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-Cu-N	Castings	...
A/SA-351	CN7M	N08007	62 (425)	45	...	111	420	8.2	28Ni-19Cr-Cu-Mo	Castings	...
A/SA-351	CT15C	N08151	63 (435)	45	...	111	420	45	32Ni-45Fe-20Cr-Cb	Castings	...
A/SA-351	HT30	N08603	65 (450)	45	...	111	420	45	35Ni-15Cr-0.5Mo	Castings	...
A/SA-352	LCA	J02504	60 (415)	1	1	101	100	11.1	C-Si	Castings	...
A/SA-352	LCC	J02505	70 (485)	1	2	101	100	11.1	C-Mn-Si	Castings	...
A/SA-352	LCB	J03003	65 (450)	1	1	101	100	1.1	C-Si	Castings	...
A/SA-352	LC1	J12522	65 (450)	3	1	101	100	1.1	C-0.5Mo	Castings	...
A/SA-352	LC2	J22500	70 (485)	9A	1	101	100	9.1	2.5Ni	Castings	...
A/SA-352	LC3	J31550	70 (485)	9B	1	101	100	9.3	3.5Ni	Castings	...
A/SA-352	LC4	J41500	70 (485)	9C	1	101	100	9.3	4.5Ni	Castings	...
A/SA-352	LC2-1	J42215	105 (725)	11A	5	102	110	9.2	3Ni-1.5Cr-0.5Mo	Castings	...
A/SA-352	CA6NM	J91540	110 (760)	6	4	102	150	7.2	13Cr-4Ni	Castings	...
A/SA-353	...	K81340	100 (690)	11A	1	101	100	9.3	9Ni	Plate	...
A356	1	J03502	70 (485)	1	2	101	100	11.1	C-Si	Castings	...
A356	8	J11697	80 (550)	4	1	102	110	6.2	1Cr-1Mo-V	Castings	...
A356	6	J12073	70 (485)	4	1	102	110	5.1	1.25Cr-0.5Mo	Castings	...
A356	2	J12523	65 (450)	3	1	101	100	1.1	C-0.5Mo	Castings	...
A356	9	J21610	85 (585)	4	1	102	110	6.2	1Cr-1Mo-V	Castings	...
A356	10	J22090	85 (585)	5A	1	102	110	5.2	2.25Cr-1Mo	Castings	...
A356	12A	J84090	85 (585)	15E	1	102	110	6.4	9Cr-1Mo-V	Castings	...
A/SA-358	N08367	N08367	95 (655)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Fusion welded pipe	≥0.187 (5)
A/SA-358	N08367	N08367	100 (690)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Fusion welded pipe	<0.187 (5)
A/SA-358	XM-19	S20910	100 (690)	8	3	102	130	8.3	22Cr-13Ni-5Mn	Fusion welded pipe	...
A/SA-358	XM-29	S24000	100 (690)	8	3	102	130	8.3	18Cr-3Ni-12Mn	Fusion welded pipe	...
A/SA-358	304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Fusion welded pipe	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	AWS P-No.	B2.2 BM Group	ISO 15608 Nominal Composition			
Ferrous (Cont'd)											
A/SA-358	304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Fusion welded pipe	...
A/SA-358	304H	S30409	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Fusion welded pipe	...
A/SA-358	304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N	Fusion welded pipe	...
A/SA-358	304LN	S30453	75 (515)	8	1	102	130	8.1	18Cr-8Ni-N	Fusion welded pipe	...
A/SA-358	S30815	S30815	87 (600)	8	2	102	130	8.2	21Cr-11Ni-N	Fusion welded pipe	...
A/SA-358	309S	S30908	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Fusion welded pipe	...
A/SA-358	309Cb	S30940	75 (515)	8	2	102	130	8.2	23Cr-12Ni-Cb	Fusion welded pipe	...
A/SA-358	310S	S31008	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Fusion welded pipe	...
A/SA-358	310Cb	S31040	75 (515)	8	2	102	130	8.2	25Cr-20Ni-Cb	Fusion welded pipe	...
A/SA-358	S31254	S31254	95 (655)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Fusion welded pipe	≥ 0.187 (5)
A/SA-358	S31254	S31254	100 (690)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Fusion welded pipe	<0.187 (5)
A/SA-358	...	S31266	109 (750)	45	...	102	420	8.2	24Cr-22Ni-6Mo-3Mn-Cu-W-N	Fusion welded pipe	...
A/SA-358	316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Fusion welded pipe	...
A/SA-358	316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Fusion welded pipe	...
A/SA-358	316H	S31609	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Fusion welded pipe	...
A/SA-358	316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Fusion welded pipe	...
A/SA-358	316LN	S31653	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Fusion welded pipe	...
A/SA-358	...	S31655	92 (635)	8	3	102	130	8.2	20.5Cr-8.8Ni-Mo-N	Fusion welded pipe	...
A/SA-358	S31725	S31725	75 (515)	8	4	102	130	8.1	19Cr-15Ni-4Mo	Fusion welded pipe	...
A/SA-358	S31726	S31726	80 (550)	8	4	102	130	8.1	19Cr-15.5Ni-4Mo	Fusion welded pipe	...
A/SA-358	...	S32053	93 (640)	8	4	102	130	8.2	23Cr-25Ni-5.5Mo-N	Fusion welded pipe	...
A/SA-358	321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Fusion welded pipe	...
A/SA-358	347	S34700	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Fusion welded pipe	...
A/SA-358	348	S34800	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Fusion welded pipe	...
A/SA-369	FPA	K02501	48 (330)	1	1	101	100	1.1	C-Si	Forged pipe	...
A/SA-369	FPB	K03006	60 (415)	1	1	101	100	1.1	C-Mn-Si	Forged pipe	...
A/SA-369	FP1	K11522	55 (380)	3	1	101	100	1.1	C-0.5Mo	Forged pipe	...
A/SA-369	FP2	K11547	55 (380)	3	1	101	100	4.2	0.5Cr-0.5Mo	Forged pipe	...
A/SA-369	FP12	K11562	60 (415)	4	1	102	110	5.1	1Cr-0.5Mo	Forged pipe	...
A/SA-369	FP11	K11597	60 (415)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Forged pipe	...
A/SA-369	FP22	K21590	60 (415)	5A	1	102	110	5.2	2.25Cr-1Mo	Forged pipe	...
A/SA-369	FP21	K31545	60 (415)	5A	1	102	110	5.2	3Cr-1Mo	Forged pipe	...
A/SA-369	FP5	K41545	60 (415)	5B	1	102	110	5.3	5Cr-0.5Mo	Forged pipe	...
A/SA-369	FP91	K90901	85 (585)	15E	1	102	110	6.4	9Cr-1Mo-V	Forged pipe	...
A/SA-369	FP9	K90941	60 (415)	5B	1	102	110	5.4	9Cr-1Mo	Forged pipe	...
A/SA-369	FP92	K92460	90 (620)	15E	1	102	110	6.4	9Cr-2W	Forged pipe	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing					Typical Product Form	Nominal Thickness Limits, in. (mm)		
				P-No.	Group No.	AWS P-No.	ISO 15608 Group		Nominal Composition					
							B2.2 BM							
Ferrous (Cont'd)														
A/SA-372	A	K03002	60 (415)	1	1	101	100	11.1	C-Si			Forgings	...	
A/SA-372	B	K04001	75 (515)	1	2	101	100	11.1	C-Mn-Si			Forgings	...	
A/SA-376	16-8-2H	S16800	75 (515)	8	1	102	130	8.1	16Cr-8Ni-2Mo			Smls. pipe	...	
A/SA-376	TP304	S30400	70 (485)	8	1	102	130	8.1	18Cr-8Ni			Smls. pipe	≥0.812 (21)	
A/SA-376	TP304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni			Smls. pipe	<0.812 (21)	
A/SA-376	TP304H	S30409	75 (515)	8	1	102	130	8.1	18Cr-8Ni			Smls. pipe	...	
A/SA-376	TP304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N			Smls. pipe	...	
A/SA-376	TP304LN	S30453	75 (515)	8	1	102	130	8.1	18Cr-8Ni-N			Smls. pipe	...	
A/SA-376	TP316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo			Smls. pipe	...	
A/SA-376	TP316H	S31609	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo			Smls. pipe	...	
A/SA-376	TP316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N			Smls. pipe	...	
A/SA-376	TP316LN	S31653	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N			Smls. pipe	...	
A/SA-376	S31725	S31725	75 (515)	8	4	102	130	8.1	19Cr-15Ni-4Mo			Smls. pipe	...	
A/SA-376	S31726	S31726	80 (550)	8	4	102	130	8.1	19Cr-15.5Ni-4Mo			Smls. pipe	...	
A/SA-376	TP321	S32100	70 (485)	8	1	102	140	8.1	18Cr-10Ni-Ti			Smls. pipe	>0.375 (10)	
A/SA-376	TP321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti			Smls. pipe	≤0.375 (10)	
A/SA-376	TP321H	S32109	70 (485)	8	1	102	140	8.1	18Cr-10Ni-Ti			Smls. pipe	>0.375 (10)	
A/SA-376	TP321H	S32109	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti			Smls. pipe	≤0.375 (10)	
A/SA-376	S34565	S34565	115 (795)	8	4	102	130	8.3	24Cr-17Ni-6Mn-4.5Mo-N			Smls. pipe	...	
A/SA-376	TP347	S34700	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb			Smls. pipe	...	
A/SA-376	TP347H	S34709	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb			Smls. pipe	...	
A/SA-376	TP348	S34800	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb			Smls. pipe	...	
A381	Y35	...	60 (415)	1	1	101	100	11.1	C			Welded pipe	...	
A381	Y42	...	60 (415)	1	1	101	100	11.1	C			Welded pipe	...	
A381	Y46	...	63 (435)	1	1	101	100	11.1	C			Welded pipe	...	
A381	Y48	...	62 (425)	1	1	101	100	11.1	C			Welded pipe	...	
A381	Y50	...	64 (440)	1	1	101	100	11.1	C			Welded pipe	...	
A381	Y52	...	66 (455)	1	2	101	100	11.1	C			Welded pipe	...	
A381	Y56	...	71 (490)	1	2	101	100	11.1	C			Welded pipe	...	
A381	Y60	...	75 (515)	1	2	101	100	11.1	C			Welded pipe	...	
A/SA-387	12, Cl. 1	K11757	55 (380)	4	1	102	110	5.1	1Cr-0.5Mo			Plate	...	
A/SA-387	12, Cl. 2	K11757	65 (450)	4	1	102	110	5.1	1Cr-0.5Mo			Plate	...	
A/SA-387	11, Cl. 1	K11789	60 (415)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si			Plate	...	
A/SA-387	11, Cl. 2	K11789	75 (515)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si			Plate	...	

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	AWS P-No.	B2.2 BM Group	Nominal Composition			
Ferrous (Cont'd)											
A/SA-387	2, Cl. 1	K12143	55 (380)	3	1	101	100	4.2	0.5Cr-0.5Mo	Plate	...
A/SA-387	2, Cl. 2	K12143	70 (485)	3	2	101	100	4.2	0.5Cr-0.5Mo	Plate	...
A/SA-387	22, Cl. 1	K21590	60 (415)	5A	1	102	110	5.2	2.25Cr-1Mo	Plate	...
A/SA-387	22, Cl. 2	K21590	75 (515)	5A	1	102	110	5.2	2.25Cr-1Mo	Plate	...
A/SA-387	21, Cl. 1	K31545	60 (415)	5A	1	102	110	5.2	3Cr-1Mo	Plate	...
A/SA-387	21, Cl. 2	K31545	75 (515)	5A	1	102	110	5.2	3Cr-1Mo	Plate	...
A/SA-387	5, Cl. 1	K41545	60 (415)	5B	1	102	110	5.3	5Cr-0.5Mo	Plate	...
A/SA-387	5, Cl. 2	K41545	75 (515)	5B	1	102	110	5.3	5Cr-0.5Mo	Plate	...
A/SA-387	91, Cl. 2	K90901	85 (585)	15E	1	102	110	6.4	9Cr-1Mo-V	Plate	...
A/SA-387	9, Cl. 1	K90941	60 (415)	5B	1	102	110	5.4	9Cr-1Mo	Plate	...
A/SA-387	9, Cl. 2	K90941	75 (515)	5B	1	102	110	5.4	9Cr-1Mo	Plate	...
A403	...	N08367	95 (655)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Wrought piping fittings	...
A/SA-403	...	N08904	71 (490)	45	...	111	420	8.2	44Fe-25Ni-21Cr-Mo	Wrought piping fittings	...
A/SA-403	WPXM-19	S20910	100 (690)	8	3	102	130	8.3	22Cr-13Ni-5Mn	Wrought piping fittings	...
A/SA-403	WP304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Wrought piping fittings	...
A/SA-403	WP304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Wrought piping fittings	...
A/SA-403	WP304H	S30409	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Wrought piping fittings	...
A/SA-403	WP304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N	Wrought piping fittings	...
A/SA-403	WP304LN	S30453	75 (515)	8	1	102	130	8.1	18Cr-8Ni-N	Wrought piping fittings	...
A/SA-403	WP309	S30900	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Wrought piping fittings	...
A/SA-403	WP310S	S31008	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Wrought piping fittings	...
A/SA-403	...	S31254	94 (650)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Wrought piping fittings	...
A/SA-403	WP316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Wrought piping fittings	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)		
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group					
								Nominal Composition					
Ferrous (Cont'd)													
A/SA-403	WP316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Wrought piping fittings	...		
A/SA-403	WP316H	S31609	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Wrought piping fittings	...		
A/SA-403	WP316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Wrought piping fittings	...		
A/SA-403	WP316LN	S31653	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Wrought piping fittings	...		
A/SA-403	WP317	S31700	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Wrought piping fittings	...		
A/SA-403	WP317L	S31703	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Wrought piping fittings	...		
A/SA-403	WP S31726	S31726	80 (550)	8	4	102	130	8.1	19Cr-15.5Ni-4Mo	Wrought piping fittings	...		
A/SA-403	...	S32053	93 (640)	8	4	102	130	8.2	23Cr-25Ni-5.5Mo-N	Wrought piping fittings	...		
A/SA-403	WP321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Wrought piping fittings	...		
A/SA-403	WP321H	S32109	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Wrought piping fittings	...		
A/SA-403	S34565	S34565	115 (795)	8	4	102	130	8.3	24Cr-17Ni-6Mn-4.5Mo-N	Wrought piping fittings	...		
A/SA-403	WP347	S34700	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Wrought piping fittings	...		
A/SA-403	WP347H	S34709	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Wrought piping fittings	...		
A/SA-403	WP348	S34800	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Wrought piping fittings	...		
A/SA-403	WP348H	S34809	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Wrought piping fittings	...		
A/SA-403	WP S38815	S38815	78 (540)	8	1	102	130	8.1	14Cr-16Ni-6Si-Cu-Mo	Wrought piping fittings	...		
A/SA-409	TP304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Welded pipe	...		
A/SA-409	TP304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Welded pipe	...		
A/SA-409	S30815	S30815	87 (600)	8	2	102	130	8.2	21Cr-11Ni-N	Welded pipe	...		
A/SA-409	TP309S	S30908	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Welded pipe	...		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	AWS P-No.	B2.2 BM Group	ISO 15608 Nominal Composition			
Ferrous (Cont'd)											
A/SA-409	TP309Cb	S30940	75 (515)	8	2	102	130	8.2	23Cr-12Ni-Cb	Welded pipe	...
A/SA-409	TP310S	S31008	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Welded pipe	...
A/SA-409	TP310Cb	S31040	75 (515)	8	2	102	130	8.2	25Cr-20Ni-Cb	Welded pipe	...
A/SA-409	S31254	S31254	94 (650)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Welded pipe	...
A/SA-409	TP316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Welded pipe	...
A/SA-409	TP316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Welded pipe	...
A/SA-409	TP317	S31700	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Welded pipe	...
A/SA-409	S31725	S31725	75 (515)	8	4	102	130	8.1	19Cr-15Ni-4Mo	Welded pipe	...
A/SA-409	S31726	S31726	80 (550)	8	4	102	130	8.1	19Cr-15.5Ni-4Mo	Welded pipe	...
A/SA-409	...	S32053	93 (640)	8	4	102	130	8.2	23Cr-25Ni-5.5Mo-N	Welded pipe	...
A/SA-409	TP321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Welded pipe	...
A/SA-409	S34565	S34565	115 (795)	8	4	102	130	8.3	24Cr-17Ni-6Mn-4.5Mo-N	Welded pipe	...
A/SA-409	TP347	S34700	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Welded pipe	...
A/SA-409	TP348	S34800	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Welded pipe	...
A/SA-414	A	K01501	45 (310)	1	1	101	100	1.1	C	Sheet	...
A/SA-414	B	K02201	50 (345)	1	1	101	100	1.1	C	Sheet	...
A/SA-414	C	K02503	55 (380)	1	1	101	100	1.1	C	Sheet	...
A/SA-414	D	K02505	60 (415)	1	1	101	100	1.1	C-Mn	Sheet	...
A/SA-414	E	K02704	65 (450)	1	1	101	100	11.1	C-Mn	Sheet	...
A/SA-414	F	K03102	70 (485)	1	2	101	100	11.1	C-Mn	Sheet	...
A/SA-414	G	K03103	75 (515)	1	2	101	100	11.1	C-Mn	Sheet	...
A/SA-420	WPL6	K03006	60 (415)	1	1	101	100	11.1	C-Mn-Si	Piping fittings	...
A/SA-420	WPL9	K22035	63 (435)	9A	1	101	100	9.1	2Ni-1Cu	Piping fittings	...
A/SA-420	WPL3	K31918	65 (450)	9B	1	101	100	9.2	3.5Ni	Piping fittings	...
A/SA-420	WPL8	K81340	100 (690)	11A	1	101	100	9.3	9Ni	Piping fittings	...
A/SA-423	1	K11535	60 (415)	4	2	102	110	5.1	0.75Cr-0.5Ni-Cu	Smls. & welded tube	...
A/SA-423	2	K11540	60 (415)	4	2	102	100	5.1	0.75Ni-0.5Cu-Mo	Smls. & welded tube	...
A/SA-426	CP15	J11522	60 (415)	3	1	101	100	1.1	C-0.5Mo-Si	Centrifugal cast pipe	...
A/SA-426	CP2	J11547	60 (415)	3	1	101	100	4.2	0.5Cr-0.5Mo	Centrifugal cast pipe	...
A/SA-426	CP12	J11562	60 (415)	4	1	102	110	5.1	1Cr-0.5Mo	Centrifugal cast pipe	...
A/SA-426	CP11	J12072	70 (485)	4	1	102	110	5.1	1.25Cr-0.5Mo	Centrifugal cast pipe	...
A/SA-426	CP1	J12521	65 (450)	3	1	101	100	1.1	C-0.5Mo	Centrifugal cast pipe	...
A/SA-426	CP22	J21890	70 (485)	5A	1	102	110	5.2	2.25Cr-1Mo	Centrifugal cast pipe	...
A/SA-426	CP21	J31545	60 (415)	5A	1	102	110	5.2	3Cr-1Mo	Centrifugal cast pipe	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)		
				P-No.	Group No.	AWS P-No.	ISO 15608 Group		Nominal Composition				
							B2.2 BM	Group					
Ferrous (Cont'd)													
A/SA-426	CP5	J42045	90 (620)	5B	1	102	110	5.3	5Cr-0.5Mo	Centrifugal cast pipe	...		
A/SA-426	CP5b	J51545	60 (415)	5B	1	102	110	5.3	5Cr-1.5Si-0.5Mo	Centrifugal cast pipe	...		
A/SA-426	CP9	J82090	90 (620)	5B	1	102	110	5.4	9Cr-1Mo	Centrifugal cast pipe	...		
A/SA-426	CPCA15	J91150	90 (620)	6	3	102	150	7.2	13Cr	Centrifugal cast pipe	...		
A/SA-451	CPF3	J92500	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Centrifugal cast pipe	...		
A/SA-451	CPF3A	J92500	77 (530)	8	1	102	130	8.1	18Cr-8Ni	Centrifugal cast pipe	...		
A/SA-451	CPF8	J92600	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Centrifugal cast pipe	...		
A/SA-451	CPF8A	J92600	77 (530)	8	1	102	130	8.1	18Cr-8Ni	Centrifugal cast pipe	...		
A/SA-451	CPF8C	J92710	70 (485)	8	1	102	130	8.1	18Cr-10Ni-Cb	Centrifugal cast pipe	...		
A/SA-451	CPF3M	J92800	70 (485)	8	1	102	130	8.1	18Cr-12Ni-2Mo	Centrifugal cast pipe	...		
A/SA-451	CPE20N	J92802	80 (550)	8	2	102	130	8.2	25Cr-8Ni-N	Centrifugal cast pipe	...		
A/SA-451	CPF8M	J92900	70 (485)	8	1	102	130	8.1	18Cr-12Ni-2Mo	Centrifugal cast pipe	...		
A/SA-451	CPF10MC	J92971	70 (485)	8	1	102	130	8.1	16Cr-14Ni-2Mo	Centrifugal cast pipe	...		
A/SA-451	CPH8	J93400	65 (450)	8	2	102	130	8.2	25Cr-12Ni	Centrifugal cast pipe	...		
A/SA-451	CPH20	J93402	70 (485)	8	2	102	130	8.2	25Cr-12Ni	Centrifugal cast pipe	...		
A/SA-451	CPK20	J94202	65 (450)	8	2	102	130	8.2	25Cr-20Ni	Centrifugal cast pipe	...		
A/SA-455	...	K03300	70 (485)	1	2	101	100	11.2	C-Mn-Si	Plate	>0.580 (15) ≤0.75 (19)		
A/SA-455	...	K03300	73 (505)	1	2	101	100	11.2	C-Mn-Si	Plate	>0.375 (10) ≤0.580 (15)		
A/SA-455	...	K03300	75 (515)	1	2	101	100	11.2	C-Mn-Si	Plate	≤0.375 (10)		
A/SA-479	...	N08367	95 (655)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Bars & shapes	...		
A/SA-479	904L	N08904	71 (490)	45	...	111	420	8.2	44Fe-25Ni-21Cr-Mo	Bars & shapes	...		
A/SA-479	XM-19	S20910	100 (690)	8	3	102	130	8.3	22Cr-13Ni-5Mn	Bars & shapes	...		
A/SA-479	XM-17	S21600	90 (620)	8	3	102	130	8.3	19Cr-8Mn-6Ni-Mo-N	Bars & shapes	...		
A/SA-479	XM-18	S21603	90 (620)	8	3	102	130	8.3	19Cr-8Mn-6Ni-Mo-N	Bars & shapes	...		
A/SA-479	S21800	S21800	95 (655)	8	3	102	130	8.1	18Cr-8Ni-8Mn-4Si-N	Bars & shapes	...		
A/SA-479	XM-11	S21904	90 (620)	8	3	102	130	8.3	21Cr-6Ni-9Mn	Bars & shapes	...		
A/SA-479	XM-29	S24000	100 (690)	8	3	102	130	8.3	18Cr-3Ni-12Mn	Bars & shapes	...		
A/SA-479	302	S30200	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Bars & shapes	...		
A/SA-479	304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Bars & shapes	...		
A/SA-479	304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Bars & shapes	...		
A/SA-479	304H	S30409	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Bars & shapes	...		
A/SA-479	304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N	Bars & shapes	...		
A/SA-479	304LN	S30453	75 (515)	8	1	102	130	8.1	18Cr-8Ni-N	Bars & shapes	...		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A/SA-479	S30600	S30600	78 (540)	8	1	102	130	8.1	18Cr-15Ni-4Si	Bars & shapes	...
A/SA-479	S30815	S30815	87 (600)	8	2	102	130	8.2	21Cr-11Ni-N	Bars & shapes	...
A/SA-479	309S	S30908	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Bars & shapes	...
A/SA-479	309Cb	S30940	75 (515)	8	2	102	130	8.2	23Cr-12Ni-Cb	Bars & shapes	...
A/SA-479	310S	S31008	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Bars & shapes	...
A/SA-479	310Cb	S31040	75 (515)	8	2	102	130	8.2	25Cr-20Ni-Cb	Bars & shapes	...
A/SA-479	S31254	S31254	95 (655)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Bars & shapes	...
A/SA-479	316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Bars & shapes	...
A/SA-479	316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Bars & shapes	...
A/SA-479	316H	S31609	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Bars & shapes	...
A/SA-479	316Ti	S31635	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-Ti	Bars & shapes	...
A/SA-479	316Cb	S31640	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-Cb	Bars & shapes	...
A/SA-479	316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Bars & shapes	...
A/SA-479	316LN	S31653	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Bars & shapes	...
A/SA-479	S31725	S31725	75 (515)	8	4	102	130	8.1	19Cr-15Ni-4Mo	Bars & shapes	...
A/SA-479	S31726	S31726	80 (550)	8	4	102	130	8.1	19Cr-15.5Ni-4Mo	Bars & shapes	...
A/SA-479	...	S31803	90 (620)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Bars & shapes	...
A/SA-479	...	S32053	93 (640)	8	4	102	130	8.2	23Cr-25Ni-5.5Mo-N	Bars & shapes	...
A/SA-479	321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Bars & shapes	...
A/SA-479	...	S32101	94 (650)	10H	1	102	145	10.3	21Cr-5Mn-1.5Ni-Cu-N	Bars & shapes	...
A/SA-479	321H	S32109	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Bars & shapes	...
A/SA-479	...	S32202	94 (650)	10H	1	102	145	10.3	22Cr-2Ni-Mo-N	Bars & shapes	...
A/SA-479	...	S32205	95 (655)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Bars & shapes	...
A/SA-479	...	S32506	90 (620)	10H	1	102	145	10.2	25Cr-6Ni-Mo-N	Bars & shapes	...
A/SA-479	S32550	S32550	110 (760)	10H	1	102	145	10.2	25Cr-5Ni-3Mo-2Cu	Bars & shapes	...
A/SA-479	S32615	S32615	80 (550)	8	1	102	130	8.1	18Cr-20Ni-5.5Si	Bars & shapes	...
A/SA-479	S32750	S32750	116 (800)	10H	1	102	145	10.2	25Cr-7Ni-4Mo-N	Bars & shapes	...
A/SA-479	S32906	S32906	109 (750)	10H	1	102	145	10.2	29Cr-6.5Ni-2Mo-N	Bars & shapes	...
A/SA-479	...	S34565	115 (795)	8	4	102	130	8.3	24Cr-17Ni-6Mn-4.5Mo-N	Bars & shapes	...
A/SA-479	347	S34700	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Bars & shapes	...
A/SA-479	347H	S34709	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Bars & shapes	...
A/SA-479	348	S34800	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Bars & shapes	...
A/SA-479	348H	S34809	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Bars & shapes	...
A/SA-479	...	S38815	78 (540)	8	1	102	130	8.1	14Cr-16Ni-6Si-Cu-Mo	Bars & shapes	...
A/SA-479	403	S40300	70 (485)	6	1	102	150	7.1	12Cr	Bars & shapes	...
A/SA-479	405	S40500	60 (415)	7	1	102	160	7.1	12Cr-Al	Bars & shapes	...
A/SA-479	410	S41000	70 (485)	6	1	102	150	7.2	13Cr	Bars & shapes	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)	
				Group	P-No.	AWS B2.2 BM No.	ISO 15608					
							P-No.	B2.2 BM	Group	Nominal Composition		
Ferrous (Cont'd)												
A/SA-479	414	S41400	115 (795)	6	4	102	150	7.2	12.5Cr-2Ni-Si	Bars & shapes	...	
A/SA-479	S41500	S41500	115 (795)	6	4	102	150	7.2	13Cr-4.5Ni-Mo	Bars & shapes	...	
A/SA-479	430	S43000	70 (485)	7	2	102	150	7.1	17Cr	Bars & shapes	...	
A/SA-479	439	S43035	70 (485)	7	2	102	150	7.1	18Cr-Ti	Bars & shapes	...	
A/SA-479	S44400	S44400	60 (415)	7	2	102	150	7.1	18Cr-2Mo	Bars & shapes	...	
A/SA-479	XM-27	S44627	65 (450)	10I	1	102	150	7.1	27Cr-1Mo	Bars & shapes	...	
A/SA-479	S44700	S44700	70 (485)	10J	1	102	150	7.1	29Cr-4Mo	Bars & shapes	...	
A/SA-479	S44800	S44800	70 (485)	10K	1	102	150	7.1	29Cr-4Mo-2Ni	Bars & shapes	...	
A/SA-479	...	S82441	99 (680)	10H	1	102	145	10.1	24Cr-4Ni-3Mn-1.5Mo-N	Bars & shapes	≥0.4375 (11)	
A/SA-479	...	S82441	107 (740)	10H	1	102	145	10.1	24Cr-4Ni-3Mn-1.5Mo-N	Bars & shapes	<0.4375 (11)	
A/SA-487	1, Cl. A	J13002	85 (585)	10A	1	101	100	2.1	Mn-V	Castings	...	
A/SA-487	1, Cl. B	J13002	90 (620)	10A	1	101	100	2.1	Mn-V	Castings	...	
A/SA-487	2, Cl. A	J13005	85 (585)	3	3	101	100	2.1	Mn-0.25Mo-V	Castings	...	
A/SA-487	2, Cl. B	J13005	90 (620)	3	3	101	100	2.1	Mn-0.25Mo-V	Castings	...	
A/SA-487	4, Cl. A	J13047	90 (620)	3	3	101	100	3.1	0.5Ni-0.5Cr-0.25Mo-V	Castings	...	
A/SA-487	4, Cl. B	J13047	105 (725)	11A	3	101	100	3.1	0.5Ni-0.5Cr-0.25Mo-V	Castings	...	
A/SA-487	4, Cl. E	J13047	115 (795)	11A	3	101	100	3.1	0.5Ni-0.5Cr-0.25Mo-V	Castings	...	
A/SA-487	8, Cl. A	J22091	85 (585)	5C	1	102	110	5.2	2.25Cr-1Mo	Castings	...	
A/SA-487	8, Cl. B	J22091	105 (725)	5C	4	102	110	5.2	2.25Cr-1Mo	Castings	...	
A/SA-487	8, Cl. C	J22091	100 (690)	5C	4	102	110	5.2	2.25Cr-1Mo	Castings	...	
A/SA-487	16, Cl. A	J31200	70 (485)	1	2	101	100	1.1	Low C-Mn-Ni	Castings	...	
A/SA-487	CA15 Cl. C	J91150	90 (620)	6	3	102	150	7.2	13Cr	Castings	...	
A/SA-487	CA15M Cl. A	J91151	90 (620)	6	3	102	150	7.2	13Cr-Mo	Castings	...	
A/SA-487	CA15 Cl. B	J91171	90 (620)	6	3	102	150	7.2	13Cr	Castings	...	
A/SA-487	CA15 Cl. D	J91171	100 (690)	6	3	102	150	7.2	13Cr	Castings	...	
A/SA-487	CA6NM Cl. A	J91540	110 (760)	6	4	102	150	7.2	13Cr-4Ni	Castings	...	
A/SA-487	CA6NM Cl. B	J91540	100 (690)	6	4	102	150	7.2	13Cr-4Ni	Castings	...	
A/SA-494	M35-2	N04020	65 (450)	42	...	110	400	42	67Ni-30Cu-Fe-Si	Castings	...	
A/SA-494	CY40	N06040	70 (485)	43	...	111	420	43	72Ni-15Cr-8Fe-Si	Castings	...	
A/SA-494	CU5MCuC	N08826	75 (515)	45	...	111	420	45	42Ni-21.5Cr-3Mo-2.3Cu	Castings	...	
A/SA-494	M30C	N24130	65 (450)	42	...	110	400	42	67Ni-30Cu-2Fe-Cb	Castings	...	
A/SA-494	M35-1	N24135	65 (450)	42	...	110	400	42	67Ni-30Cu-2Fe-Cb	Castings	...	
A/SA-494	CX2MW	N26022	80 (550)	43	...	111	420	43	59Ni-22Cr-14Mo-4Fe-3W	Castings	...	
A/SA-494	CW2M	N26455	72 (495)	43	...	111	420	43	66Ni-16Mo-16Cr-Fe-W	Castings	...	
A/SA-494	CW6MC	N26625	70 (485)	43	...	111	420	43	60Ni-21.5Cr-9Mo-4Cb-Fe	Castings	...	
A/SA-494	N7M	N30007	76 (525)	44	...	112	410	44	65Ni-31.5Mo-1.5Fe-Cr	Castings	...	

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing					Typical Product Form	Nominal Thickness Limits, in. (mm)	
				P-No.	Group No.	AWS	B2.2 BM	ISO 15608 Group	Nominal Composition				
Ferrous (Cont'd)													
A/SA-494	CW6M	N30107	72 (495)	44	...	112	420	44	56Ni-19Mo-18Cr-2Fe	Castings	...		
A500	C	K02705	62 (425)	1	1	101	100	1.2	C	Smls. & welded tube	...		
A500	B	K03000	58 (400)	1	1	101	100	11.1	C	Smls. & welded tube	...		
A501	A	K03000	58 (400)	1	1	101	100	11.1	C	Smls. & welded tube	...		
A501	B	K03000	70 (485)	1	2	101	100	1.2	C	Smls. & welded tube	...		
A/SA-508	3, Cl. 1	K12042	80 (550)	3	3	101	100	3.1	0.75Ni-0.5Mo-Cr-V	Forgings	...		
A/SA-508	3, Cl. 2	K12042	90 (620)	3	3	102	100	3.1	0.75Ni-0.5Mo-Cr-V	Forgings	...		
A/SA-508	2, Cl. 1	K12766	80 (550)	3	3	101	100	3.1	0.75Ni-0.5Mo-0.3Cr-V	Forgings	...		
A/SA-508	2, Cl. 2	K12766	90 (620)	3	3	101	100	3.1	0.75Ni-0.5Mo-0.3Cr-V	Forgings	...		
A/SA-508	1	K13502	70 (485)	1	2	101	100	11.1	C	Forgings	...		
A/SA-508	1A	K13502	70 (485)	1	2	101	100	11.1	C	Forgings	...		
A/SA-508	22, Cl. 3	K21590	85 (585)	5C	1	102	110	5.2	2.25Cr-1Mo	Forgings	...		
A/SA-508	4N, Cl. 1	K22375	105 (725)	11A	5	102	110	3.1	3.5Ni-1.75Cr-0.5Mo-V	Forgings	...		
A/SA-508	4N, Cl. 2	K22375	115 (795)	11B	10	102	110	3.1	3.5Ni-1.75Cr-0.5Mo-V	Forgings	...		
A/SA-508	4N, Cl. 3	K22375	90 (620)	3	3	102	110	3.1	3.5Ni-1.75Cr-0.5Mo-V	Forgings	...		
A/SA-508	3Vcb	K31390	85 (585)	5C	1	102	110	6.2	3Cr-1Mo-0.25V-Cb-Ca	Forgings	...		
A/SA-508	3V	K31830	85 (585)	5C	1	102	120	6.2	3Cr-1Mo-V-Ti-B	Forgings	...		
A/SA-508	5, Cl. 1	K42365	105 (725)	11A	5	102	110	3.1	3.5Ni-1.75Cr-0.5Mo-V	Forgings	...		
A/SA-508	5, Cl. 2	K42365	115 (795)	11B	10	102	110	3.1	3.5Ni-1.75Cr-0.5Mo-V	Forgings	...		
A/SA-513	1008	G10080	42 (290)	1	1	101	100	1.1	C	Tube	...		
A/SA-513	1010	G10100	45 (310)	1	1	101	100	1.1	C	Tube	...		
A/SA-513	1015	G10150	48 (330)	1	1	101	100	1.1	C	Tube	...		
A513	1015 CW	G10150	...	1	1	101	100	1.1	C	Tube	...		
A513	1020 CW	G10200	...	1	2	101	100	1.1	C	Tube	...		
A513	1025 CW	G10250	...	1	2	101	100	1.2	C	Tube	...		
A513	1026 CW	G10260	...	1	3	101	100	11.1	C	Tube	...		
A514	Q	...	100 (690)	11B	9	102	100	3.1	1.3Ni-1.3Cr-0.5Mo-V	Plate	>2.5 (65) ≤6 (150)		
A514	Q	...	110 (760)	11B	9	102	100	3.1	1.3Ni-1.3Cr-0.5Mo-V	Plate	≤2.5 (65)		
A514	F	K11576	110 (760)	11B	3	101	100	3.1	0.75Ni-0.5Cr-0.5Mo-V	Plate	≤2.5 (65)		
A514	B	K11630	110 (760)	11B	4	101	100	3.1	0.5Cr-0.2Mo-V	Plate	≤1.25 (32)		
A514	A	K11856	110 (760)	11B	1	101	100	3.1	0.5Cr-0.25Mo-Si	Plate	≤1.25 (32)		
A514	E	K21604	100 (690)	11B	2	102	110	3.1	1.75Cr-0.5Mo-Cu	Plate	>2.5 (65) ≤6 (150)		
A514	E	K21604	110 (760)	11B	2	102	110	3.1	1.75Cr-0.5Mo-Cu	Plate	≤2.5 (65)		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A514	P	K21650	100 (690)	11B	8	102	110	3.1	1.25Ni-1Cr-0.5Mo	Plate	>2.5 (65) ≤6 (150)
A514	P	K21650	110 (760)	11B	8	102	110	3.1	1.25Ni-1Cr-0.5Mo	Plate	≤2.5 (65)
A/SA-515	60	...	60 (415)	1	1	101	100	11.1	C-Si	Plate	>1 (25)
A/SA-515	60	K02401	60 (415)	1	1	101	100	1.1	C	Plate	≤1 (25)
A/SA-515	65	K02800	65 (450)	1	1	101	100	11.1	C-Si	Plate	...
A/SA-515	70	K03101	70 (485)	1	2	101	100	11.1	C-Si	Plate	...
A/SA-516	55	K01800	55 (380)	1	1	101	100	1.1	C-Si	Plate	...
A/SA-516	60	K02100	60 (415)	1	1	101	100	1.1	C-Mn-Si	Plate	...
A/SA-516	65	K02403	65 (450)	1	1	101	100	1.1	C-Mn-Si	Plate	...
A/SA-516	70	K02700	70 (485)	1	2	101	100	11.1	C-Mn-Si	Plate	...
A/SA-517	F	K11576	115 (795)	11B	3	101	100	3.1	0.75Ni-0.5Cr-0.5Mo-V	Plate	≤2.5 (65)
A/SA-517	B	K11630	115 (795)	11B	4	101	100	3.1	0.5Cr-0.2Mo-V	Plate	≤1.25 (32)
A/SA-517	A	K11856	115 (795)	11B	1	101	100	3.1	0.5Cr-0.25Mo-Si	Plate	≤1.25 (32)
A/SA-517	E	K21604	105 (725)	11B	2	102	110	3.1	1.75Cr-0.5Mo-Cu	Plate	>2.5 (65) ≤6 (150)
A/SA-517	E	K21604	115 (795)	11B	2	102	110	3.1	1.75Cr-0.5Mo-Cu	Plate	≤2.5 (65)
A/SA-517	P	K21650	105 (725)	11B	8	102	110	3.1	1.25Ni-1Cr-0.5Mo	Plate	>2.5 (65) ≤4 (100)
A/SA-517	P	K21650	115 (795)	11B	8	102	110	3.1	1.25Ni-1Cr-0.5Mo	Plate	≤2.5 (65)
A519	1018 CW	G10180	...	1	2	101	100	1.1	C	Tube	...
A519	1018 HR	G10180	...	1	1	101	100	1.1	C	Tube	...
A519	1020 CW	G10200	...	1	2	101	100	1.1	C	Tube	...
A519	1020 HR	G10200	...	1	1	101	100	1.1	C	Tube	...
A519	1022 CW	G10220	...	1	2	101	100	1.1	C	Tube	...
A519	1022 HR	G10220	...	1	1	101	100	1.1	C	Tube	...
A519	1025 CW	G10250	...	1	2	101	100	1.2	C	Tube	...
A519	1025 HR	G10250	...	1	1	101	100	1.1	C	Tube	...
A519	1026 CW	G10260	...	1	2	101	100	11.1	C	Tube	...
A519	1026 HR	G10260	...	1	1	101	100	11.1	C	Tube	...
A/SA-522	II	K71340	100 (690)	11A	1	101	100	9.3	8Ni	Forgings	...
A/SA-522	I	K81340	100 (690)	11A	1	101	100	9.3	9Ni	Forgings	...
A/SA-524	I	K02104	60 (415)	1	1	101	100	1.1	C-Mn-Si	Smls. pipe	...
A/SA-524	II	K02104	55 (380)	1	1	101	100	1.1	C-Mn-Si	Smls. pipe	...
A/SA-533	A, Cl. 1	K12521	80 (550)	3	3	101	100	3.1	Mn-0.5Mo	Plate	...
A/SA-533	A, Cl. 2	K12521	90 (620)	3	3	101	100	3.1	Mn-0.5Mo	Plate	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)		
				Group P-No.	Group No.	AWS P-No.	B2.2 BM Group	ISO 15608 Nominal Composition					
Ferrous (Cont'd)													
A/SA-533	A, Cl. 3	K12521	100 (690)	11A	4	101	100	3.1	Mn-0.5Mo	Plate	...		
A/SA-533	D, Cl. 1	K12529	80 (550)	3	3	101	100	3.1	Mn-0.5Mo-0.25Ni	Plate	...		
A/SA-533	D, Cl. 2	K12529	90 (620)	3	3	101	100	3.1	Mn-0.5Mo-0.25Ni	Plate	...		
A/SA-533	D, Cl. 3	K12529	100 (690)	11A	4	101	100	3.1	Mn-0.5Mo-0.25Ni	Plate	...		
A/SA-533	B, Cl. 1	K12539	80 (550)	3	3	101	100	3.1	Mn-0.5Mo-0.5Ni	Plate	...		
A/SA-533	B, Cl. 2	K12539	90 (620)	3	3	101	100	3.1	Mn-0.5Mo-0.5Ni	Plate	...		
A/SA-533	B, Cl. 3	K12539	100 (690)	11A	4	101	100	3.2	Mn-0.5Mo-0.5Ni	Plate	...		
A/SA-533	C, Cl. 1	K12554	80 (550)	3	3	101	100	3.1	Mn-0.5Mo-0.75Ni	Plate	...		
A/SA-533	C, Cl. 2	K12554	90 (620)	3	3	101	100	3.1	Mn-0.5Mo-0.75Ni	Plate	...		
A/SA-533	C, Cl. 3	K12554	100 (690)	11A	4	101	100	3.2	Mn-0.5Mo-0.75Ni	Plate	...		
A/SA-533	E, Cl. 1	K12554	80 (550)	3	3	101	100	3.1	Mn-0.5Mo-0.75Ni	Plate	...		
A/SA-533	E, Cl. 2	K12554	90 (620)	3	3	101	100	3.1	Mn-0.5Mo-0.75Ni	Plate	...		
A/SA-537	Cl. 1	K12437	65 (450)	1	2	101	100	1.2	C-Mn-Si	Plate	>2.5 (65) ≤4 (100)		
A/SA-537	Cl. 1	K12437	70 (485)	1	2	101	100	1.2	C-Mn-Si	Plate	≤2.5 (65)		
A/SA-537	Cl. 2	K12437	70 (485)	1	3	101	100	1.2	C-Mn-Si	Plate	>4 (100) ≤6 (150)		
A/SA-537	Cl. 2	K12437	75 (515)	1	3	101	100	1.2	C-Mn-Si	Plate	>2.5 (65) ≤4 (100)		
A/SA-537	Cl. 2	K12437	80 (550)	1	3	101	100	1.2	C-Mn-Si	Plate	≤2.5 (65)		
A/SA-537	Cl. 3	K12437	70 (485)	1	3	101	100	1.2	C-Mn-Si	Plate	>4 (100)		
A/SA-537	Cl. 3	K12437	75 (515)	1	3	101	100	1.2	C-Mn-Si	Plate	>2.5 (65) ≤4 (100)		
A/SA-537	Cl. 3	K12437	80 (550)	1	3	101	100	1.2	C-Mn-Si	Plate	≤2.5 (65)		
A/SA-541	1A	K03020	70 (485)	1	2	101	100	11.1	C-Mn-Si	Forgings	...		
A/SA-541	1	K03506	70 (485)	1	2	101	100	11.1	C-Si	Forgings	...		
A/SA-541	11, Cl. 4	K11572	80 (550)	4	1	102	110	5.2	1.25Cr-0.5Mo-Si	Forgings	...		
A/SA-541	3, Cl. 1	K12045	80 (550)	3	3	101	100	4.1	0.5Ni-0.5Mo-V	Forgings	...		
A/SA-541	3, Cl. 2	K12045	90 (620)	3	3	101	100	4.1	0.5Ni-0.5Mo-V	Forgings	...		
A/SA-541	2, Cl. 1	K12765	80 (550)	3	3	101	100	4.2	0.75Ni-0.5Mo-0.3Cr-V	Forgings	...		
A/SA-541	2, Cl. 2	K12765	90 (620)	3	3	101	100	4.2	0.75Ni-0.5Mo-0.3Cr-V	Forgings	...		
A/SA-541	22, Cl. 3	K21390	85 (585)	5C	1	102	110	5.2	2.25Cr-1Mo	Forgings	...		
A/SA-541	22, Cl. 4	K21390	105 (725)	5C	4	102	110	5.2	2.25Cr-1Mo	Forgings	...		
A/SA-541	22, Cl. 5	K21390	115 (795)	5C	5	102	110	5.2	2.25Cr-1Mo	Forgings	...		
A/SA-541	3Vcb	K31390	85 (585)	5C	1	102	110	6.2	3Cr-1Mo-0.25V-Cb-Ca	Forgings	...		
A/SA-541	3V	K31830	85 (585)	5C	1	102	120	6.2	3Cr-1Mo-V-Ti-B	Forgings	...		
A/SA-541	22V	K31835	85 (585)	5C	1	102	110	5.2	2.25Cr-1Mo-V	Forgings	...		
A/SA-542	A, Cl. 1	K21590	105 (725)	5C	4	102	110	5.2	2.25Cr-1Mo	Plate	...		
A/SA-542	A, Cl. 2	K21590	115 (795)	5C	5	102	110	5.2	2.25Cr-1Mo	Plate	...		

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)		
				Group P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608					
								Group	Nominal Composition				
Ferrous (Cont'd)													
A/SA-542	A, Cl. 3	K21590	95 (655)	5C	3	102	110	5.2	2.25Cr-1Mo	Plate	...		
A/SA-542	A, Cl. 4	K21590	85 (585)	5C	1	102	110	5.2	2.25Cr-1Mo	Plate	...		
A/SA-542	A, Cl. 4a	K21590	85 (585)	5C	1	102	110	5.2	2.25Cr-1Mo	Plate	...		
A/SA-542	B, Cl. 1	K21590	105 (725)	5C	4	102	110	5.2	2.25Cr-1Mo	Plate	...		
A/SA-542	B, Cl. 2	K21590	115 (795)	5C	5	102	110	5.2	2.25Cr-1Mo	Plate	...		
A/SA-542	B, Cl. 3	K21590	95 (655)	5C	3	102	110	5.2	2.25Cr-1Mo	Plate	...		
A/SA-542	B, Cl. 4	K21590	85 (585)	5C	1	102	110	5.2	2.25Cr-1Mo	Plate	...		
A/SA-542	B, Cl. 4a	K21590	85 (585)	5C	1	102	110	5.2	2.25Cr-1Mo	Plate	...		
A/SA-542	E, Cl. 4a	K31390	85 (585)	5C	1	102	110	6.2	3Cr-1Mo-0.25V-Cb-Ca	Plate	...		
A/SA-542	C, Cl. 1	K31830	105 (725)	5C	4	102	120	6.2	3Cr-1Mo-V-Ti-B	Plate	...		
A/SA-542	C, Cl. 2	K31830	115 (795)	5C	5	102	120	6.2	3Cr-1Mo-V-Ti-B	Plate	...		
A/SA-542	C, Cl. 3	K31830	95 (655)	5C	3	102	120	6.2	3Cr-1Mo-V-Ti-B	Plate	...		
A/SA-542	C, Cl. 4	K31830	85 (585)	5C	1	102	120	6.2	3Cr-1Mo-V-Ti-B	Plate	...		
A/SA-542	C, Cl. 4a	K31830	85 (585)	5C	1	102	120	6.2	3Cr-1Mo-V-Ti-B	Plate	...		
A/SA-542	D, Cl. 4a	K31835	85 (585)	5C	1	102	110	6.3	2.25Cr-1Mo-V	Plate	...		
A/SA-543	C, Cl. 1	...	105 (725)	11A	5	102	110	3.1	2.75Ni-1.5Cr-0.5Mo	Plate	...		
A/SA-543	C, Cl. 2	...	115 (795)	11B	10	102	110	3.1	2.75Ni-1.5Cr-0.5Mo	Plate	...		
A/SA-543	C, Cl. 3	...	90 (620)	3	3	102	110	3.1	2.75Ni-1.5Cr-0.5Mo	Plate	...		
A/SA-543	B, Cl. 1	K42339	105 (725)	11A	5	102	110	3.1	3Ni-1.75Cr-0.5Mo	Plate	...		
A/SA-543	B, Cl. 2	K42339	115 (795)	11B	10	102	110	3.1	3Ni-1.75Cr-0.5Mo	Plate	...		
A/SA-543	B, Cl. 3	K42339	90 (620)	3	3	102	110	3.1	3Ni-1.75Cr-0.5Mo	Plate	...		
A/SA-553	III	...	100 (690)	11A	1	101	100	9.2	7Ni	Plate	...		
A/SA-553	II	K71340	100 (690)	11A	1	101	100	9.3	8Ni	Plate	...		
A/SA-553	I	K81340	100 (690)	11A	1	101	100	9.3	9Ni	Plate	...		
A/SA-556	A2	K01807	47 (325)	1	1	101	100	1.1	C	Smls. tube	...		
A/SA-556	B2	K02707	60 (415)	1	1	101	100	11.1	C-Si	Smls. tube	...		
A/SA-556	C2	K03006	70 (485)	1	2	101	100	11.1	C-Mn-Si	Smls. tube	...		
A/SA-557	A2	K01807	47 (325)	1	1	101	100	1.1	C	E.R.W. tube	...		
A/SA-557	B2	K03007	60 (415)	1	1	101	100	11.1	C	E.R.W. tube	...		
A/SA-557	C2	K03505	70 (485)	1	2	101	100	11.1	C-Mn	E.R.W. tube	...		
A/SA-562	...	K11224	55 (380)	1	1	101	120	1.1	C-Mn-Ti	Plate	...		
A/SA-572	42	...	60 (415)	1	1	101	100	1.2	C-Mn-Si	Plate & shapes	...		
A/SA-572	50	...	65 (450)	1	1	101	100	1.2	C-Mn-Si	Plate & shapes	...		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A/SA-572	55	...	70 (485)	1	2	101	100	1.3	C-Mn-Si	Plate & shapes	...
A/SA-572	60	...	75 (515)	1	2	101	100	11.1	C-Mn-Si	Plate & shapes	...
A/SA-572	65	...	80 (550)	1	3	101	100	1.3	C-Mn-Si	Plate & shapes	...
A573	58	...	58 (400)	1	1	101	100	11.1	C	Plate	...
A573	65	...	65 (450)	1	1	101	100	11.1	C	Plate	...
A573	70	...	70 (485)	1	2	101	100	11.1	C	Plate	...
A575	M 1008	1	1	101	100	1.1	C	Bar	...
A575	M 1010	1	1	101	100	1.1	C	Bar	...
A575	M 1012	1	1	101	100	1.1	C	Bar	...
A575	M 1015	1	1	101	100	1.1	C	Bar	...
A575	M 1017	1	1	101	100	1.1	C	Bar	...
A575	M 1020	1	1	101	100	11.1	C	Bar	...
A575	M 1023	1	1	101	100	11.1	C	Bar	...
A575	M 1025	1	1	101	100	11.1	C	Bar	...
A576	G10080	1	1	101	100	1.1	C	Bar	...
A576	G10100	1	1	101	100	1.1	C	Bar	...
A576	G10120	1	1	101	100	1.1	C	Bar	...
A576	G10150	1	1	101	100	1.1	C	Bar	...
A576	G10160	1	1	101	100	1.1	C	Bar	...
A576	G10170	1	1	101	100	1.1	C	Bar	...
A576	G10180	1	1	101	100	1.1	C	Bar	...
A576	G10190	1	1	101	100	1.1	C	Bar	...
A576	G10200	1	1	101	100	1.1	C	Bar	...
A576	G10210	1	1	101	100	11.1	C	Bar	...
A576	G10220	1	1	101	100	11.1	C	Bar	...
A576	G10230	1	1	101	100	11.1	C	Bar	...
A576	G10250	1	1	101	100	11.1	C	Bar	...
A/SA-587	...	K11500	48 (330)	1	1	101	100	1.1	C	E.R.W. pipe	...
A588	A	K11430	63 (435)	3	1	101	100	1.4	Mn-0.5Cr-0.3Cu-Si-V	Plate & bar	>5 (125) ≤8 (200)
A588	A	K11430	67 (460)	3	1	101	100	1.4	Mn-0.5Cr-0.3Cu-Si-V	Plate & bar	>4 (100) ≤5 (125)
A588	A	K11430	70 (485)	3	1	101	100	1.4	Mn-0.5Cr-0.3Cu-Si-V	Shapes	...
A588	A	K11430	70 (485)	3	1	101	100	1.4	Mn-0.5Cr-0.3Cu-Si-V	Plate & bar	≤4 (100)
A588	B	K12043	63 (435)	3	1	101	100	1.4	Mn-0.6Cr-0.3Cu-Si-V	Plate & bar	>5 (125) ≤8 (200)
A588	B	K12043	67 (460)	3	1	101	100	1.4	Mn-0.6Cr-0.3Cu-Si-V	Plate & bar	>4 (100) ≤5 (125)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)		
				P-No.	Group No.	AWS BZ2.2 BM	ISO 15608 Group						
							P-No.	BZ2.2 BM	Nominal Composition				
Ferrous (Cont'd)													
A588	B	K12043	70 (485)	3	1	101	100	1.4	Mn-0.6Cr-0.3Cu-Si-V	Shapes	...		
A588	B	K12043	70 (485)	3	1	101	100	1.4	Mn-0.6Cr-0.3Cu-Si-V	Plate & bar	≤4 (100)		
A/SA-592	F	K11576	105 (725)	11B	3	101	100	3.1	0.75Ni-0.5Cr-0.5Mo-V	Forgings	≥2.5 (65) ≤4 (100)		
A/SA-592	F	K11576	115 (795)	11B	3	101	100	3.1	0.75Ni-0.5Cr-0.5Mo-V	Forgings	≤2.5 (65)		
A/SA-592	E	K11695	105 (725)	11B	2	102	110	3.1	1.75Cr-0.5Mo-Cu	Forgings	≥2.5 (65) ≤4 (100)		
A/SA-592	E	K11695	115 (795)	11B	2	102	110	3.1	1.75Cr-0.5Mo-Cu	Forgings	≤2.5 (65)		
A/SA-592	A	K11856	115 (795)	11B	1	101	100	3.1	0.5Cr-0.25Mo-Si	Forgings	≤1.5 (38)		
A/SA-612	...	K02900	81 (560)	10C	1	101	100	1.3	C-Mn-Si	Plate	>0.5 (13) ≤1 (25)		
A/SA-612	...	K02900	83 (570)	10C	1	101	100	1.3	C-Mn-Si	Plate	≤0.5 (13)		
A618	Ia	...	67 (460)	1	2	101	100	1.2	Mn-Cu-V	Tube	>0.75 (19) ≤1.5 (38)		
A618	Ia	...	70 (485)	1	2	101	100	1.2	Mn-Cu-V	Tube	≤0.75 (19)		
A618	Ib	K02601	67 (460)	1	2	101	100	1.2	Mn-Cu-V	Tube	>0.75 (19) ≤1.5 (38)		
A618	Ib	K02601	70 (485)	1	2	101	100	1.2	Mn-Cu-V	Tube	≤0.75 (19)		
A618	II	K12609	67 (460)	1	2	101	100	1.2	Mn-Cu-V	Tube	>0.75 (19) ≤1.5 (38)		
A618	II	K12609	70 (485)	1	2	101	100	1.2	Mn-Cu-V	Tube	≤0.75 (19)		
A618	III	K12700	65 (450)	1	1	101	100	1.2	Mn-V	Tube	...		
A633	A	K01802	63 (435)	1	1	101	100	1.1	Mn-Cb	Plate	...		
A633	C	K12000	65 (450)	1	1	101	100	1.1	Mn-Cb	Plate	>2.5 (65) ≤4 (100)		
A633	C	K12000	70 (485)	1	2	101	100	1.1	Mn-Cb	Plate	≤2.5 (65)		
A633	D	K12037	65 (450)	1	1	101	100	1.1	C-Mn-Si	Plate	>2.5 (65) ≤4 (100)		
A633	D	K12037	70 (485)	1	2	101	100	1.1	C-Mn-Si	Plate	≤2.5 (65)		
A633	E	K12202	75 (515)	1	3	101	100	4.1	C-Mn-Si-V	Plate	>4 (100) ≤6 (150)		
A633	E	K12202	80 (550)	1	3	101	100	4.1	C-Mn-Si-V	Plate	≤4 (100)		
A/SA-645	A	K41583	95 (655)	11A	2	101	100	9.2	5Ni-0.25Mo	Plate	...		
A/SA-656	T3, 50	...	60 (415)	1	1	101	100	1.2	C-Mn-Si-V-Cb	Plate	...		
A/SA-656	T3, 60	...	70 (485)	1	2	101	100	1.3	C-Mn-Si-V-Cb	Plate	...		
A/SA-656	T3, 70	...	80 (550)	1	3	101	100	2.2	C-Mn-Si-V-Cb	Plate	...		
A/SA-656	T3, 80	...	90 (620)	1	4	101	100	2.2	C-Mn-Si-V-Cb	Plate	...		
A/SA-656	T7, 50	...	60 (415)	1	1	101	100	1.2	C-Mn-Si-V-Cb	Plate	...		
A/SA-656	T7, 60	...	70 (485)	1	2	101	100	1.3	C-Mn-Si-V-Cb	Plate	...		
A/SA-656	T7, 70	...	80 (550)	1	3	101	100	2.2	C-Mn-Si-V-Cb	Plate	...		
A/SA-656	T7, 80	...	90 (620)	1	4	101	100	2.2	C-Mn-Si-V-Cb	Plate	...		
A/SA-660	WCA	J02504	60 (415)	1	1	101	100	11.1	C-Si	Centrifugal cast pipe	...		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A/SA-660	WCC	J02505	70 (485)	1	2	101	100	11.1	C-Mn-Si	Centrifugal cast pipe	...
A/SA-660	WCB	J03003	70 (485)	1	2	101	100	1.1	C-Si	Centrifugal cast pipe	...
A/SA-662	A	K01701	58 (400)	1	1	101	100	1.1	C-Mn-Si	Plate	...
A/SA-662	C	K02007	70 (485)	1	2	101	100	1.1	C-Mn-Si	Plate	...
A/SA-662	B	K02203	65 (450)	1	1	101	100	1.1	C-Mn-Si	Plate	...
A663	1	1	101	100	...	C	Bar	...
A/SA-666	201-1	S20100	75 (515)	8	3	102	130	8.3	17Cr-4Ni-6Mn	Plate, sheet & strip	...
A/SA-666	201-2	S20100	95 (655)	8	3	102	130	8.3	17Cr-4Ni-6Mn	Plate, sheet & strip	...
A/SA-666	XM-11	S21904	90 (620)	8	3	102	130	8.3	21Cr-6Ni-9Mn	Plate, sheet & strip	...
A/SA-666	302	S30200	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Plate, sheet & strip	...
A/SA-666	304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Plate, sheet & strip	...
A/SA-666	304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Plate, sheet & strip	...
A/SA-666	304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N	Plate, sheet & strip	...
A/SA-666	304LN	S30453	75 (515)	8	1	102	130	8.1	18Cr-8Ni-N	Plate, sheet & strip	...
A/SA-666	316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Plate, sheet & strip	...
A/SA-666	316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Plate, sheet & strip	...
A/SA-666	316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Plate, sheet & strip	...
A/SA-671	CC60	K02100	60 (415)	1	1	101	100	1.1	C-Mn-Si	Fusion welded pipe	...
A/SA-671	CE55	K02202	55 (380)	1	1	101	100	11.1	C	Fusion welded pipe	...
A/SA-671	CB60	K02401	60 (415)	1	1	101	100	1.1	C	Fusion welded pipe	...
A/SA-671	CE60	K02402	60 (415)	1	1	101	100	11.1	C-Mn-Si	Fusion welded pipe	...
A/SA-671	CC65	K02403	65 (450)	1	1	101	100	1.1	C-Mn-Si	Fusion welded pipe	...
A/SA-671	CC70	K02700	70 (485)	1	2	101	100	11.1	C-Mn-Si	Fusion welded pipe	...
A/SA-671	CB65	K02800	65 (450)	1	1	101	100	11.1	C-Si	Fusion welded pipe	...
A/SA-671	CA55	K02801	55 (380)	1	1	101	100	11.1	C	Fusion welded pipe	...
A/SA-671	CK75	K02803	75 (515)	1	2	101	100	11.1	C-Mn-Si	Fusion welded pipe	...
A/SA-671	CB70	K03101	70 (485)	1	2	101	100	11.1	C-Si	Fusion welded pipe	...
A/SA-671	CD70	K12437	70 (485)	1	2	101	100	1.2	C-Mn-Si	Fusion welded pipe	...
A/SA-671	CD80	K12437	80 (550)	1	3	101	100	1.2	C-Mn-Si	Fusion welded pipe	...
A/SA-672	J80	...	80 (550)	3	3	101	100	3.1	Mn-0.5Mo-0.75Ni	Fusion welded pipe	...
A/SA-672	J90	...	90 (620)	3	3	101	100	3.1	Mn-0.5Mo-0.75Ni	Fusion welded pipe	...
A/SA-672	A45	K01700	45 (310)	1	1	101	100	1.1	C	Fusion welded pipe	...
A/SA-672	C55	K01800	55 (380)	1	1	101	100	1.1	C-Si	Fusion welded pipe	...
A/SA-672	B55	K02001	55 (380)	1	1	101	100	1.1	C-Si	Fusion welded pipe	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing		AWS P-No.	ISO 15608 Group	Nominal Composition	Typical Product Form	Nominal Thickness Limits, in. (mm)					
				Group	P-No.	Group	Nominal Composition										
Ferrous (Cont'd)																	
A/SA-672	C60	K02100	60 (415)	1	1	101	100	1.1	C-Mn-Si		Fusion welded pipe	...					
A/SA-672	A50	K02200	50 (345)	1	1	101	100	1.1	C		Fusion welded pipe	...					
A/SA-672	E55	K02202	55 (380)	1	1	101	100	11.1	C		Fusion welded pipe	...					
A/SA-672	B60	K02401	60 (415)	1	1	101	100	1.1	C		Fusion welded pipe	...					
A/SA-672	E60	K02402	60 (415)	1	1	101	100	11.1	C-Mn-Si		Fusion welded pipe	...					
A/SA-672	C65	K02403	65 (450)	1	1	101	100	1.1	C-Mn-Si		Fusion welded pipe	...					
A/SA-672	C70	K02700	70 (485)	1	2	101	100	11.1	C-Mn-Si		Fusion welded pipe	...					
A/SA-672	B65	K02800	65 (450)	1	1	101	100	11.1	C-Si		Fusion welded pipe	...					
A/SA-672	A55	K02801	55 (380)	1	1	101	100	11.1	C		Fusion welded pipe	...					
A/SA-672	N75	K02803	75 (515)	1	2	101	100	11.1	C-Mn-Si		Fusion welded pipe	...					
A/SA-672	B70	K03101	70 (485)	1	2	101	100	11.1	C-Si		Fusion welded pipe	...					
A/SA-672	L65	K11820	65 (450)	3	1	101	100	1.1	C-0.5Mo		Fusion welded pipe	...					
A/SA-672	L70	K12020	70 (485)	3	2	101	100	1.2	C-0.5Mo		Fusion welded pipe	...					
A/SA-672	H75	K12021	75 (515)	3	2	101	100	1.1	Mn-0.5Mo		Fusion welded pipe	...					
A/SA-672	H80	K12022	80 (550)	3	3	101	100	1.2	Mn-0.5Mo		Fusion welded pipe	...					
A/SA-672	L75	K12320	75 (515)	3	2	101	100	1.2	C-0.5Mo		Fusion welded pipe	...					
A/SA-672	D70	K12437	70 (485)	1	2	101	100	1.2	C-Mn-Si		Fusion welded pipe	...					
A/SA-672	D80	K12437	80 (550)	1	3	101	100	1.2	C-Mn-Si		Fusion welded pipe	...					
A/SA-672	J100	K12521	100 (690)	11A	4	101	100	3.2	Mn-0.5Mo		Fusion welded pipe	...					
A/SA-675	45	...	45 (310)	1	1	101	100	11.1	C		Bar	...					
A/SA-675	50	...	50 (345)	1	1	101	100	11.1	C		Bar	...					
A/SA-675	55	...	55 (380)	1	1	101	100	11.1	C		Bar	...					
A/SA-675	60	...	60 (415)	1	1	101	100	11.1	C		Bar	...					
A/SA-675	65	...	65 (450)	1	1	101	100	11.1	C		Bar	...					
A/SA-675	70	...	70 (485)	1	2	101	100	11.1	C		Bar	...					
A/SA-688	XM-29	S24000	100 (690)	8	3	102	130	8.3	18Cr-3Ni-12Mn		Welded tube	...					
A/SA-688	TP304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni		Welded tube	...					
A/SA-688	TP304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni		Welded tube	...					
A/SA-688	TP304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N		Welded tube	...					
A/SA-688	TP304LN	S30453	75 (515)	8	1	102	130	8.1	18Cr-8Ni-N		Welded tube	...					
A/SA-688	TP316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo		Welded tube	...					
A/SA-688	TP316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo		Welded tube	...					
A/SA-688	TP316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N		Welded tube	...					
A/SA-688	TP316LN	S31653	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N		Welded tube	...					
A/SA-691	CMS-75	K02803	75 (515)	1	2	101	100	11.1	C-Mn-Si		Fusion welded pipe	...					

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A/SA-691	1CR, Cl. 1	K11757	55 (380)	4	1	102	110	5.1	1Cr-0.5Mo	Fusion welded pipe	...
A/SA-691	1CR, Cl. 2	K11757	65 (450)	4	1	102	110	5.1	1Cr-0.5Mo	Fusion welded pipe	...
A/SA-691	1.25CR, Cl. 1	K11789	60 (415)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Fusion welded pipe	...
A/SA-691	1.25CR, Cl. 2	K11789	75 (515)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Fusion welded pipe	...
A/SA-691	CM-65	K11820	65 (450)	3	1	101	100	1.1	C-0.5Mo	Fusion welded pipe	...
A/SA-691	CM-70	K12020	70 (485)	3	2	101	100	1.2	C-0.5Mo	Fusion welded pipe	...
A/SA-691	0.5CR, Cl. 1	K12143	55 (380)	3	1	101	100	4.2	0.5Cr-0.5Mo	Fusion welded pipe	...
A/SA-691	0.5CR, Cl. 2	K12143	70 (485)	3	2	101	100	4.2	0.5Cr-0.5Mo	Fusion welded pipe	...
A/SA-691	CM-75	K12320	75 (515)	3	2	101	100	1.2	C-0.5Mo	Fusion welded pipe	...
A/SA-691	CMSH-70	K12437	65 (450)	1	2	101	100	1.2	C-Mn-Si	Fusion welded pipe	>2.5 (65) ≤4 (100)
A/SA-691	CMSH-70	K12437	70 (485)	1	2	101	100	1.2	C-Mn-Si	Fusion welded pipe	≤2.5 (65)
A/SA-691	CMSH-80	K12437	75 (515)	1	3	101	100	1.2	C-Mn-Si	Fusion welded pipe	>2.5 (65) ≤4 (100)
A/SA-691	CMSH-80	K12437	80 (550)	1	3	101	100	1.2	C-Mn-Si	Fusion welded pipe	≤2.5 (65)
A/SA-691	2.25CR, Cl. 1	K21590	60 (415)	5A	1	102	110	5.2	2.25Cr-1Mo	Fusion welded pipe	...
A/SA-691	2.25CR, Cl. 2	K21590	75 (515)	5A	1	102	110	5.2	2.25Cr-1Mo	Fusion welded pipe	...
A/SA-691	3CR, Cl. 1	K31545	60 (415)	5A	1	102	110	5.2	3Cr-1Mo	Fusion welded pipe	...
A/SA-691	3CR, Cl. 2	K31545	75 (515)	5A	1	102	110	5.2	3Cr-1Mo	Fusion welded pipe	...
A/SA-691	5CR, Cl. 1	K41545	60 (415)	5B	1	102	110	5.3	5Cr-0.5Mo	Fusion welded pipe	...
A/SA-691	5CR, Cl. 2	K41545	75 (515)	5B	1	102	110	5.3	5Cr-0.5Mo	Fusion welded pipe	...
A/SA-691	91	K91560	85 (585)	15E	1	102	110	6.4	9Cr-1Mo-V	Fusion welded pipe	...
A694	F42	K03014	60 (415)	1	1	101	100	11.1	C-Mn	Forgings	...
A694	F46	K03014	60 (415)	1	1	101	100	11.1	C-Mn	Forgings	...
A694	F48	K03014	62 (425)	1	1	101	100	11.1	C-Mn	Forgings	...
A694	F50	K03014	64 (440)	1	1	101	100	11.1	C-Mn	Forgings	...
A694	F52	K03014	66 (455)	1	1	101	100	11.1	C-Mn	Forgings	...
A694	F56	K03014	68 (470)	1	2	101	100	11.1	C-Mn	Forgings	...
A694	F60	K03014	75 (515)	1	2	101	100	11.1	C-Mn	Forgings	...
A694	F65	K03014	77 (530)	1	2	101	100	11.1	C-Mn	Forgings	...
A694	F70	K03014	82 (565)	1	3	101	100	11.1	C-Mn	Forgings	...
A/SA-696	B	K03200	60 (415)	1	1	101	100	11.1	C-Mn-Si	Bar	...
A/SA-696	C	K03200	70 (485)	1	2	101	100	11.1	C-Mn-Si	Bar	...
A707	L1, Cl. 1	K02302	...	1	1	101	100	1.2	C-Mn	Forgings	...
A707	L1, Cl. 2	K02302	...	1	1	101	100	1.2	C-Mn	Forgings	...
A707	L2, Cl. 1	K03301	...	1	1	101	100	11.1	C-Mn	Forgings	...
A707	L2, Cl. 2	K03301	...	1	1	101	100	11.1	C-Mn	Forgings	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing					Typical Product Form	Nominal Thickness Limits, in. (mm)			
				P-No.	Group No.	AWS			ISO 15608						
						P-No.	B2.2 BM	Group	Nominal Composition						
Ferrous (Cont'd)															
A707	L2, Cl. 3	K03301	...	1	2	101	100	11.1	C-Mn		Forgings	...			
A707	L3, Cl. 1	K12510	...	1	1	101	100	1.2	C-Mn-V-N		Forgings	...			
A707	L3, Cl. 2	K12510	...	1	1	101	100	1.2	C-Mn-V-N		Forgings	...			
A707	L3, Cl. 3	K12510	...	1	2	101	100	1.3	C-Mn-V-N		Forgings	...			
A714	V	K22035	65 (450)	9A	1	102	100	9.1	2Ni-1Cu		Smls. & welded pipe	...			
A714	V, E	K22035	65 (450)	9A	1	102	100	9.1	2Ni-1Cu		Smls. & welded pipe	...			
A/SA-724	A	K11831	90 (620)	1	4	101	100	3.1	C-Mn-Si		Plate	...			
A/SA-724	B	K12031	95 (655)	1	4	101	100	3.1	C-Mn-Si		Plate	...			
A/SA-724	C	K12037	90 (620)	1	4	101	100	1.1	C-Mn-Si		Plate	...			
A/SA-727	...	K02506	60 (415)	1	1	101	100	11.1	C-Mn-Si		Forgings	...			
A/SA-731	S41500	S41500	115 (795)	6	4	102	150	7.2	13Cr-4.5Ni-Mo		Smls. & welded pipe	...			
A/SA-731	TP439	S43035	60 (415)	7	2	102	150	7.1	18Cr-Ti		Smls. & welded pipe	...			
A/SA-731	18Cr-2Mo	S44400	60 (415)	7	2	102	150	7.1	18Cr-2Mo		Smls. & welded pipe	...			
A/SA-731	TPXM-33	S44626	65 (450)	10I	1	102	150	7.1	27Cr-1Mo-Ti		Smls. & welded pipe	...			
A/SA-731	TPXM-27	S44627	65 (450)	10I	1	102	150	7.1	27Cr-1Mo		Smls. & welded pipe	...			
A/SA-731	S44660	S44660	85 (585)	10K	1	102	150	7.1	26Cr-3Ni-3Mo		Smls. & welded pipe	...			
A/SA-731	S44700	S44700	80 (550)	10J	1	102	150	7.1	29Cr-4Mo		Smls. & welded pipe	...			
A/SA-731	S44800	S44800	80 (550)	10K	1	102	150	7.1	29Cr-4Mo-2Ni		Smls. & welded pipe	...			
A/SA-737	B	K12001	70 (485)	1	2	101	100	11.1	C-Mn-Si-Cb		Plate	...			
A/SA-737	C	K12202	80 (550)	1	3	101	100	4.1	C-Mn-Si-V		Plate	...			
A/SA-738	C	K02008	70 (485)	1	3	101	100	11.1	C-Mn-Si		Plate	>4 (100) ≤6 (150)			
A/SA-738	C	K02008	75 (515)	1	3	101	100	11.1	C-Mn-Si		Plate	>2.5 (65) ≤4 (100)			
A/SA-738	C	K02008	80 (550)	1	3	101	100	11.1	C-Mn-Si		Plate	≤2.5 (65)			
A/SA-738	B	K12007	85 (585)	1	3	101	100	11.1	C-Mn-Si-Cb		Plate	...			
A/SA-738	A	K12447	75 (515)	1	2	101	100	11.1	C-Mn-Si		Plate	...			
A/SA-739	B11	K11797	70 (485)	4	1	102	110	5.1	1.25Cr-0.5Mo		Bar	...			
A/SA-739	B22	K21390	75 (515)	5A	1	102	110	5.2	2.25Cr-1Mo		Bar	...			
A/SA-765	IV	K02009	80 (550)	1	3	101	100	1.1	C-Mn-Si		Forgings	...			
A/SA-765	I	K03046	60 (415)	1	1	101	100	11.1	C-Mn-Si		Forgings	...			
A/SA-765	II	K03047	70 (485)	1	2	101	100	11.1	C-Mn-Si		Forgings	...			
A/SA-765	III	K32026	70 (485)	9B	1	101	100	9.2	3.5Ni		Forgings	...			

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A/SA-789	S31200	S31200	100 (690)	10H	1	102	145	10.2	25Cr-6Ni-Mo-N	Smls. & welded tube	...
A/SA-789	S31260	S31260	100 (690)	10H	1	102	145	10.2	25Cr-6.5Ni-3Mo-N	Smls. & welded tube	...
A/SA-789	S31500	S31500	92 (635)	10H	1	102	145	10.1	18Cr-5Ni-3Mo-N	Smls. & welded tube	...
A/SA-789	S31803	S31803	90 (620)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Smls. & welded tube	...
A/SA-789	...	S32003	100 (690)	10H	1	102	145	10.3	21Cr-3.5Ni-Mo-N	Smls. & welded tube	...
A/SA-789	...	S32101	94 (650)	10H	1	102	145	10.3	21Cr-5Mn-1.5Ni-Cu-N	Smls. & welded tube	>0.187 (5)
A/SA-789	...	S32101	101 (700)	10H	1	102	145	10.3	21Cr-5Mn-1.5Ni-Cu-N	Smls. & welded tube	≤0.187 (5)
A/SA-789	...	S32202	94 (650)	10H	1	102	145	10.3	22Cr-2Ni-Mo-N	Smls. & welded tube	...
A/SA-789	...	S32205	95 (655)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Smls. & welded tube	...
A/SA-789	S32304	S32304	87 (600)	10H	1	102	145	10.1	23Cr-4Ni-Mo-Cu-N	Smls. & welded tube	>1 (25) O.D.
A/SA-789	S32304	S32304	100 (690)	10H	1	102	145	10.1	23Cr-4Ni-Mo-Cu-N	Smls. & welded tube	≤1 (25) O.D.
A/SA-789	...	S32506	90 (620)	10H	1	102	145	10.2	25Cr-6Ni-Mo-N	Smls. & welded tube	...
A/SA-789	S32550	S32550	110 (760)	10H	1	102	145	10.2	25Cr-5Ni-3Mo-2Cu	Smls. & welded tube	...
A/SA-789	S32750	S32750	116 (800)	10H	1	102	145	10.2	25Cr-7Ni-4Mo-N	Smls. & welded tube	...
A/SA-789	S32760	S32760	109 (750)	10H	1	102	145	10.2	25Cr-8Ni-3Mo-W-Cu-N	Smls. & welded tube	...
A/SA-789	S32900	S32900	90 (620)	10H	1	102	145	10.2	26Cr-4Ni-Mo	Smls. & welded tube	...
A/SA-789	S32906	S32906	109 (750)	10H	1	102	145	10.2	29Cr-6.5Ni-2Mo-N	Smls. & welded tube	≥0.40 (10)
A/SA-789	S32906	S32906	116 (800)	10H	1	102	145	10.2	29Cr-6.5Ni-2Mo-N	Smls. & welded tube	<0.40 (10)
A/SA-789	S32950	S32950	100 (690)	10H	1	102	145	10.2	26Cr-4Ni-Mo-N	Smls. & welded tube	...
A/SA-789	S39274	S39274	116 (800)	10H	1	102	145	10.2	25Cr-7Ni-3Mo-2W-Cu-N	Smls. & welded tube	...
A/SA-789	...	S82011	95 (655)	10H	1	102	145	10.3	22Cr-1.5Ni-Mo-N	Smls. & welded tube	>0.187 (5)
A/SA-789	...	S82011	101 (700)	10H	1	102	145	10.3	22Cr-1.5Ni-Mo-N	Smls. & welded tube	≤0.187 (5)
A/SA-789	...	S82441	99 (680)	10H	1	102	145	10.1	24Cr-4Ni-3Mn-1.5Mo-N	Smls. & welded tube	≥0.40 (10)
A/SA-789	...	S82441	107 (740)	10H	1	102	145	10.1	24Cr-4Ni-3Mn-1.5Mo-N	Smls. & welded tube	<0.40 (10)
A/SA-790	S31200	S31200	100 (690)	10H	1	102	145	10.2	25Cr-6Ni-Mo-N	Smls. & welded pipe	...
A/SA-790	S31260	S31260	100 (690)	10H	1	102	145	10.2	25Cr-6.5Ni-3Mo-N	Smls. & welded pipe	...
A/SA-790	S31500	S31500	92 (635)	10H	1	102	145	10.1	18Cr-5Ni-3Mo-N	Smls. & welded pipe	...
A/SA-790	S31803	S31803	90 (620)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Smls. & welded pipe	...
A/SA-790	...	S32003	90 (620)	10H	1	102	145	10.3	21Cr-3.5Ni-Mo-N	Smls. & welded pipe	...
A/SA-790	...	S32101	94 (650)	10H	1	102	145	10.3	21Cr-5Mn-1.5Ni-Cu-N	Smls. & welded pipe	>0.187 (5)
A/SA-790	...	S32101	101 (700)	10H	1	102	145	10.3	21Cr-5Mn-1.5Ni-Cu-N	Smls. & welded pipe	≤0.187 (5)
A/SA-790	...	S32202	94 (650)	10H	1	102	145	10.3	22Cr-2Ni-Mo-N	Smls. & welded pipe	...
A/SA-790	2205	S32205	95 (655)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Smls. & welded pipe	...
A/SA-790	S32304	S32304	87 (600)	10H	1	102	145	10.1	23Cr-4Ni-Mo-Cu-N	Smls. & welded pipe	...
A/SA-790	...	S32506	90 (620)	10H	1	102	145	10.2	25Cr-6Ni-Mo-N	Smls. & welded pipe	...
A/SA-790	S32550	S32550	110 (760)	10H	1	102	145	10.2	25Cr-5Ni-3Mo-2Cu	Smls. & welded pipe	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)		
				P-No.	Group No.	AWS B2.2 BM	ISO 15608						
							P-No.	Group	Nominal Composition				
Ferrous (Cont'd)													
A/SA-790	S32750	S32750	116 (800)	10H	1	102	145	10.2	25Cr-7Ni-4Mo-N	Smels. & welded pipe	...		
A/SA-790	S32760	S32760	109 (750)	10H	1	102	145	10.2	25Cr-8Ni-3Mo-W-Cu-N	Smels. & welded pipe	...		
A/SA-790	S32900	S32900	90 (620)	10H	1	102	145	10.2	26Cr-4Ni-Mo	Smels. & welded pipe	...		
A/SA-790	S32906	S32906	109 (750)	10H	1	102	145	10.2	29Cr-6.5Ni-2Mo-N	Smels. & welded pipe	≥ 0.40 (10)		
A/SA-790	S32906	S32906	116 (800)	10H	1	102	145	10.2	29Cr-6.5Ni-2Mo-N	Smels. & welded pipe	<0.40 (10)		
A/SA-790	S32950	S32950	100 (690)	10H	1	102	145	10.2	26Cr-4Ni-Mo-N	Smels. & welded pipe	...		
A/SA-790	S39274	S39274	116 (800)	10H	1	102	145	10.2	25Cr-7Ni-3Mo-2W-Cu-N	Smels. & welded pipe	...		
A/SA-790	...	S82011	95 (655)	10H	1	102	145	10.3	22Cr-1.5Ni-Mo-N	Smels. & welded pipe	≥ 0.187 (5)		
A/SA-790	...	S82011	101 (700)	10H	1	102	145	10.3	22Cr-1.5Ni-Mo-N	Smels. & welded pipe	<0.187 (5)		
A/SA-790	...	S82441	99 (680)	10H	1	102	145	10.1	24Cr-4Ni-3Mn-1.5Mo-N	Smels. & welded pipe	≥ 0.40 (10)		
A/SA-790	...	S82441	107 (740)	10H	1	102	145	10.1	24Cr-4Ni-3Mn-1.5Mo-N	Smels. & welded pipe	<0.40 (10)		
A/SA-803	TP439	S43035	60 (415)	7	2	102	150	7.1	18Cr-Ti	Welded tube	...		
A/SA-803	26-3-3	S44660	85 (585)	10K	1	102	150	7.1	26Cr-3Ni-3Mo	Welded tube	...		
A/SA-813	N08367	N08367	95 (655)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Welded pipe	>0.187 (5)		
A/SA-813	N08367	N08367	100 (690)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Welded pipe	≤ 0.187 (5)		
A/SA-813	TPXM-19	S20910	100 (690)	8	3	102	130	8.3	22Cr-13Ni-5Mn	Welded pipe	...		
A/SA-813	TPXM-11	S21904	90 (620)	8	3	102	130	8.3	21Cr-6Ni-9Mn	Welded pipe	...		
A/SA-813	TPXM-29	S24000	100 (690)	8	3	102	130	8.3	18Cr-3Ni-12Mn	Welded pipe	...		
A/SA-813	TP304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Welded pipe	...		
A/SA-813	TP304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Welded pipe	...		
A/SA-813	TP304H	S30409	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Welded pipe	...		
A/SA-813	TP304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N	Welded pipe	...		
A/SA-813	TP304LN	S30453	75 (515)	8	1	102	130	8.1	18Cr-8Ni-N	Welded pipe	...		
A/SA-813	S30815	S30815	87 (600)	8	2	102	130	8.2	21Cr-11Ni-N	Welded pipe	...		
A/SA-813	TP309S	S30908	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Welded pipe	...		
A/SA-813	TP309Cb	S30940	75 (515)	8	2	102	130	8.2	23Cr-12Ni-Cb	Welded pipe	...		
A/SA-813	TP310S	S31008	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Welded pipe	...		
A/SA-813	TP310Cb	S31040	75 (515)	8	2	102	130	8.2	25Cr-20Ni-Cb	Welded pipe	...		
A/SA-813	S31254	S31254	94 (650)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Welded pipe	...		
A/SA-813	TP316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Welded pipe	...		
A/SA-813	TP316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Welded pipe	...		
A/SA-813	TP316H	S31609	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Welded pipe	...		
A/SA-813	TP316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Welded pipe	...		
A/SA-813	TP316LN	S31653	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Welded pipe	...		
A/SA-813	TP317	S31700	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Welded pipe	...		
A/SA-813	TP317L	S31703	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Welded pipe	...		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	AWS P-No.	B2.2 BM Group	ISO 15608 Nominal Composition			
Ferrous (Cont'd)											
A/SA-813	...	S32053	93 (640)	8	4	102	130	8.2	23Cr-25Ni-5.5Mo-N	Welded pipe	...
A/SA-813	TP321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Welded pipe	...
A/SA-813	TP321H	S32109	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Welded pipe	...
A/SA-813	TP347	S34700	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Welded pipe	...
A/SA-813	TP347H	S34709	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Welded pipe	...
A/SA-813	TP348	S34800	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Welded pipe	...
A/SA-813	TP348H	S34809	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Welded pipe	...
A/SA-813	TPXM-15	S38100	75 (515)	8	1	102	130	8.1	18Cr-18Ni-2Si	Welded pipe	...
A/SA-814	N08367	N08367	95 (655)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Cold worked welded pipe	>0.187 (5)
A/SA-814	N08367	N08367	100 (690)	45	...	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Cold worked welded pipe	≤0.187 (5)
A/SA-814	TPXM-19	S20910	100 (690)	8	3	102	130	8.3	22Cr-13Ni-5Mn	Cold worked welded pipe	...
A/SA-814	TPXM-11	S21904	90 (620)	8	3	102	130	8.3	21Cr-6Ni-9Mn	Cold worked welded pipe	...
A/SA-814	TPXM-29	S24000	100 (690)	8	3	102	130	8.3	18Cr-3Ni-12Mn	Cold worked welded pipe	...
A/SA-814	TP304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Cold worked welded pipe	...
A/SA-814	TP304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Cold worked welded pipe	...
A/SA-814	TP304H	S30409	75 (515)	8	1	102	130	8.1	18Cr-8Ni	Cold worked welded pipe	...
A/SA-814	TP304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N	Cold worked welded pipe	...
A/SA-814	TP304LN	S30453	75 (515)	8	1	102	130	8.1	18Cr-8Ni-N	Cold worked welded pipe	...
A/SA-814	S30815	S30815	87 (600)	8	2	102	130	8.2	21Cr-11Ni-N	Cold worked welded pipe	...
A/SA-814	TP309S	S30908	75 (515)	8	2	102	130	8.2	23Cr-12Ni	Cold worked welded pipe	...
A/SA-814	TP309Cb	S30940	75 (515)	8	2	102	130	8.2	23Cr-12Ni-Cb	Cold worked welded pipe	...
A/SA-814	TP310S	S31008	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Cold worked welded pipe	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)		
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group					
								Nominal Composition					
Ferrous (Cont'd)													
A/SA-814	TP310Cb	S31040	75 (515)	8	2	102	130	8.2	25Cr-20Ni-Cb	Cold worked welded pipe	...		
A/SA-814	S31254	S31254	94 (650)	8	4	102	130	8.2	20Cr-18Ni-6Mo	Cold worked welded pipe	...		
A/SA-814	TP316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Cold worked welded pipe	...		
A/SA-814	TP316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Cold worked welded pipe	...		
A/SA-814	TP316H	S31609	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Cold worked welded pipe	...		
A/SA-814	TP316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Cold worked welded pipe	...		
A/SA-814	TP316LN	S31653	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Cold worked welded pipe	...		
A/SA-814	TP317	S31700	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Cold worked welded pipe	...		
A/SA-814	TP317L	S31703	75 (515)	8	1	102	130	8.1	18Cr-13Ni-3Mo	Cold worked welded pipe	...		
A/SA-814	...	S32053	93 (640)	8	4	102	130	8.2	23Cr-25Ni-5.5Mo-N	Cold worked welded pipe	...		
A/SA-814	TP321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Cold worked welded pipe	...		
A/SA-814	TP321H	S32109	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti	Cold worked welded pipe	...		
A/SA-814	TP347	S34700	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Cold worked welded pipe	...		
A/SA-814	TP347H	S34709	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Cold worked welded pipe	...		
A/SA-814	TP348	S34800	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Cold worked welded pipe	...		
A/SA-814	TP348H	S34809	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb	Cold worked welded pipe	...		
A/SA-814	TPXM-15	S38100	75 (515)	8	1	102	130	8.1	18Cr-18Ni-2Si	Cold worked welded pipe	...		
A/SA-815	...	S31803	90 (620)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Fittings	...		
A/SA-815	...	S32101	94 (650)	10H	1	102	145	10.3	21Cr-5Mn-1.5Ni-Cu-N	Fittings	...		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	AWS	B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A/SA-815	...	S32202	94 (650)	10H	1	102	145	10.3	22Cr-2Ni-Mo-N	Fittings	...
A/SA-815	...	S32205	95 (655)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Fittings	...
A/SA-815	...	S32750	116 (800)	10H	1	102	145	10.2	25Cr-7Ni-4Mo-N	Fittings	...
A/SA-815	...	S32760	109 (750)	10H	1	102	145	10.2	25Cr-8Ni-3Mo-W-Cu-N	Fittings	...
A/SA-815	...	S41500	110 (760)	6	4	102	150	7.2	13Cr-4.5Ni-Mo	Fittings	...
A/SA-832	23V	...	85 (585)	5C	1	102	110	6.2	3Cr-1Mo-0.25V-Cb-Ca	Plate	...
A/SA-832	21V	K31830	85 (585)	5C	1	102	120	6.2	3Cr-1Mo-V-Ti-B	Plate	...
A/SA-832	22V	K31835	85 (585)	5C	1	102	110	6.2	2.25Cr-1Mo-V	Plate	...
A/SA-836	55 (380)	1	1	101	120	1.1	C-Si-Ti	Forgings	...
A/SA-841	A, Cl. 1	...	65 (450)	1	2	101	100	1.2	C-Mn-Si	Plate	>2.5 (65)
A/SA-841	A, Cl. 1	...	70 (485)	1	2	101	100	1.2	C-Mn-Si	Plate	≤2.5 (65)
A/SA-841	B, Cl. 2	...	75 (515)	1	3	101	100	1.3	C-Mn-Si	Plate	>2.5 (65)
A/SA-841	B, Cl. 2	...	80 (550)	1	3	101	100	1.3	C-Mn-Si	Plate	≤2.5 (65)
A/SA-841	F, Cl. 6	...	82 (565)	3	3	101	100	2.2	Mn-0.85Ni-0.30Cr-0.50Mo	Plate	...
A/SA-841	F, Cl. 7	...	86 (595)	3	3	101	100	2.2	Mn-0.85Ni-0.30Cr-0.50Mo	Plate	...
A859	A, Cl. 1	K20747	65 (450)	11C	1	101	100	3.3	1Ni-1Cu-0.75Cr-Mo-Nb	Forgings	...
A859	A, Cl. 2	K20747	75 (515)	11C	1	101	100	3.3	1Ni-1Cu-0.75Cr-Mo-Nb	Forgings	...
A860	WPHY 42	...	60 (415)	1	1	101	120	1.2	C-Mn	Smls. & welded fittings	...
A860	WPHY 46	...	63 (435)	1	1	101	120	1.2	C-Mn	Smls. & welded fittings	...
A860	WPHY 52	...	66 (455)	1	1	101	120	1.2	C-Mn	Smls. & welded fittings	...
A860	WPHY 60	...	75 (515)	1	2	101	120	1.3	C-Mn	Smls. & welded fittings	...
A860	WPHY 65	...	77 (530)	1	2	101	120	1.3	C-Mn	Smls. & welded fittings	...
A860	WPHY 70	...	80 (550)	1	3	101	120	1.3	C-Mn	Smls. & welded fittings	...
A890	4A	J92205	90 (620)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Castings	...
A890	2A	J93345	95 (655)	10H	1	102	145	10.2	24Cr-10Ni-Mo-N	Castings	...
A890	3A	J93371	95 (655)	10H	1	102	145	10.2	25Cr-5Ni-Mo-N	Castings	...
A890	1B	J93372	100 (690)	10H	1	102	145	10.2	25Cr-5Ni-Mo-Cu-N	Castings	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A890	1C	J93373	100 (690)	10H	1	102	145	10.2	25Cr-6Ni-Mo-Cu-N	Castings	...
A890	7A	J93379	100 (690)	10H	1	102	145	10.2	27Cr-7Ni-Mo-W-N	Castings	...
A890	6A	J93380	100 (690)	10H	1	102	145	10.2	25Cr-8Ni-3Mo-W-Cu-N	Castings	...
A890	5A	J93404	100 (690)	10H	1	102	145	10.2	25Cr-7Ni-Mo-N	Castings	...
A928	S31803	S31803	90 (620)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Welded pipe	...
A928	S32003	S32003	95 (655)	10H	1	102	145	10.3	21Cr-3.5Ni-Mo-N	Welded pipe	>0.187 (5)
A928	S32003	S32003	100 (690)	10H	1	102	145	10.3	21Cr-3.5Ni-Mo-N	Welded pipe	≤0.187 (5)
A928	2205	S32205	95 (655)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Welded pipe	...
A928	2304	S32304	87 (600)	10H	1	102	145	10.1	23Cr-4Ni-Mo-Cu-N	Welded pipe	...
A928	2507	S32750	116 (800)	10H	1	102	145	10.2	25Cr-7Ni-4Mo-N	Welded pipe	...
A928	...	S32760	108 (745)	10H	1	102	145	10.2	25Cr-8Ni-3Mo-W-Cu-N	Welded pipe	...
A/SA-965	FXM-19	S20910	100 (690)	8	3	102	130	8.3	22Cr-13Ni-5Mn	Forgings	...
A/SA-965	FXM-11	S21904	90 (620)	8	3	102	130	8.3	21Cr-6Ni-9Mn	Forgings	...
A/SA-965	F304	S30400	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Forgings	...
A/SA-965	F304L	S30403	65 (450)	8	1	102	130	8.1	18Cr-8Ni	Forgings	...
A/SA-965	F304H	S30409	70 (485)	8	1	102	130	8.1	18Cr-8Ni	Forgings	...
A/SA-965	F304N	S30451	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N	Forgings	...
A/SA-965	F304LN	S30453	70 (485)	8	1	102	130	8.1	18Cr-8Ni-N	Forgings	...
A/SA-965	F46	S30600	78 (540)	8	1	102	130	8.1	18Cr-15Ni-4Si	Forgings	...
A/SA-965	F310	S31000	75 (515)	8	2	102	130	8.2	25Cr-20Ni	Forgings	...
A/SA-965	F316	S31600	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Forgings	...
A/SA-965	F316L	S31603	65 (450)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Forgings	...
A/SA-965	F316H	S31609	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Forgings	...
A/SA-965	F316N	S31651	80 (550)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Forgings	...
A/SA-965	F316LN	S31653	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Forgings	...
A/SA-965	F321	S32100	70 (485)	8	1	102	140	8.1	18Cr-10Ni-Ti	Forgings	...
A/SA-965	F321H	S32109	70 (485)	8	1	102	140	8.1	18Cr-10Ni-Ti	Forgings	...
A/SA-965	F347	S34700	70 (485)	8	1	102	130	8.1	18Cr-10Ni-Cb	Forgings	...
A/SA-965	F347H	S34709	70 (485)	8	1	102	130	8.1	18Cr-10Ni-Cb	Forgings	...
A/SA-965	F348	S34800	70 (485)	8	1	102	130	8.1	18Cr-10Ni-Cb	Forgings	...
A/SA-965	F348H	S34809	70 (485)	8	1	102	130	8.1	18Cr-10Ni-Cb	Forgings	...
A992	65 (450)	1	1	101	100	1.2	C-Mn-Si	Shapes	...
A/SA-995	4A	J92205	90 (620)	10H	1	102	145	10.1	22Cr-5Ni-3Mo-N	Castings	...
A/SA-995	2A	J93345	95 (655)	10H	1	102	145	10.2	24Cr-10Ni-4Mo-N	Castings	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
A/SA-995	3A	J93371	95 (655)	10H	1	102	145	10.2	25Cr-5Ni-Mo-N	Castings	...
A/SA-995	1B	J93372	100 (690)	10H	1	102	145	10.2	25Cr-5Ni-3Mo-2Cu	Castings	...
A/SA-995	7A	J93379	100 (690)	10H	1	102	145	10.2	27Cr-7Ni-Mo-W-N	Castings	...
A/SA-995	6A	J93380	100 (690)	10H	1	102	145	10.2	25Cr-8Ni-3Mo-W-Cu-N	Castings	...
A/SA-995	5A	J93404	100 (690)	10H	1	102	145	10.2	25Cr-7Ni-4Mo-N	Castings	...
A/SA-1008	CS A	...	40 (275)	1	1	101	100	1.1	C	Sheet	...
A/SA-1008	CS B	...	40 (275)	1	1	101	100	1.1	C	Sheet	...
A/SA-1008	DS B	...	40 (275)	1	1	101	100	1.1	C	Sheet	...
A/SA-1010	40	S41003	66 (455)	7	1	102	150	7.2	12Cr-1Ni	Plate, sheet & strip	...
A/SA-1010	50	S41003	70 (485)	7	1	102	150	7.2	12Cr-1Ni	Plate, sheet & strip	...
A/SA-1011	CS B	...	40 (275)	1	1	101	100	1.1	C	Sheet & strip	...
A/SA-1011	DS B	...	40 (275)	1	1	101	100	1.1	C	Sheet & strip	...
A/SA-1011	HSLAS 45 Cl. 1	...	60 (415)	1	1	101	120	1.2	C	Sheet & strip	...
A/SA-1011	HSLAS 45 Cl. 2	...	55 (380)	1	1	101	120	1.2	C	Sheet & strip	...
A/SA-1011	HSLAS 50 Cl. 1	...	65 (450)	1	1	101	120	1.2	C	Sheet & strip	...
A/SA-1011	HSLAS 50 Cl. 2	...	60 (415)	1	1	101	120	1.2	C	Sheet & strip	...
A/SA-1011	HSLAS 55 Cl. 1	...	70 (485)	1	2	101	120	1.3	C	Sheet & strip	...
A/SA-1011	HSLAS 55 Cl. 2	...	65 (450)	1	1	101	120	1.3	C	Sheet & strip	...
A/SA-1011	HSLAS 60 Cl. 1	...	75 (515)	1	2	101	120	1.3	C	Sheet & strip	...
A/SA-1011	HSLAS 60 Cl. 2	...	70 (485)	1	2	101	120	1.3	C	Sheet & strip	...
A/SA-1011	SS 33	...	52 (360)	1	1	101	100	1.1	C	Sheet & strip	...
A/SA-1011	SS 36 1	...	53 (365)	1	1	101	100	1.1	C	Sheet & strip	...
A/SA-1011	SS 36 2	...	58 (400)	1	1	101	100	1.1	C	Sheet & strip	...
A/SA-1011	SS 40	...	55 (380)	1	1	101	100	1.2	C	Sheet & strip	...
A/SA-1011	SS 45	...	60 (415)	1	1	101	120	1.2	C	Sheet & strip	...
A/SA-1011	SS 50	...	65 (450)	1	1	101	100	1.2	C	Sheet & strip	...
A/SA-1011	SS 55	...	70 (485)	1	2	101	100	1.3	C	Sheet & strip	...
A/SA-1011	SS 60	...	75 (515)	1	2	101	100	1.3	C	Sheet & strip	...
A/SA-1017	92	K92460	90 (620)	15E	1	102	110	6.4	9Cr-2W	Plate	...
A1066	50	...	65 (450)	3	1	101	100	1.2	Mn-Ni-Cr-Mo	Plate	...
A1066	60	...	75 (515)	3	2	101	100	2.1	Mn-Ni-Cr-Mo	Plate	...
A1066	65	...	80 (550)	3	3	101	100	2.1	Mn-Ni-Cr-Mo	Plate	...
A1066	70	...	85 (585)	3	3	101	100	2.2	Mn-Ni-Cr-Mo	Plate	...
A1066	80	...	90 (620)	3	3	101	100	2.2	Mn-Ni-Cr-Mo	Plate	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)		
				Group	P-No.	AWS B2.2 BM No.	ISO 15608 Group						
							P-No.	B2.2 BM	Nominal Composition				
Ferrous (Cont'd)													
A1091	C91	J84090	85 (585)	15E	1	102	110	6.4	9Cr-1Mo-V	Castings	...		
API 5L	A	...	49 (340)	1	1	101	100	1.1	C-Mn	Smls. & welded pipe	...		
API 5L	A25	...	45 (310)	1	1	101	100	1.1	C-Mn	Smls. & welded pipe	...		
API 5L	A25P	...	45 (310)	1	1	101	100	1.1	C-Mn	Smls. & welded pipe	...		
API 5L	B	...	60 (415)	1	1	101	120	11.1	C-Mn	Smls. & welded pipe	...		
API 5L	BM	...	60 (415)	1	1	101	120	1.1	C-Mn	Welded pipe	...		
API 5L	BMO	...	60 (415)	1	1	101	120	1.1	C-Mn	Welded pipe	...		
API 5L	BMS	...	60 (415)	1	1	101	120	1.1	C-Mn	Welded pipe	...		
API 5L	BN	...	60 (415)	1	1	101	120	1.1	C-Mn	Smls. & welded pipe	...		
API 5L	BNO	...	60 (415)	1	1	101	120	1.1	C-Mn	Smls. & welded pipe	...		
API 5L	BNS	...	60 (415)	1	1	101	120	1.1	C-Mn	Smls. & welded pipe	...		
API 5L	BQ	...	60 (415)	1	1	101	120	1.1	C-Mn	Smls. & welded pipe	...		
API 5L	BQO	...	60 (415)	1	1	101	120	1.1	C-Mn	Smls. & welded pipe	...		
API 5L	BQS	...	60 (415)	1	1	101	120	1.1	C-Mn	Smls. & welded pipe	...		
API 5L	BR	...	60 (415)	1	1	101	120	1.1	C-Mn	Smls. & welded pipe	...		
API 5L	X42	...	60 (415)	1	1	101	120	11.1	C-Mn	Smls. & welded pipe	...		
API 5L	X42M	...	60 (415)	1	1	101	120	1.2	C-Mn	Welded pipe	...		
API 5L	X42MO	...	60 (415)	1	1	101	120	1.2	C-Mn	Welded pipe	...		
API 5L	X42MS	...	60 (415)	1	1	101	120	1.2	C-Mn	Welded pipe	...		
API 5L	X42N	...	60 (415)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...		
API 5L	X42NO	...	60 (415)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...		
API 5L	X42NS	...	60 (415)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...		
API 5L	X42Q	...	60 (415)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...		
API 5L	X42QO	...	60 (415)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...		
API 5L	X42QS	...	60 (415)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...		
API 5L	X42R	...	60 (415)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...		
API 5L	X46	...	63 (435)	1	1	101	120	11.1	C-Mn	Smls. & welded pipe	...		
API 5L	X46M	...	63 (435)	1	1	101	120	1.2	C-Mn	Welded pipe	...		
API 5L	X46MO	...	63 (435)	1	1	101	120	1.2	C-Mn	Welded pipe	...		
API 5L	X46MS	...	63 (435)	1	1	101	120	1.2	C-Mn	Welded pipe	...		
API 5L	X46N	...	63 (435)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...		
API 5L	X46NO	...	63 (435)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...		
API 5L	X46NS	...	63 (435)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...		
API 5L	X46Q	...	63 (435)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...		
API 5L	X46QO	...	63 (435)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...		
API 5L	X46QS	...	63 (435)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
API 5L	X52	...	67 (460)	1	1	101	120	11.1	C-Mn	Smls. & welded pipe	...
API 5L	X52M	...	67 (460)	1	1	101	120	1.2	C-Mn	Welded pipe	...
API 5L	X52MO	...	67 (460)	1	1	101	120	1.2	C-Mn	Welded pipe	...
API 5L	X52MS	...	67 (460)	1	1	101	120	1.2	C-Mn	Welded pipe	...
API 5L	X52N	...	67 (460)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...
API 5L	X52NO	...	67 (460)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...
API 5L	X52NS	...	67 (460)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...
API 5L	X52Q	...	67 (460)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...
API 5L	X52QO	...	67 (460)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...
API 5L	X52QS	...	67 (460)	1	1	101	120	1.2	C-Mn	Smls. & welded pipe	...
API 5L	X56	...	71 (490)	1	2	101	120	11.1	C-Mn	Smls. & welded pipe	...
API 5L	X56M	...	71 (490)	1	2	101	120	2.1	C-Mn	Welded pipe	...
API 5L	X56MO	...	71 (490)	1	2	101	120	2.1	C-Mn	Welded pipe	...
API 5L	X56MS	...	71 (490)	1	2	101	120	2.1	C-Mn	Welded pipe	...
API 5L	X56N	...	71 (490)	1	2	101	120	1.3	C-Mn	Smls. & welded pipe	...
API 5L	X56Q	...	71 (490)	1	2	101	120	3.1	C-Mn	Smls. & welded pipe	...
API 5L	X56QO	...	71 (490)	1	2	101	120	3.1	C-Mn	Smls. & welded pipe	...
API 5L	X56QS	...	71 (490)	1	2	101	120	3.1	C-Mn	Smls. & welded pipe	...
API 5L	X60	...	75 (515)	1	2	101	120	11.1	C-Mn	Smls. & welded pipe	...
API 5L	X60M	...	75 (515)	1	2	101	120	2.1	C-Mn	Welded pipe	...
API 5L	X60MO	...	75 (515)	1	2	101	120	2.1	C-Mn	Welded pipe	...
API 5L	X60MS	...	75 (515)	1	2	101	120	2.1	C-Mn	Welded pipe	...
API 5L	X60N	...	75 (515)	1	2	101	120	1.3	C-Mn	Smls. & welded pipe	...
API 5L	X60Q	...	75 (515)	1	2	101	120	3.1	C-Mn	Smls. & welded pipe	...
API 5L	X60QQ	...	75 (515)	1	2	101	120	3.1	C-Mn	Smls. & welded pipe	...
API 5L	X60QS	...	75 (515)	1	2	101	120	3.1	C-Mn	Smls. & welded pipe	...
API 5L	X65	...	78 (540)	1	2	101	120	11.1	C-Mn	Smls. & welded pipe	...
API 5L	X65M	...	78 (540)	1	2	101	120	2.1	C-Mn	Welded pipe	...
API 5L	X65MO	...	78 (540)	1	2	101	120	2.1	C-Mn	Welded pipe	...
API 5L	X65MS	...	78 (540)	1	2	101	120	2.1	C-Mn	Welded pipe	...
API 5L	X65Q	...	78 (540)	1	2	101	120	3.1	C-Mn	Smls. & welded pipe	...
API 5L	X65QO	...	78 (540)	1	2	101	120	3.1	C-Mn	Smls. & welded pipe	...
API 5L	X65QS	...	78 (540)	1	2	101	120	3.1	C-Mn	Smls. & welded pipe	...
API 5L	X70	...	83 (565)	1	3	101	120	11.1	C-Mn	Smls. & welded pipe	...
API 5L	X70M	...	83 (565)	1	3	101	120	2.2	C-Mn	Welded pipe	...
API 5L	X70MO	...	83 (565)	1	3	101	120	2.2	C-Mn	Welded pipe	...
API 5L	X70MS	...	83 (565)	1	3	101	120	2.2	C-Mn	Welded pipe	...

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
API 5L	X70Q	...	83 (565)	1	3	101	120	3.1	C-Mn	Smls. & welded pipe	...
API 5L	X70QO	...	83 (565)	1	3	101	120	3.1	C-Mn	Smls. & welded pipe	...
API 5L	X70QS	...	83 (565)	1	3	101	120	3.1	C-Mn	Smls. & welded pipe	...
API 5L	X80M	...	91 (625)	1	4	101	120	2.2	C-Mn	Welded pipe	...
API 5L	X80MO	...	91 (625)	1	4	101	120	2.2	C-Mn	Welded pipe	...
API 5L	X80Q	...	91 (625)	1	4	101	120	3.1	C-Mn	Smls. & welded pipe	...
API 5L	X80QQ	...	91 (625)	1	4	101	120	3.1	C-Mn	Smls. & welded pipe	...
AS 1448	K3	...	59.5 (410)	1	1	101	100	1.1	C-Si	Forgings	...
AS 1448	K4	...	72.5 (500)	1	2	101	100	11.2	C-Si	Forgings	...
AS 1448	K5	...	78 (540)	1	2	101	100	11.2	C-Mn-Si	Forgings	...
AS 1448	K6	...	87 (600)	1	3	101	100	11.2	C-Mn-Si	Forgings	...
AS 1448	K8	...	69.5 (480)	1	1	101	100	1.2	C-Mn-Si	Forgings	...
AS 1448	K9	...	78 (540)	1	2	101	100	1.2	C-Mn-Si	Forgings	...
AS 1448	K10	...	84 (580)	1	3	101	100	11.1	C-Mn-Si	Forgings	...
AS 1448	S1	...	58 (400)	1	1	101	100	1.1	C-Si	Forgings	...
AS 1448	S3	...	59.5 (410)	1	1	101	100	1.1	C-Si	Forgings	...
AS 1448	S4	...	72.5 (500)	1	2	101	100	11.2	C-Si	Forgings	...
AS 1448	S5	...	78 (540)	1	2	101	100	11.2	C-Mn	Forgings	...
AS 1448	S6	...	87 (600)	1	3	101	100	11.2	C-Mn	Forgings	...
AS or SA/AS 1548	PT430	...	62.5 (430)	1	1	101	100	1.1	C	Plate	...
AS or SA/AS 1548	PT460	...	66.5 (460)	1	1	101	100	1.1	C	Plate	...
AS or SA/AS 1548	PT490	...	71 (490)	1	2	101	100	1.2	C	Plate	...
AS 4728	200 L0	...	46.5 (320)	1	1	101	120	1.1	C-Mn	E.R.W. pipe	...
AS 4728	240 L0	...	55 (380)	1	1	101	120	1.1	C-Mn	E.R.W. pipe	...
AS 4728	290 L0	...	60 (415)	1	1	101	120	1.2	C-Mn	E.R.W. pipe	...
CSA or SA/CSA-G40.21	38W	...	60 (415)	1	1	101	100	1.1	C-Mn-Si	Plate, bar & shapes	...
CSA or SA/CSA-G40.21	44W	...	65 (450)	1	1	101	100	1.2	C-Mn-Si	Plate, bar & shapes	...
CSA or SA/CSA-G40.21	50W	...	65 (450)	1	1	101	100	1.2	C-Mn-Si	Plate, bar & shapes	...
CSA Z245.1	241	...	60 (415)	1	1	101	120	11.1	C-Mn	Smls. & welded pipe	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
CSA Z245.1	290	...	60 (415)	1	1	101	120	11.1	C-Mn	Smls. & welded pipe	...
CSA Z245.1	359	...	66 (455)	1	1	101	120	11.1	C-Mn	Smls. & welded pipe	...
CSA Z245.1	386	...	71 (490)	1	2	101	120	11.1	C-Mn	Smls. & welded pipe	...
CSA Z245.1	414	...	75 (515)	1	2	101	120	11.1	C-Mn	Smls. & welded pipe	...
CSA Z245.1	448	...	77 (530)	1	2	101	120	11.1	C-Mn	Smls. & welded pipe	...
CSA Z245.1	483	...	82 (565)	1	3	101	120	11.1	C-Mn	Smls. & welded pipe	...
CSA Z245.1	550	...	90 (620)	1	4	101	120	11.1	C-Mn	Smls. & welded pipe	...
CSA Z245.1	620	...	100 (690)	1	4	101	120	11.1	C-Mn	Smls. & welded pipe	...
CSA Z245.11	207	...	48 (330)	1	1	101	100	11.1	C-Mn	Fittings	...
CSA Z245.11	241	...	60 (415)	1	1	101	100	11.1	C-Mn	Fittings	...
CSA Z245.11	290	...	60 (415)	1	1	101	100	11.1	C-Mn	Fittings	...
CSA Z245.11	317	...	63 (435)	1	1	101	100	11.1	C-Mn	Fittings	...
CSA Z245.11	359	...	66 (455)	1	1	101	100	11.1	C-Mn	Fittings	...
CSA Z245.11	386	...	71 (490)	1	2	101	100	11.1	C-Mn	Fittings	...
CSA Z245.11	414	...	75 (515)	1	2	101	100	11.1	C-Mn	Fittings	...
CSA Z245.11	448	...	77 (530)	1	2	101	100	11.1	C-Mn	Fittings	...
CSA Z245.11	483	...	82 (565)	1	3	101	100	11.1	C-Mn	Fittings	...
CSA Z245.11	550	...	90 (620)	1	4	101	100	11.1	C-Mn	Fittings	...
CSA Z245.11	620	...	100 (690)	1	4	101	100	11.1	C-Mn	Fittings	...
CSA Z245.12	248	...	60 (415)	1	1	101	100	11.1	C-Mn	Flanges	...
CSA Z245.12	290	...	60 (415)	1	1	101	100	11.1	C-Mn	Flanges	...
CSA Z245.12	317	...	63 (435)	1	1	101	100	11.1	C-Mn	Flanges	...
CSA Z245.12	359	...	66 (455)	1	1	101	100	11.1	C-Mn	Flanges	...
CSA Z245.12	386	...	71 (490)	1	2	101	100	11.1	C-Mn	Flanges	...
CSA Z245.12	414	...	75 (515)	1	2	101	100	11.1	C-Mn	Flanges	...
CSA Z245.12	448	...	77 (530)	1	2	101	100	11.1	C-Mn	Flanges	...
CSA Z245.12	483	...	82 (565)	1	3	101	100	11.1	C-Mn	Flanges	...
CSA Z245.12	550	...	90 (620)	1	4	101	100	11.1	C-Mn	Flanges	...
CSA Z245.12	620	...	100 (690)	1	4	101	100	11.1	C-Mn	Flanges	...
EN or SA/EN 10025-2	S235JR	...	52 (360)	1	1	...	100	1.1	C	Plate	...
EN or SA/EN 10025-2	S275J2	...	55 (380)	1	1	101	100	1.1	C	Plate & shapes	>6 (150) ≤16 (400)
EN or SA/EN 10025-2	S275J2	...	58 (400)	1	1	101	100	1.1	C	Plate & shapes	>4 (100) ≤6 (150)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing					Typical Product Form	Nominal Thickness Limits, in. (mm)	
				P-No.	Group No.	AWS P-No.	B2.2 BM	ISO 15608 Group		Nominal Composition			
Ferrous (Cont'd)													
EN or SA/EN 10025-2	S275J2	...	59.5 (410)	1	1	101	100	1.1	C			Plate & shapes	≥0.125 (3) ≤4 (100)
EN or SA/EN 10025-2	S275J2	...	62.5 (430)	1	1	101	100	1.1	C			Plate & shapes	<0.125 (3)
EN or SA/EN 10025-2	S275JR	...	55 (380)	1	1	101	100	1.1	C			Plate & shapes	>6 (150) ≤16 (400)
EN or SA/EN 10025-2	S275JR	...	58 (400)	1	1	101	100	1.1	C			Plate & shapes	>4 (100) ≤6 (150)
EN or SA/EN 10025-2	S275JR	...	59.5 (410)	1	1	101	100	1.1	C			Plate & shapes	≥0.125 (3) ≤4 (100)
EN or SA/EN 10025-2	S275JR	...	62.5 (430)	1	1	101	100	1.1	C			Plate & shapes	<0.125 (3)
EN or SA/EN 10025-2	S355J2	...	65.5 (450)	1	2	101	100	1.2	C-Mn-Si			Plate & shapes	>4 (100) ≤16 (400)
EN or SA/EN 10025-2	S355J2	...	68 (470)	1	2	101	100	1.2	C-Mn-Si			Plate & shapes	≥0.125 (3) ≤4 (100)
EN or SA/EN 10025-2	S355J2	...	74 (510)	1	2	101	100	1.2	C-Mn-Si			Plate & shapes	<0.125 (3)
EN or SA/EN 10025-2	S355JR	...	65.5 (450)	1	2	101	100	1.2	C-Mn-Si			Plate & shapes	>4 (100) ≤16 (400)
EN or SA/EN 10025-2	S355JR	...	68 (470)	1	2	101	100	1.2	C-Mn-Si			Plate & shapes	≥0.125 (3) ≤4 (100)
EN or SA/EN 10025-2	S355JR	...	74 (510)	1	2	101	100	1.2	C-Mn-Si			Plate & shapes	<0.125 (3)
EN or SA/EN 10028-2	10CrMo9-10	...	65.5 (450)	5A	1	102	110	5.2	2.25Cr-1Mo			Plate	>6 (150) ≤10 (250)
EN or SA/EN 10028-2	10CrMo9-10	...	66.5 (460)	5A	1	102	110	5.2	2.25Cr-1Mo			Plate > 4 in. (100 mm)	>4 (100) ≤6 (150)
EN or SA/EN 10028-2	10CrMo9-10	...	68 (470)	5A	1	102	110	5.2	2.25Cr-1Mo			≤ 6 in. (150 mm)	>2.4 (60) ≤4 (100)
EN or SA/EN 10028-2	10CrMo9-10	...	69.5 (480)	5A	1	102	110	5.2	2.25Cr-1Mo			Plate	≤2.4 (60)

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing					Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	AWS P-No.	B2.2 BM Group	ISO 15608 Nominal Composition				
Ferrous (Cont'd)												
EN or SA/EN 10028-2	13CrMo4-5	...	61 (420)	4	1	102	110	5.1	1Cr-0.5Mo	Plate	>6 (150) ≤10 (250)	
EN or SA/EN 10028-2	13CrMo4-5	...	62.5 (430)	4	1	102	110	5.1	1Cr-0.5Mo	Plate	>4 (100) ≤6 (150)	
EN or SA/EN 10028-2	13CrMo4-5	...	64 (440)	4	1	102	110	5.1	1Cr-0.5Mo	Plate	>2.4 (60) ≤4 (100)	
EN or SA/EN 10028-2	13CrMo4-5	...	65.5 (450)	4	1	102	110	5.1	1Cr-0.5Mo	Plate	≤2.4 (60)	
EN or SA/EN 10028-2	13CrMoSi5-5+QT	...	71 (490)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Plate	>4 (100) ≤10 (250)	
EN or SA/EN 10028-2	13CrMoSi5-5+QT	...	72.5 (500)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Plate	>2.4 (60) ≤4 (100)	
EN or SA/EN 10028-2	13CrMoSi5-5+QT	...	74 (510)	4	1	102	110	5.1	1.25Cr-0.5Mo-Si	Plate	≤2.4 (60)	
EN or SA/EN 10028-2	P235GH	...	52 (360)	1	1	101	100	1.1	C-Mn	Plate	≤2.4 (60)	
EN or SA/EN 10028-2	P265GH	...	59.5 (410)	1	1	101	100	1.1	C-Mn	Plate	≤2.4 (60)	
EN or SA/EN 10028-2	P295GH	...	62.5 (430)	1	1	101	100	1.2	C-Mn-Si	Plate	>6 (150) ≤10 (250)	
EN or SA/EN 10028-2	P295GH	...	64 (440)	1	1	101	100	1.2	C-Mn-Si	Plate	>4 (100) ≤6 (150)	
EN or SA/EN 10028-2	P295GH	...	66.5 (460)	1	1	101	100	1.2	C-Mn-Si	Plate	≤4 (100)	
EN or SA/EN 10028-2	P355GH	...	68 (470)	1	2	101	100	1.2	C-Mn-Si	Plate	>6 (150) ≤10 (250)	
EN or SA/EN 10028-2	P355GH	...	69.5 (480)	1	2	101	100	1.2	C-Mn-Si	Plate	>4 (100) ≤6 (150)	
EN or SA/EN 10028-2	P355GH	...	71 (490)	1	2	101	100	1.2	C-Mn-Si	Plate	>2.4 (60) ≤4 (100)	
EN or SA/EN 10028-2	P355GH	...	74 (510)	1	2	101	100	1.2	C-Mn-Si	Plate	≤2.4 (60)	
EN or SA/EN 10028-3	P275NH	...	51 (350)	1	1	101	100	1.1	C	Plate	>6 (150) ≤10 (250)	
EN or SA/EN 10028-3	P275NH	...	52 (360)	1	1	101	100	1.1	C	Plate	>4 (100) ≤6 (150)	

Table QW/QB-422 Ferrous and Nonferrous P-Numbers Grouping of Base Metals for Qualification (Cont'd)											
Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing				Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	AWS B2.2 BM	ISO 15608 Group	Nominal Composition		
Ferrous (Cont'd)											
EN or SA/EN 10028-3	P275NH	...	53.5 (370)	1	1	101	100	1.1	C	Plate	>2 (50) ≤4 (100)
EN or SA/EN 10028-3	P275NH	...	56.5 (390)	1	1	101	100	1.1	C	Plate	≤2 (50)
EN or SA/EN 10028-3	P355NH	...	65.5 (450)	1	2	101	120	1.2	C-Mn-Si	Plate	>6 (150) ≤10 (250)
EN or SA/EN 10028-3	P355NH	...	66.5 (460)	1	2	101	120	1.2	C-Mn-Si	Plate	>4 (100) ≤6 (150)
EN or SA/EN 10028-3	P355NH	...	68 (470)	1	2	101	120	1.2	C-Mn-Si	Plate	>2.4 (60) ≤4 (100)
EN or SA/EN 10028-3	P355NH	...	71 (490)	1	2	101	120	1.2	C-Mn-Si	Plate	≤2.4 (60)
EN or SA/EN 10028-3	P355NL2	...	65 (450)	1	2	101	120	1.2	C-Mn	Plate	>6 (150) ≤10 (250)
EN or SA/EN 10028-3	P355NL2	...	67 (460)	1	2	101	120	1.2	C-Mn	Plate	>4 (100) ≤6 (150)
EN or SA/EN 10028-3	P355NL2	...	68 (470)	1	2	101	120	1.2	C-Mn	Plate	>2.4 (60) ≤4 (100)
EN or SA/EN 10028-3	P355NL2	...	71 (490)	1	2	101	120	1.2	C-Mn	Plate	≤2.4 (60)
EN or SA/EN 10028-4	X7Ni9	...	98.5 (680)	11A	1	...	100	9.3	9Ni	Plate	...
EN or SA/EN 10028-4	X8Ni9	...	93 (640)	11A	1	...	100	9.3	9Ni	Plate	...
EN or SA/EN 10028-7	X2CrNi18-9	...	72.5 (500)	8	1	102	130	8.1	18Cr-8Ni	Plate	...
EN or SA/EN 10028-7	X2CrNiMo17-12-2	...	75.5 (520)	8	1	102	130	8.1	16Cr-12Ni-2Mo	Plate	...
EN or SA/EN 10028-7	X2CrNiMoN17-11-2	...	84 (580)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Plate	...
EN or SA/EN 10028-7	X2CrNiMoN17-13-3	...	84 (580)	8	1	102	130	8.1	16Cr-12Ni-2Mo-N	Plate	...
EN or SA/EN 10028-7	X2CrNiN18-10	...	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N	Plate	...
EN or SA/EN 10028-7	X5CrNi18-10	...	75.5 (520)	8	1	102	130	8.1	18Cr-8Ni	Plate	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing					Typical Product Form	Nominal Thickness Limits, in. (mm)	
				P-No.	Group No.	AWS P-No.	B2.2 BM Group	ISO 15608 Nominal Composition					
Ferrous (Cont'd)													
EN or SA/EN 10028-7	X5CrNiMo17-12-2	...	75.5 (520)	8	1	102	130	8.1	16Cr-12Ni-2Mo		Plate	...	
EN or SA/EN 10028-7	X5CrNi19-9	...	80 (550)	8	1	102	130	8.1	18Cr-8Ni-N		Plate	...	
EN or SA/EN 10028-7	X6CrNiTi18-10	...	72.5 (500)	8	1	102	130	8.1	18Cr-10Ni-Ti		Plate	...	
EN or SA/EN 10088-2	X6CrNiMoTi17-12-2	...	78.5 (540)	8	1	...	130	8.1	16Cr-12Ni-2Mo-Ti		Plate, sheet & strip	...	
EN or SA/EN 10216-2	10CrMo9-10	...	69.5 (480)	5A	1	...	110	5.2	2.25Cr-1Mo		Smls. tube	...	
EN or SA/EN 10216-2	13CrMo4-5	...	64 (440)	4	1	...	110	5.1	1Cr-0.5Mo		Smls. tube	...	
EN or SA/EN 10216-2	16Mo3	...	65.5 (450)	3	1	...	100	1.1	C-0.5Mo		Smls. tube	...	
EN or SA/EN 10216-2	P235GH	...	52 (360)	1	1	...	100	1.1	C		Smls. tube	...	
EN or SA/EN 10216-2	P265GH	...	59.5 (410)	1	1	...	100	1.1	C		Smls. tube	...	
EN or SA/EN 10216-2	X10CrMoVNb9-1	...	91.5 (630)	15E	1	...	110	6.4	9Cr-1Mo-V		Smls. tube	...	
EN or SA/EN 10217-1	P235TR2	...	52 (360)	1	1	...	100	1.1	C		E.R.W. tube	...	
EN or SA/EN 10222-2	11CrMo9-10	...	65.5 (450)	5A	1	102	110	5.2	2.25Cr-1Mo		Forgings	>8 (200) ≤20 (500)	
EN or SA/EN 10222-2	11CrMo9-10	...	75.5 (520)	5A	1	102	110	5.2	2.25Cr-1Mo		Forgings	≤8 (200)	
EN or SA/EN 10222-2	13CrMo4-5	...	61 (420)	4	1	102	110	5.1	1Cr-0.5Mo		Forgings	>10 (250) ≤20 (500)	
EN or SA/EN 10222-2	13CrMo4-5	...	64 (440)	4	1	102	110	5.1	1Cr-0.5Mo		Forgings	≤10 (250)	
EN or SA/EN 10222-2	P280GH	...	66.5 (460)	1	1	101	100	1.2	C-Mn-Si		Forgings	...	
EN or SA/EN 10222-2	P305GH	...	71 (490)	1	2	101	100	1.2	C-Mn-Si		Forgings	...	

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing					Typical Product Form	Nominal Thickness Limits, in. (mm)		
				Group P-No.	Group No.	AWS B2.2 BM			ISO 15608 Group					
						P-No.	B2.2 BM	Group	Nominal	Composition				
Ferrous (Cont'd)														
EN or SA/EN 10222-2	X10CrMoVNb9-1	...	91.5 (630)	15E	1	102	110	6.4	9Cr-1Mo-V		Forgings	...		
GB or SA/GB 713	15CrMoR	...	64 (440)	4	1	101	110	5.1	1Cr-0.5Mo		Plate	>4 (100) ≤6 (150)		
GB or SA/GB 713	15CrMoR	...	65 (450)	4	1	101	110	5.1	1Cr-0.5Mo		Plate	>0.25 (6) ≤4 (100)		
GB or SA/GB 713	Q345R	...	68 (470)	1	1	101	100	1.1	C-Mn		Plate	>6 (150) ≤10 (250)		
GB or SA/GB 713	Q345R	...	69.5 (480)	1	1	101	100	1.2	C-Mn		Plate	>4 (100) ≤6 (150)		
GB or SA/GB 713	Q345R	...	71 (490)	1	2	101	100	1.2	C-Mn		Plate	>1.4 (36) ≤4 (100)		
GB or SA/GB 713	Q345R	...	72.5 (500)	1	2	101	100	1.2	C-Mn		Plate	>0.65 (16) ≤1.4 (36)		
GB or SA/GB 713	Q345R	...	74 (510)	1	2	101	100	1.2	C-Mn		Plate	>0.125 (3) ≤0.65 (16)		
GB or SA/GB 713	Q370R	...	75.5 (520)	1	2	101	100	1.2	C		Plate	>1.4 (36) ≤2.4 (60)		
GB or SA/GB 713	Q370R	...	77 (530)	1	2	101	100	1.2	C		Plate	>0.65 (16) ≤1.4 (36)		
GB or SA/GB 713	Q370R	...	77 (530)	1	2	101	100	1.3	C		Plate	>0.375 (10) ≤0.65 (16)		
IS or SA/IS 2062	E250 A	...	59.5 (410)	1	1	101	100	1.1	C-Mn-Si		Plate, bars & shapes	...		
IS or SA/IS 2062	E250 B	...	59.5 (410)	1	1	101	100	1.1	C-Mn-Si		Plate, bars & shapes	...		
IS or SA/IS 2062	E250 C	...	59.5 (410)	1	1	101	100	1.1	C-Mn-Si		Plate, bars & shapes	...		
JIS or SA/JIS G3118	SGV480	...	70 (485)	1	2	101	100	1.2	C-Mn-Si		Plate	...		
JIS or SA/JIS G4303	SUS 302	S30200	75 (515)	8	1	102	130	8.1	18Cr-8Ni		Bars & shapes	...		
JIS or SA/JIS G4303	SUS 304	S30400	75 (515)	8	1	102	130	8.1	18Cr-8Ni		Bars & shapes	...		
JIS or SA/JIS G4303	SUS 304L	S30403	70 (485)	8	1	102	130	8.1	18Cr-8Ni		Bars & shapes	...		
JIS or SA/JIS G4303	SUS 309S	S30908	75 (515)	8	2	102	130	8.2	23Cr-12Ni		Bars & shapes	...		
JIS or SA/JIS G4303	SUS 310S	S31008	75 (515)	8	2	102	130	8.2	25Cr-20Ni		Bars & shapes	...		
JIS or SA/JIS G4303	SUS 316	S31600	75 (515)	8	1	102	130	8.1	16Cr-12Ni-2Mo		Bars & shapes	...		
JIS or SA/JIS G4303	SUS 316L	S31603	70 (485)	8	1	102	130	8.1	16Cr-12Ni-2Mo		Bars & shapes	...		
JIS or SA/JIS G4303	SUS 321	S32100	75 (515)	8	1	102	140	8.1	18Cr-10Ni-Ti		Bars & shapes	...		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Designation, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Welding		Brazing		AWS B2.2 BM	ISO 15608 Group	Nominal Composition	Typical Product Form	Nominal Thickness Limits, in. (mm)
				P-No.	Group No.	P-No.	No.					
Ferrous (Cont'd)												
JIS or SA/JIS G4303	SUS 347	S34700	75 (515)	8	1	102	130	8.1	18Cr-10Ni-Cb		Bars & shapes	...
JIS or SA/JIS G4303	SUS 405	S40500	60 (415)	7	1	102	160	7.1	12Cr-Al		Bars & shapes	...
MSS SP-75	WPHY-42	...	60 (415)	1	1	101	120	11.1	C-Mn		Smls. & welded fittings	...
MSS SP-75	WPHY-46	...	63 (435)	1	1	101	120	11.1	C-Mn		Smls. & welded fittings	...
MSS SP-75	WPHY-52	...	66 (455)	1	1	101	120	11.1	C-Mn		Smls. & welded fittings	...
MSS SP-75	WPHY-56	...	71 (490)	1	2	101	120	11.1	C-Mn		Smls. & welded fittings	...
MSS SP-75	WPHY-60	...	75 (515)	1	2	101	120	11.1	C-Mn		Smls. & welded fittings	...
MSS SP-75	WPHY-65	...	77 (530)	1	2	101	120	11.1	C-Mn		Smls. & welded fittings	...
MSS SP-75	WPHY-70	...	82 (565)	1	3	101	120	11.1	C-Mn		Smls. & welded fittings	...
NF or SA/NFA 36-215	P440 NJ4	...	91.5 (630)	10A	1	101	100	4.1	Mn-0.5Ni-V		Plate	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing			ISO 15608			Typical Product Form	Thickness Limits, Nominal in. (mm)	
					P-No.	AWS B2.2 BM	Group	Nominal Composition					
Nonferrous													
A/SA-182	F58	S31266	109 (750)	45	102	420	8.2	24Cr-22Ni-6Mo-3Mn-Cu-W-N			Forgings	...	
A/SA-240	...	S31266	109 (750)	45	102	420	8.2	24Cr-22Ni-6Mo-3Mn-Cu-W-N			Plate, sheet & strip	...	
A/SA-240	...	S31277	112 (770)	45	111	420	8.2	27Ni-22Cr-7Mo-Mn-Cu			Plate, sheet & strip	...	
A/SA-351	CN3MN	J94651	80 (550)	45	111	420	8.2	46Fe-24Ni-21Cr-6Mo-Cu-N			Castings	...	
A/SA-351	CN7M	N08007	62 (425)	45	111	420	8.2	28Ni-19Cr-Cu-Mo			Castings	...	
A/SA-351	CT15C	N08151	63 (435)	45	111	420	45	32Ni-45Fe-20Cr-Cb			Castings	...	
A/SA-351	HT30	N08603	65 (450)	45	111	420	45	35Ni-15Cr-0.5Mo			Castings	...	
A/SA-358	...	S31266	109 (750)	45	102	420	8.2	24Cr-22Ni-6Mo-3Mn-Cu-W-N			Fusion welded pipe	...	
A/SA-494	M35-2	N04020	65 (450)	42	110	400	42	67Ni-30Cu-Fe-Si			Castings	...	
A/SA-494	CY40	N06040	70 (485)	43	111	420	43	72Ni-15Cr-8Fe-Si			Castings	...	
A/SA-494	CU5MCuC	N08826	75 (515)	45	111	420	45	42Ni-21.5Cr-3Mo-2.3Cu			Castings	...	
A/SA-494	M30C	N24130	65 (450)	42	110	400	42	67Ni-30Cu-2Fe-Cb			Castings	...	
A/SA-494	M35-1	N24135	65 (450)	42	110	400	42	67Ni-30Cu-2Fe-Cb			Castings	...	
A/SA-494	CX2MW	N26022	80 (550)	43	111	420	43	59Ni-22Cr-14Mo-4Fe-3W			Castings	...	
A/SA-494	CW2M	N26455	72 (495)	43	111	420	43	66Ni-16Mo-16Cr-Fe-W			Castings	...	
A/SA-494	CW6MC	N26625	70 (485)	43	111	420	43	60Ni-21.5Cr-9Mo-4Cb-Fe			Castings	...	
A/SA-494	N7M	N30007	76 (525)	44	112	410	44	65Ni-31.5Mo-1.5Fe-Cr			Castings	...	
A/SA-494	CW6M	N30107	72 (495)	44	112	420	44	56Ni-19Mo-18Cr-2Fe			Castings	...	
B16	...	C36000	40 (275)	...	107	320	NA	65Cu-Zn-3Pb			Bar	>1 (25) dia.	
B16	...	C36000	44 (305)	...	107	320	NA	65Cu-Zn-3Pb			Bar	≤1 (25) dia.	
B16	...	C36000	40 (275)	...	107	320	NA	65Cu-Zn-3Pb			Rod	>2 (50) dia.	
B16	...	C36000	44 (305)	...	107	320	NA	65Cu-Zn-3Pb			Rod	>1 (25) ≤2 (50) dia.	
B16	...	C36000	48 (330)	...	107	320	NA	65Cu-Zn-3Pb			Rod	≤1 (25) dia.	
B16.18	...	C83600	30 (205)	...	107	320	NA	5Sn-5Zn-5Pb			Cast fittings	...	
B16.18	...	C83800	30 (205)	...	107	320	NA	4Sn-6.5Zn-6Pb			Cast fittings	...	
B16.18	...	C84400	29 (200)	...	107	320	NA	2.5Sn-8.5Zn-7Pb			Cast fittings	...	
B16.22	...	C10200	30 (205)	...	107	300	NA	99.95Cu-P			Wrought piping fittings	...	
B16.22	...	C12000	30 (205)	...	107	300	NA	99.9Cu-P			Wrought piping fittings	...	
B16.22	...	C12200	30 (205)	...	107	300	NA	99.9Cu-P			Wrought piping fittings	...	

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing		ISO 15608		Typical Product Form	Thickness Limits, Nominal in. (mm)
					AWS P-No.	B2.2 BM	Group	Nominal Composition		
Nonferrous (Cont'd)										
B16.22	...	C23000	40 (275)	...	107	300	NA	85Cu-15Zn	Wrought piping fittings	...
B16.50	...	C10200	30 (205)	...	107	300	NA	99.95Cu-P	Wrought piping fittings	...
B16.50	...	C12000	30 (205)	...	107	300	NA	99.9Cu-P	Wrought piping fittings	...
B16.50	...	C12200	30 (205)	...	107	300	NA	99.9Cu-P	Wrought piping fittings	...
B16.50	...	C23000	40 (275)	...	107	300	NA	85Cu-15Zn	Wrought piping fittings	...
B/SB-26	T6	A03560	30 (205)	26	...	210	24.2	Al-Si-Mg	Castings	...
	T71	A03560	25 (170)	26	...	210	24.2	Al-Si-Mg	Castings	...
	...	A24430	17 (115)	26	...	210	24.1	Al-Si	Castings	...
B/SB-42	...	C10200	30 (205)	31	107	300	31	99.95Cu-P	Smls. pipe	...
B/SB-42	...	C12000	30 (205)	31	107	300	31	99.9Cu-P	Smls. pipe	...
B/SB-42	...	C12200	30 (205)	31	107	300	31	99.9Cu-P	Smls. pipe	...
B/SB-43	...	C23000	40 (275)	32	107	300	32.1	85Cu-15Zn	Smls. pipe	...
B/SB-61	...	C92200	30 (205)	...	107	320	NA	88Cu-Sn-Zn-Pb	Castings	...
B/SB-62	...	C83600	30 (205)	...	107	320	NA	85Cu-5Sn-5Zn-5Pb	Castings	...
B68	...	C10200	30 (205)	31	107	300	31	99.95Cu-P	Tube	...
B68	...	C12000	30 (205)	31	107	300	31	99.9Cu-P	Tube	...
B68	...	C12200	30 (205)	31	107	300	31	99.9Cu-P	Tube	...
B/SB-75	...	C10200	30 (205)	31	107	300	31	99.95Cu-P	Smls. tube	...
B/SB-75	...	C12000	30 (205)	31	107	300	31	99.9Cu-P	Smls. tube	...
B/SB-75	...	C12200	30 (205)	31	107	300	31	99.9Cu-P	Smls. tube	...
B88	...	C10200	30 (205)	31	107	300	31	99.95Cu-P	Tube	...
B88	...	C12000	30 (205)	31	107	300	31	99.9Cu-P	Tube	...
B88	...	C12200	30 (205)	31	107	300	31	99.9Cu-P	Tube	...
B/SB-96	...	C65500	50 (345)	33	107	330	37	97Cu-3Si	Plate, sheet, strip & bar	...

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing				ISO 15608			Typical Product Form	Thickness Limits, Nominal in. (mm)		
					AWS		Group	Nominal Composition							
					P-No.	B2.2 BM									
Nonferrous (Cont'd)															
B/SB-98	...	C65100	40 (275)	33	107	330	37	98.5Cu-1.5Si		Rod, bar & shapes		...			
B/SB-98	...	C65500	52 (360)	33	107	330	37	97Cu-3Si		Rod, bar & shapes		...			
B/SB-98	...	C66100	52 (360)	33	107	330	37	94Cu-3Si		Rod, bar & shapes		...			
B/SB-111	...	C10200	30 (205)	31	107	300	31	99.95Cu-P		Smls. tube		...			
B/SB-111	...	C12000	30 (205)	31	107	300	31	99.9Cu-P		Smls. tube		...			
B/SB-111	...	C12200	30 (205)	31	107	300	31	99.9Cu-P		Smls. tube		...			
B/SB-111	...	C14200	30 (205)	31	107	300	31	99.4Cu-As-P		Smls. tube		...			
B/SB-111	...	C19200	38 (260)	31	107	300	31	99.7Cu-Fe-P		Smls. tube		...			
B/SB-111	...	C23000	40 (275)	32	107	300	32.1	85Cu-15Zn		Smls. tube		...			
B/SB-111	...	C28000	50 (345)	32	107	300	32.1	60Cu-40Zn		Smls. tube		...			
B/SB-111	...	C44300	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06As		Smls. tube		...			
B/SB-111	...	C44400	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06Sb		Smls. tube		...			
B/SB-111	...	C44500	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06P		Smls. tube		...			
B/SB-111	...	C60800	50 (345)	35	108	360	35	95Cu-5Al		Smls. tube		...			
B/SB-111	...	C68700	50 (345)	32	108	350	32.2	78Cu-20Zn-2Al		Smls. tube		...			
B/SB-111	...	C70400	38 (260)	34	107	300	34	95Cu-5Ni		Smls. tube		...			
B/SB-111	...	C70600	40 (275)	34	107	300	34	90Cu-10Ni		Smls. tube		...			
B/SB-111	...	C70620	40 (275)	34	107	300	34	90Cu-10Ni		Smls. tube		...			
B/SB-111	...	C71000	45 (310)	34	107	300	34	80Cu-20Ni		Smls. tube		...			
B/SB-111	...	C71500	52 (360)	34	107	300	34	70Cu-30Ni		Smls. tube		...			
B/SB-111	...	C71520	52 (360)	34	107	300	34	70Cu-30Ni		Smls. tube		...			
B/SB-111	...	C72200	45 (310)	34	107	300	34	80Cu-16Ni-0.75Fe-0.5Cr		Smls. tube		...			
B/SB-127	...	N04400	70 (485)	42	110	400	42	67Ni-30Cu		Plate, sheet & strip		...			
B/SB-135	...	C23000	40 (275)	32	107	300	32.1	85Cu-15Zn		Smls. tube		...			
B/SB-148	...	C95200	65 (450)	35	108	360	35	88Cu-9Al-3Fe		Castings		...			
B/SB-148	...	C95300	65 (450)	35	108	360	35	89Cu-10Al-1Fe		Castings		...			
B/SB-148	...	C95400	75 (515)	35	108	360	35	85Cu-11Al-4Fe		Castings		...			
B/SB-148	...	C95500	90 (620)	35	108	360	35	82Cu-11Al-4Fe-3Mn		Castings		...			
B/SB-148	...	C95600	60 (415)	35	108	360	35	90Cu-7Al-3Si		Castings		...			
B/SB-148	...	C95800	85 (585)	35	108	360	35	81Cu-9Al-5Ni-4Fe-1Mn		Castings		...			
B/SB-148	...	C95820	94 (650)	35	108	360	35	81Cu-9Al-5Ni-5Fe-1Mn		Castings		...			
B/SB-150	...	C61400	70 (485)	35	108	360	35	90Cu-7Al-3Fe		Rod & bar		...			
B/SB-150	...	C62300	75 (515)	35	108	360	35	88Cu-9Al-3Fe		Rod (round)		...			

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing			ISO 15608 Group	Nominal Composition	Typical Product Form	Thickness Limits, Nominal in. (mm)
					P-No.	AWS B2.2 BM	Group				
Nonferrous (Cont'd)											
B/SB-150	...	C63000	85 (585)	35	108	360	35		81Cu-10Al-5Ni-3Fe	Rod & bar	...
B/SB-150	...	C64200	70 (485)	35	108	360	35		91Cu-7Al-2Si	Rod & bar	...
B/SB-151	...	C70600	38 (260)	34	107	300	34		90Cu-10Ni	Rod & bar	...
B/SB-151	...	C70620	38 (260)	34	107	300	34		90Cu-10Ni	Rod & bar	...
B/SB-152	...	C10200	30 (205)	31	107	300	31		99.95Cu-P	Plate, sheet, strip & bar	...
B/SB-152	...	C10400	30 (205)	31	107	300	31		99.95Cu + Ag	Plate, sheet, strip & bar	...
B/SB-152	...	C10500	30 (205)	31	107	300	31		99.95Cu + Ag	Plate, sheet, strip & bar	...
B/SB-152	...	C10700	30 (205)	31	107	300	31		99.95Cu + Ag	Plate, sheet, strip & bar	...
B/SB-152	...	C11000	30 (205)	31	107	300	31		99.90Cu	Plate, sheet, strip & bar	...
B/SB-152	...	C12200	30 (205)	31	107	300	31		99.9Cu-P	Plate, sheet, strip & bar	...
B/SB-152	...	C12300	30 (205)	31	107	300	31		99.9Cu-P	Plate, sheet, strip & bar	...
B/SB-152	...	C14200	30 (205)	31	107	300	31		99.4Cu-As-P	Plate, sheet, strip & bar	...
B/SB-160	...	N02200	55 (380)	41	110	400	41		99.0Ni	Rod & bar	...
B/SB-160	...	N02201	50 (345)	41	110	400	41		99.0Ni-Low C	Rod & bar	...
B/SB-161	...	N02200	55 (380)	41	110	400	41		99.0Ni	Smls. pipe & tube	...
B/SB-161	...	N02201	50 (345)	41	110	400	41		99.0Ni-Low C	Smls. pipe & tube	...
B/SB-162	...	N02200	55 (380)	41	110	400	41		99.0Ni	Plate, sheet & strip	...
B/SB-162	...	N02201	50 (345)	41	110	400	41		99.0Ni-Low C	Plate, sheet & strip	...
B/SB-163	...	N02200	55 (380)	41	110	400	41		99.0Ni	Smls. tube	...
B/SB-163	...	N02201	50 (345)	41	110	400	41		99.0Ni-Low C	Smls. tube	...
B/SB-163	...	N04400	70 (485)	42	110	400	42		67Ni-30Cu	Smls. tube	...
B/SB-163	...	N06025	98 (675)	43	111	420	43		63Ni-25Cr-10Fe-2Al-Ti-Y-Zr	Smls. tube	...
B/SB-163	...	N06600	80 (550)	43	111	420	43		72Ni-15Cr-8Fe	Smls. tube	...
B/SB-163	...	N06601	80 (550)	43	111	420	43		60Ni-23Cr-12Fe-Al	Smls. tube	...
B/SB-163	...	N06690	85 (585)	43	111	420	43		58Ni-29Cr-9Fe	Smls. tube	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing		ISO 15608		Typical Product Form	Thickness Limits, Nominal in. (mm)
					AWS P-No.	B2.2 BM	Group	Nominal Composition		
Nonferrous (Cont'd)										
B/SB-163	...	N08120	90 (620)	45	111	430	45	37Ni-33Fe-25Cr	Smls. tube	...
B/SB-163	...	N08800	75 (515)	45	111	430	45	33Ni-42Fe-21Cr	Smls. tube	...
B/SB-163	...	N08801	65 (450)	45	111	430	45	32Ni-45Fe-20.5Cr-Ti	Smls. tube	...
B/SB-163	...	N08810	65 (450)	45	111	430	45	33Ni-42Fe-21Cr	Smls. tube	...
B/SB-163	...	N08811	65 (450)	45	111	430	45	33Ni-42Fe-21Cr-Al-Ti	Smls. tube	...
B/SB-163	...	N08825	85 (585)	45	111	430	45	42Ni-21.5Cr-3Mo-2.3Cu	Smls. tube	...
B/SB-164	...	N04400	70 (485)	42	110	400	42	67Ni-30Cu	Rod, bar & wire	...
B/SB-164	...	N04405	70 (485)	42	110	400	42	67Ni-30Cu	Rod, bar & wire	...
B/SB-165	...	N04400	70 (485)	42	110	400	42	67Ni-30Cu	Smls. pipe & tube	...
B/SB-166	...	N06025	98 (675)	43	111	420	43	63Ni-25Cr-10Fe-2Al-Ti-Y-Zr	Rod, bar & wire	...
B/SB-166	...	N06045	90 (620)	46	111	420	45	46Ni-27Cr-23Fe-2.75Si	Rod, bar & wire	...
B/SB-166	...	N06600	80 (550)	43	111	420	43	72Ni-15Cr-8Fe	Rod, bar & wire	...
B/SB-166	...	N06601	80 (550)	43	111	420	43	60Ni-23Cr-12Fe-Al	Rod, bar & wire	...
B/SB-166	...	N06617	95 (655)	43	111	420	46	52Ni-22Cr-13Co-9Mo	Rod, bar & wire	...
B/SB-166	...	N06690	85 (585)	43	111	420	43	58Ni-29Cr-9Fe	Rod, bar & wire	...
B/SB-167	...	N06025	98 (675)	43	111	420	43	63Ni-25Cr-10Fe-2Al-Ti-Y-Zr	Smls. pipe & tube	...
B/SB-167	...	N06045	90 (620)	46	111	420	45	46Ni-27Cr-23Fe-2.75Si	Smls. pipe & tube	...
B/SB-167	...	N06600	75 (515)	43	111	420	43	72Ni-15Cr-8Fe	Smls. pipe & tube	...
B/SB-167	...	N06601	80 (550)	43	111	420	43	60Ni-23Cr-12Fe-Al	Smls. pipe & tube	...
B/SB-167	...	N06617	95 (655)	43	111	420	46	52Ni-22Cr-13Co-9Mo	Smls. pipe & tube	...
B/SB-167	...	N06690	75 (515)	43	111	420	43	58Ni-29Cr-9Fe	Smls. pipe & tube	...
B/SB-168	...	N06025	98 (675)	43	111	420	43	63Ni-25Cr-10Fe-2Al-Ti-Y-Zr	Plate, sheet & strip	...
B/SB-168	...	N06045	90 (620)	46	111	420	45	46Ni-27Cr-23Fe-2.75Si	Plate, sheet & strip	...
B/SB-168	...	N06600	80 (550)	43	111	420	43	72Ni-15Cr-8Fe	Plate, sheet & strip	...
B/SB-168	...	N06601	80 (550)	43	111	420	43	60Ni-23Cr-12Fe-Al	Plate, sheet & strip	...
B/SB-168	...	N06617	95 (655)	43	111	420	46	52Ni-22Cr-13Co-9Mo	Plate, sheet & strip	...
B/SB-168	...	N06690	85 (585)	43	111	420	43	58Ni-29Cr-9Fe	Plate, sheet & strip	...
B/SB-169	...	C61400	65 (450)	35	108	360	35	90Cu-7Al-3Fe	Plate, sheet, strip & bar	>2 (50) ≤5 (125)
B/SB-169	...	C61400	70 (485)	35	108	360	35	90Cu-7Al-3Fe	Plate, sheet, strip & bar	>0.5 (13) ≤2 (50)
B/SB-169	...	C61400	72 (495)	35	108	360	35	90Cu-7Al-3Fe	Plate, sheet, strip & bar	≤0.5 (13)

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing		ISO 15608 Group	Nominal Composition	Typical Product Form	Thickness Limits, Nominal in. (mm)
					P-No.	AWS B2.2 BM				
Nonferrous (Cont'd)										
B/SB-171	...	C36500	40 (275)	32	107	310	32.2	60Cu-39Zn-Pb	Plate & sheet	>3.5 (90) ≤5 (125)
B/SB-171	...	C36500	45 (310)	32	107	310	32.2	60Cu-39Zn-Pb	Plate & sheet	>2.0 (50) ≤3.5 (90)
B/SB-171	...	C36500	50 (345)	32	107	310	32.2	60Cu-39Zn-Pb	Plate & sheet	≤2.0 (50)
B/SB-171	...	C44300	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06As	Plate & sheet	...
B/SB-171	...	C44400	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06Sb	Plate & sheet	...
B/SB-171	...	C44500	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06P	Plate & sheet	...
B/SB-171	...	C46400	50 (345)	32	107	300	32.2	60Cu-39Zn-Sn	Plate & sheet	...
B/SB-171	...	C46500	50 (345)	32	107	300	32.2	60Cu-39Zn-As	Plate & sheet	...
B/SB-171	...	C61400	65 (450)	35	108	360	35	90Cu-7Al-3Fe	Plate & sheet	>2 (50) ≤5 (125)
B/SB-171	...	C61400	70 (485)	35	108	360	35	90Cu-7Al-3Fe	Plate & sheet	≤2 (50)
B/SB-171	...	C63000	80 (550)	35	108	360	35	81Cu-10Al-5Ni-3Fe	Plate & sheet	>3.5 (90) ≤5 (125)
B/SB-171	...	C63000	85 (585)	35	108	360	35	81Cu-10Al-5Ni-3Fe	Plate & sheet	>2 (50) ≤3.5 (90)
B/SB-171	...	C63000	90 (620)	35	108	360	35	81Cu-10Al-5Ni-3Fe	Plate & sheet	≤2 (50)
B/SB-171	...	C70600	40 (275)	34	107	300	34	90Cu-10Ni	Plate & sheet	...
B/SB-171	...	C70620	40 (275)	34	107	300	34	90Cu-10Ni	Plate & sheet	...
B/SB-171	...	C71500	45 (310)	34	107	300	34	70Cu-30Ni	Plate & sheet	>2.5 (65) ≤5 (125)
B/SB-171	...	C71500	50 (345)	34	107	300	34	70Cu-30Ni	Plate & sheet	≤2.5 (65)
B/SB-171	...	C71520	45 (310)	34	107	300	34	70Cu-30Ni	Plate & sheet	>2.5 (65) ≤5 (125)
B/SB-171	...	C71520	50 (345)	34	107	300	34	70Cu-30Ni	Plate & sheet	≤2.5 (65)
B/SB-187	060	C10200	28 (195)	31	107	300	31	99.95Cu-P	Rod & bar	...
B/SB-187	060	C11000	28 (195)	31	107	300	31	99.9Cu	Rod & bar	...
B/SB-209	Alclad 3003	...	13 (90)	21	104	200	...	Al-Mn-Cu	Plate & sheet	>0.05 (1.3) <0.5 (13)
B/SB-209	Alclad 3003	...	14 (97)	21	104	200	...	Al-Mn-Cu	Plate & sheet	≥0.5 (13) ≤3 (75)
B/SB-209	Alclad 3004	...	21 (145)	22	104	220	...	Al-Mn-Mg	Plate & sheet	>0.05 (1.3) <0.5 (13)
B/SB-209	Alclad 3004	...	22 (150)	22	104	220	...	Al-Mn-Mg	Plate & sheet	≥0.5 (13) ≤3 (75)
B/SB-209	Alclad 6061	...	24 (165)	23	105	200	...	Al-Mg-Si-Cu	Plate & sheet	...
B/SB-209	1060	A91060	8 (55)	21	104	200	21	99.60Al	Plate & sheet	...
B/SB-209	1100	A91100	11 (76)	21	104	200	21	99.0Al-Cu	Plate & sheet	...
B/SB-209	3003	A93003	14 (97)	21	104	200	22.1	Al-Mn-Cu	Plate & sheet	...
B/SB-209	3004	A93004	22 (150)	22	104	220	22.2	Al-Mn-Mg	Plate & sheet	...
B/SB-209	5050	A95050	18 (125)	21	105	220	22.2	Al-1.5Mg	Plate & sheet	...
B/SB-209	5052	A95052	25 (170)	22	105	220	22.3	Al-2.5Mg	Plate & sheet	...
B/SB-209	5083	A95083	36 (250)	25	105	220	22.4	Al-4.4Mg-Mn	Plate & sheet	>7 (180) ≤8 (200)
B/SB-209	5083	A95083	37 (255)	25	105	220	22.4	Al-4.4Mg-Mn	Plate & sheet	>5 (125) ≤7 (180)
B/SB-209	5083	A95083	38 (260)	25	105	220	22.4	Al-4.4Mg-Mn	Plate & sheet	>3 (75) ≤5 (125)

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing		ISO 15608		Typical Product Form	Thickness Limits, Nominal in. (mm)
					AWS P-No.	B2.2 BM	Group	Nominal Composition		
Nonferrous (Cont'd)										
B/SB-209	5083	A95083	39 (270)	25	105	220	22.4	Al-4.4Mg-Mn	Plate & sheet	>1.5 (38) ≤3 (75)
B/SB-209	5083	A95083	40 (275)	25	105	220	22.4	Al-4.4Mg-Mn	Plate & sheet	>0.05 (1.3) ≤1.5 (38)
B/SB-209	5086	A95086	35 (240)	25	105	220	22.4	Al-4.0Mg-Mn	Plate & sheet	...
B/SB-209	5154	A95154	30 (205)	22	105	220	22.4	Al-3.5Mg	Plate & sheet	...
B/SB-209	5254	A95254	30 (205)	22	105	220	22.4	Al-3.5Mg	Plate & sheet	...
B/SB-209	5454	A95454	31 (215)	22	105	220	22.3	Al-2.7Mg-Mn	Plate & sheet	...
B/SB-209	5456	A95456	38 (260)	25	105	220	22.4	Al-5.1Mg-Mn	Plate & sheet	>7 (180) ≤8 (200)
B/SB-209	5456	A95456	39 (270)	25	105	220	22.4	Al-5.1Mg-Mn	Plate & sheet	>5 (125) ≤7 (180)
B/SB-209	5456	A95456	40 (275)	25	105	220	22.4	Al-5.1Mg-Mn	Plate & sheet	>3 (75) ≤5 (125)
B/SB-209	5456	A95456	41 (285)	25	105	220	22.4	Al-5.1Mg-Mn	Plate & sheet	>1.5 (38) ≤3 (75)
B/SB-209	5456	A95456	42 (290)	25	105	220	22.4	Al-5.1Mg-Mn	Plate & sheet	>0.05 (1.3) ≤1.5 (38)
B/SB-209	5652	A95652	25 (170)	22	105	220	22.3	Al-2.5Mg	Plate & sheet	...
B/SB-209	6061	A96061	24 (165)	23	105	220	23.1	Al-Mg-Si-Cu	Plate & sheet	...
B/SB-210	Alclad 3003	...	13 (90)	21	104	200	...	Al-Mn-Cu	Smls. tube	...
B/SB-210	1060	A91060	8.5 (59)	21	104	200	21	99.60Al	Smls. tube	...
B/SB-210	3003	A93003	14 (97)	21	104	200	22.1	Al-Mn-Cu	Smls. tube	...
B/SB-210	5052	A95052	25 (170)	22	105	220	22.3	Al-2.5Mg	Smls. tube	...
B/SB-210	5083	A95083	39 (270)	25	105	220	22.4	Al-4.4Mg-Mn	Smls. tube	...
B/SB-210	5086	A95086	35 (240)	25	105	220	22.4	Al-4.0Mg-Mn	Smls. tube	...
B/SB-210	5154	A95154	30 (205)	22	105	220	22.4	Al-3.5Mg	Smls. tube	...
B/SB-210	5456	A95456	41 (285)	25	105	220	22.4	Al-5.1Mg-Mn	Smls. tube	...
B/SB-210	6061	A96061	24 (165)	23	105	220	23.1	Al-Mg-Si-Cu	Smls. tube	...
B/SB-210	6063	A96063	17 (115)	23	105	210	23.1	Al-Mg-Si	Smls. tube	...
B/SB-211	6061	A96061	24 (165)	23	105	220	23.1	Al-Mg-Si-Cu	Bar, rod & wire	...
B/SB-221	1060	A91060	8.5 (59)	21	104	200	21	99.60Al	Bar, rod & shapes	...
B/SB-221	1100	A91100	11 (76)	21	104	200	21	99.0Al-Cu	Bar, rod & shapes	...
B/SB-221	3003	A93003	14 (97)	21	104	200	22.1	Al-Mn-Cu	Bar, rod & shapes	...
B/SB-221	5083	A95083	39 (270)	25	105	220	22.4	Al-4.4Mg-Mn	Bar, rod & shapes	...
B/SB-221	5154	A95154	30 (205)	22	105	220	22.4	Al-3.5Mg	Bar, rod & shapes	...
B/SB-221	5454	A95454	31 (215)	22	105	220	22.3	Al-2.7Mg-Mn	Bar, rod & shapes	...
B/SB-221	5456	A95456	41 (285)	25	105	220	22.4	Al-5.1Mg-Mn	Bar, rod & shapes	...
B/SB-221	6061	A96061	24 (165)	23	105	220	23.1	Al-Mg-Si-Cu	Bar, rod & shapes	...
B/SB-221	6063	A96063	17 (115)	23	105	210	23.1	Al-Mg-Si	Bar, rod & shapes	...
B/SB-234	Alclad 3003	...	13 (90)	21	104	200	...	Al-Mn-Cu	Smls. tube	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing		ISO 15608 Group	Nominal Composition	Typical Product Form	Thickness Limits, Nominal in. (mm)
					P-No.	AWS B2.2 BM				
Nonferrous (Cont'd)										
B/SB-234	1060	A91060	8.5 (59)	21	104	200	21	99.60Al	Smls. tube	...
B/SB-234	3003	A93003	14 (97)	21	104	200	22.1	Al-Mn-Cu	Smls. tube	...
B/SB-234	5052	A95052	25 (170)	22	105	220	22.3	Al-2.5Mg	Smls. tube	...
B/SB-234	5454	A95454	31 (215)	22	105	220	22.3	Al-2.7Mg-Mn	Smls. tube	...
B/SB-234	6061	A96061	24 (165)	23	105	220	23.1	Al-Mg-Si-Cu	Smls. tube	...
B/SB-241	Alclad 3003	...	13 (90)	21	104	200	...	Al-Mn-Cu	Smls. pipe & tube	...
B/SB-241	1060	A91060	8.5 (59)	21	104	200	21	99.60Al	Smls. pipe & tube	...
B/SB-241	1100	A91100	11 (76)	21	104	200	21	99.0Al-Cu	Smls. pipe & tube	...
B/SB-241	3003	A93003	14 (97)	21	104	200	22.1	Al-Mn-Cu	Smls. pipe & tube	...
B/SB-241	5052	A95052	25 (170)	22	105	220	22.3	Al-2.5Mg	Smls. pipe & tube	...
B/SB-241	5083	A95083	39 (270)	25	105	220	22.4	Al-4.4Mg-Mn	Smls. pipe & tube	...
B/SB-241	5086	A95086	35 (240)	25	105	220	22.4	Al-4.0Mg-Mn	Smls. pipe & tube	...
B/SB-241	5454	A95454	31 (215)	22	105	220	22.3	Al-2.7Mg-Mn	Smls. pipe & tube	...
B/SB-241	5456	A95456	41 (285)	25	105	220	22.4	Al-5.1Mg-Mn	Smls. pipe & tube	...
B/SB-241	6061	A96061	24 (165)	23	105	220	23.1	Al-Mg-Si-Cu	Smls. pipe & tube	...
B/SB-241	6063	A96063	17 (115)	23	105	210	23.1	Al-Mg-Si	Smls. pipe & tube	...
B/SB-247	3003	A93003	14 (97)	21	104	200	22.1	Al-Mn-Cu	Forgings	...
B/SB-247	5083	A95083	38 (260)	25	105	220	22.4	Al-4.4Mg-Mn	Forgings	...
B/SB-247	6061	A96061	24 (165)	23	105	220	23.1	Al-Mg-Si-Cu	Forgings	...
B/SB-265	1	R50250	35 (240)	51	115	500	51.1	Ti	Plate, sheet & strip	...
B/SB-265	2	R50400	50 (345)	51	115	500	51.2	Ti	Plate, sheet & strip	...
B/SB-265	2H	R50400	58 (400)	51	115	500	51.2	Ti	Plate, sheet & strip	...
B/SB-265	3	R50550	65 (450)	52	115	500	51.3	Ti	Plate, sheet & strip	...
B/SB-265	11	R52250	35 (240)	51	115	500	52	Ti-Pd	Plate, sheet & strip	...
B/SB-265	17	R52252	35 (240)	51	...	500	51.1	Ti-Pd	Plate, sheet & strip	...
B/SB-265	27	R52254	35 (240)	51	115	500	51.1	Ti-Ru	Plate, sheet & strip	...
B/SB-265	7	R52400	50 (345)	51	115	500	52	Ti-Pd	Plate, sheet & strip	...
B/SB-265	7H	R52400	58 (400)	51	115	500	52	Ti-Pd	Plate, sheet & strip	...
B/SB-265	16	R52402	50 (345)	51	115	500	51.2	Ti-Pd	Plate, sheet & strip	...
B/SB-265	16H	R52402	58 (400)	51	115	500	51.2	Ti-Pd	Plate, sheet & strip	...
B/SB-265	26	R52404	50 (345)	51	115	500	51.2	Ti-Ru	Plate, sheet & strip	...
B/SB-265	26H	R52404	58 (400)	51	115	500	51.2	Ti-Ru	Plate, sheet & strip	...
B/SB-265	12	R53400	70 (485)	52	115	500	52	Ti-0.3Mo-0.8Ni	Plate, sheet & strip	...
B/SB-265	38	R54250	130 (895)	54	115	500	53	Ti-4Al-2.5V-1.5Fe	Plate, sheet & strip	...
B/SB-265	9	R56320	90 (620)	53	115	500	53	Ti-3Al-2.5V	Plate, sheet & strip	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing			ISO 15608			Typical Product Form	Thickness Limits, Nominal in. (mm)	
					AWS P-No.	B2.2 BM	Group	Nominal Composition					
Nonferrous (Cont'd)													
B/SB-265	28	R56323	90 (620)	53	115	500	53	Ti-3Al-2.5V-0.1Ru			Plate, sheet & strip	...	
B/SB-271	...	C95200	65 (450)	35	108	360	35	88Cu-9Al-3Fe			Castings	...	
B/SB-271	...	C95400	75 (515)	35	108	360	35	85Cu-11Al-4Fe			Castings	...	
B280	102	C10200	30 (205)	31	107	300	31	99.95Cu-P			Smls. tube	...	
B280	120	C12000	30 (205)	31	107	300	31	99.9Cu-P			Smls. tube	...	
B280	122	C12200	30 (205)	31	107	300	31	99.9Cu-P			Smls. tube	...	
B/SB-283	Cu	C11000	33 (230)	31	107	300	31	99.9Cu			Forgings	...	
B/SB-283	Forging Brass	C37700	46 (315)	...	107	320	NA	60Cu-38Zn-2Pb			Forgings	>1.5 (38)	
B/SB-283	Forging Brass	C37700	50 (345)	...	107	320	NA	60Cu-38Zn-2Pb			Forgings	≤1.5 (38)	
B/SB-283	Naval Brass	C46400	64 (440)	32	107	300	32.2	60Cu-39Zn-Sn			Forgings	...	
B/SB-283	High Si Bronze	C65500	52 (360)	33	107	330	31	97Cu-3Si			Forgings	...	
B/SB-283	Mn Bronze	C67500	72 (495)	32	107	300	32.2	59Cu-39Zn-Fe-Sn			Forgings	...	
B/SB-283	...	C70620	40 (275)	34	107	300	34	90Cu-10Ni			Forgings	>6 (150)	
B/SB-283	...	C70620	45 (310)	34	107	300	34	90Cu-10Ni			Forgings	≤6 (150)	
B/SB-283	...	C71520	45 (310)	34	107	300	34	70Cu-30Ni			Forgings	>6 (150)	
B/SB-283	...	C71520	50 (345)	34	107	300	34	70Cu-30Ni			Forgings ≤ 6 in. (150 mm)	≤ 6 (150)	
B302	...	C12000	30 (205)	31	107	300	31	99.9Cu-P			Pipe	...	
B302	...	C12200	30 (205)	31	107	300	31	99.9Cu-P			Pipe	...	
B/SB-308	6061	A96061	24 (165)	23	105	220	23.1	Al-Mg-Si-Cu			Shapes	...	
B/SB-315	...	C65500	50 (345)	33	107	330	33	97Cu-3Si			Smls. pipe & tube	...	
B/SB-333	...	N10001	100 (690)	44	112	410	44	62Ni-28Mo-5Fe			Plate, sheet & strip	≥0.187 (5) ≤2.5 (65)	
B/SB-333	...	N10001	115 (795)	44	112	410	44	62Ni-28Mo-5Fe			Plate, sheet & strip	<0.187 (5)	
B/SB-333	...	N10629	110 (760)	44	112	410	44	66Ni-28Mo-3Fe-1.3Cr-0.25Al			Plate, sheet & strip	...	
B/SB-333	...	N10665	110 (760)	44	112	410	44	65Ni-28Mo-2Fe			Plate, sheet & strip	...	
B/SB-333	...	N10675	110 (760)	44	112	410	44	65Ni-29.5Mo-2Fe-2Cr			Plate, sheet & strip	...	
B/SB-335	...	N10001	100 (690)	44	112	410	44	62Ni-28Mo-5Fe			Rod	>1.5 (38) ≤3.5 (90)	
B/SB-335	...	N10001	115 (795)	44	112	410	44	62Ni-28Mo-5Fe			Rod	≥0.3125 (8) ≤1.5 (38)	
B/SB-335	...	N10629	110 (760)	44	112	410	44	66Ni-28Mo-3Fe-1.3Cr-0.25Al			Rod	...	
B/SB-335	...	N10665	110 (760)	44	112	410	44	65Ni-28Mo-2Fe			Rod	...	
B/SB-335	...	N10675	110 (760)	44	112	410	44	65Ni-29.5Mo-2Fe-2Cr			Rod	...	

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing			ISO 15608			Typical Product Form	Thickness Limits, Nominal in. (mm)
					P-No.	AWS B2.2 BM	Group	Nominal Composition				
Nonferrous (Cont'd)												
B/SB-338	1	R50250	35 (240)	51	115	500	51.1	Ti			Smls. & welded tube	...
B/SB-338	2	R50400	50 (345)	51	115	500	51.2	Ti			Smls. & welded tube	...
B/SB-338	2H	R50400	58 (400)	51	115	500	51.2	Ti			Smls. & welded tube	...
B/SB-338	3	R50550	65 (450)	52	115	500	51.3	Ti			Smls. & welded tube	...
B/SB-338	7	R52400	50 (345)	51	115	500	52	Ti-Pd			Smls. & welded tube	...
B/SB-338	7H	R52400	58 (400)	51	115	500	52	Ti-Pd			Smls. & welded tube	...
B/SB-338	16	R52402	50 (345)	51	115	500	51.2	Ti-Pd			Smls. & welded tube	...
B/SB-338	16H	R52402	58 (400)	51	115	500	51.2	Ti-Pd			Smls. & welded tube	...
B/SB-338	26	R52404	50 (345)	51	115	500	51.2	Ti-Ru			Smls. & welded tube	...
B/SB-338	26H	R52404	58 (400)	51	115	500	51.2	Ti-Ru			Smls. & welded tube	...
B/SB-338	12	R53400	70 (485)	52	115	500	52	Ti-0.3Mo-0.8Ni			Smls. & welded tube	...
B/SB-338	38	R54250	130 (895)	54	115	500	53	Ti-4Al-2.5V-1.5Fe			Smls. & welded tube	...
B/SB-338	9	R56320	90 (620)	53	115	500	53	Ti-3Al-2.5V			Smls. & welded tube	...
B/SB-338	28	R56323	90 (620)	53	115	500	53	Ti-3Al-2.5V-0.1Ru			Smls. & welded tube	...
B345	1060	A91060	8.5 (59)	21	104	200	21	99.60Al			Smls. pipe & tube	...
B345	3003	A93003	14 (97)	21	104	200	22.1	Al-Mn-Cu			Smls. pipe & tube	...
B345	5083	A95083	39 (270)	25	105	220	22.4	Al-4.4Mg-Mn			Smls. pipe & tube	...
B345	5086	A95086	35 (240)	25	105	220	22.4	Al-4.0Mg-Mn			Smls. pipe & tube	...
B345	6061	A96061	24 (165)	23	105	220	23.1	Al-Mg-Si-Cu			Smls. pipe & tube	...
B345	6063	A96063	17 (115)	23	105	210	23.1	Al-Mg-Si			Smls. pipe & tube	...
B/SB-348	1	R50250	35 (240)	51	115	500	51.1	Ti			Bars & billets	...
B/SB-348	2	R50400	50 (345)	51	115	500	51.2	Ti			Bars & billets	...
B/SB-348	2H	R50400	58 (400)	51	115	500	51.2	Ti			Bars & billets	...
B/SB-348	3	R50550	65 (450)	52	115	500	51.3	Ti			Bars & billets	...
B/SB-348	7	R52400	50 (345)	51	115	500	52	Ti-Pd			Bars & billets	...
B/SB-348	7H	R52400	58 (400)	51	115	500	52	Ti-Pd			Bars & billets	...
B/SB-348	16	R52402	50 (345)	51	115	500	51.2	Ti-Pd			Bars & billets	...
B/SB-348	16H	R52402	58 (400)	51	115	500	51.2	Ti-Pd			Bars & billets	...
B/SB-348	26	R52404	50 (345)	51	115	500	51.2	Ti-Ru			Bars & billets	...
B/SB-348	26H	R52404	58 (400)	51	115	500	51.2	Ti-Ru			Bars & billets	...
B/SB-348	12	R53400	70 (485)	52	115	500	52	Ti-0.3Mo-0.8Ni			Bars & billets	...
B/SB-348	38	R54250	130 (895)	54	115	500	53	Ti-4Al-2.5V-1.5Fe			Bars & billets	...
B/SB-348	9	R56320	90 (620)	53	115	500	53	Ti-3Al-2.5V			Bars & billets	...
B/SB-348	28	R56323	90 (620)	53	115	500	53	Ti-3Al-2.5V-0.1Ru			Bars & billets	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing		ISO 15608		Typical Product Form	Thickness Limits, Nominal in. (mm)
					P-No.	AWS B2.2 BM	Group	Nominal Composition		
Nonferrous (Cont'd)										
B/SB-359	...	C12200	30 (205)	31	107	300	31	99.9Cu-P	Smls. tube	...
B/SB-359	...	C44300	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06As	Smls. tube	...
B/SB-359	...	C44400	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06Sb	Smls. tube	...
B/SB-359	...	C44500	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06P	Smls. tube	...
B/SB-359	...	C70600	40 (275)	34	107	300	34	90Cu-10Ni	Smls. tube	...
B/SB-359	...	C70620	40 (275)	34	107	300	34	90Cu-10Ni	Smls. tube	...
B/SB-359	...	C71000	45 (310)	34	107	300	34	80Cu-20Ni	Smls. tube	...
B/SB-359	...	C71500	52 (360)	34	107	300	34	70Cu-30Ni	Smls. tube	...
B/SB-359	...	C71520	52 (360)	34	107	300	34	70Cu-30Ni	Smls. tube	...
B361	WP Alclad 3003	A83003	13 (90)	21	104	200	...	Al-Mn-Cu	Fittings	...
B361	WP1060	A91060	8.5 (59)	21	104	200	21	99.60Al	Fittings	...
B361	WP1100	A91100	11 (76)	21	104	200	21	99.0Al-Cu	Fittings	...
B361	WP3003	A93003	14 (97)	21	104	200	22.1	Al-Mn-Cu	Fittings	...
B361	5083	A95083	39 (270)	25	105	220	22.4	Al-4.4Mg-Mn	Fittings	...
B361	5154	A95154	30 (205)	22	105	220	22.3	Al-3.5Mg	Fittings	...
B361	WP6061	A96061	24 (165)	23	105	220	23.1	Al-Mg-Si-Cu	Fittings	...
B361	WP6063	A96063	17 (115)	23	105	210	23.1	Al-Mg-Si	Fittings	...
B/SB-363	WPT 1	R50250	35 (240)	51	115	500	51.1	Ti	Smls. & welded fittings	...
B/SB-363	WPT 2	R50400	50 (345)	51	115	500	51.2	Ti	Smls. & welded fittings	...
B/SB-363	WPT 3	R50550	65 (450)	52	115	500	51.3	Ti	Smls. & welded fittings	...
B/SB-363	WPT 7	R52400	50 (345)	51	115	500	52	Ti-Pd	Smls. & welded fittings	...
B/SB-363	WPT 7H	R52400	58 (400)	51	115	500	52	Ti-Pd	Smls. & welded fittings	...
B/SB-363	WPT 16	R52402	50 (345)	51	115	500	51.2	Ti-Pd	Smls. & welded fittings	...
B/SB-363	WPT 16H	R52402	58 (400)	51	115	500	51.2	Ti-Pd	Smls. & welded fittings	...
B/SB-363	WPT 26	R52404	50 (345)	51	115	500	51.2	Ti-Ru	Smls. & welded fittings	...
B/SB-363	WPT 26H	R52404	58 (400)	51	115	500	51.2	Ti-Ru	Smls. & welded fittings	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing		ISO 15608 Group	Nominal Composition	Typical Product Form	Thickness Limits, Nominal in. (mm)
					P-No.	AWS B2.2 BM				
Nonferrous (Cont'd)										
B/SB-363	WPT 12	R53400	70 (485)	52	115	500	52	Ti-0.3Mo-0.8Ni	Smls. & welded fittings	...
B/SB-363	WPT 38	R54250	130 (895)	54	115	500	53	Ti-4Al-2.5V-1.5Fe	Smls. & welded fittings	...
B/SB-363	WPT 9	R56320	90 (620)	53	115	500	53	Ti-3Al-2.5V	Smls. & welded fittings	...
B/SB-363	WPT 28	R56323	90 (620)	53	115	500	53	Ti-3Al-2.5V-0.1Ru	Smls. & welded fittings	...
B/SB-366	...	N02200	55 (380)	41	110	400	41	99.0Ni	Fittings	...
B/SB-366	...	N02201	50 (345)	41	110	400	41	99.0Ni-Low C	Fittings	...
B/SB-366	...	N04400	70 (485)	42	110	400	42	67Ni-30Cu	Fittings	...
B/SB-366	...	N06002	100 (690)	43	111	420	43	47Ni-22Cr-9Mo-18Fe	Fittings	...
B/SB-366	...	N06007	90 (620)	45	111	420	43	47Ni-22Cr-19Fe-6Mo	Fittings	...
B/SB-366	...	N06022	100 (690)	43	111	420	43	55Ni-21Cr-13.5Mo	Fittings	...
B/SB-366	...	N06025	98 (675)	43	111	420	43	63Ni-25Cr-10Fe-2Al-Ti-Y-Zr	Fittings	...
B/SB-366	...	N06030	85 (585)	45	111	420	45	40Ni-29Cr-15Fe-5Mo	Fittings	...
B/SB-366	...	N06035	85 (585)	43	111	420	43	58Ni-33Cr-8Mo	Fittings	...
B/SB-366	...	N06045	90 (620)	46	111	420	45	46Ni-27Cr-23Fe-2.75Si	Fittings	...
B/SB-366	...	N06059	100 (690)	43	111	420	43	59Ni-23Cr-16Mo	Fittings	...
B/SB-366	...	N06200	100 (690)	43	111	420	43	59Ni-23Cr-16Mo-1.6Cu	Fittings	...
B/SB-366	...	N06210	100 (690)	43	111	420	43	60Ni-19Cr-19Mo-1.8Ta	Fittings	...
B/SB-366	...	N06230	110 (760)	43	111	420	43	53Ni-22Cr-14W-Co-Fe-Mo	Fittings	...
B/SB-366	...	N06455	100 (690)	43	111	420	43	61Ni-15Mo-16Cr	Fittings	...
B/SB-366	...	N06600	80 (550)	43	111	420	43	72Ni-15Cr-8Fe	Fittings	...
B/SB-366	...	N06625	100 (690)	43	111	430	43	60Ni-22Cr-9Mo-3.5Cb	Fittings	...
B/SB-366	...	N06985	90 (620)	45	111	420	45	47Ni-22Cr-20Fe-7Mo	Fittings	...
B/SB-366	...	N08020	80 (550)	45	111	420	45	35Ni-35Fe-20Cr-Cb	Fittings	...
B/SB-366	...	N08031	94 (650)	45	111	420	45	31Ni-31Fe-27Cr-7Mo	Fittings	...
B/SB-366	...	N08120	90 (620)	45	111	430	45	37Ni-33Fe-25Cr	Fittings	...
B/SB-366	...	N08330	70 (485)	46	111	420	45	35Ni-19Cr-1.25Si	Fittings	...
B/SB-366	...	N08367	95 (655)	45	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Fittings	>0.187 (5)
B/SB-366	...	N08367	100 (690)	45	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Fittings	≤0.187 (5)
B/SB-366	...	N08800	75 (515)	45	111	430	45	33Ni-42Fe-21Cr	Fittings	...
B/SB-366	...	N08825	85 (585)	45	111	430	45	42Ni-21.5Cr-3Mo-2.3Cu	Fittings	...
B/SB-366	...	N08925	87 (600)	45	111	420	8.2	25Ni-20Cr-6Mo-Cu-N	Fittings	...
B/SB-366	...	N08926	94 (650)	45	111	420	8.2	25Ni-20Cr-6Mo-Cu-N	Fittings	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing			ISO 15608			Typical Product Form	Thickness Limits, Nominal in. (mm)	
					AWS P-No.	B2.2 BM	Group	Nominal Composition					
Nonferrous (Cont'd)													
B/SB-366	...	N10001	100 (690)	44	112	410	44	62Ni-28Mo-5Fe		Fittings	...		
B/SB-366	...	N10003	100 (690)	44	112	410	44	70Ni-16Mo-7Cr-5Fe		Fittings	...		
B/SB-366	...	N10242	105 (725)	44	112	410	44	62Ni-25Mo-8Cr-2Fe		Fittings	...		
B/SB-366	...	N10276	100 (690)	43	111	420	43	54Ni-16Mo-15Cr		Fittings	...		
B/SB-366	...	N10362	105 (725)	43	111	420	43	62Ni-22Mo-15Cr		Fittings	...		
B/SB-366	...	N10629	110 (760)	44	112	410	44	66Ni-28Mo-3Fe-1.3Cr-0.25Al		Fittings	...		
B/SB-366	...	N10665	110 (760)	44	112	410	44	65Ni-28Mo-2Fe		Fittings	...		
B/SB-366	...	N10675	110 (760)	44	112	410	44	65Ni-29.5Mo-2Fe-2Cr		Fittings	...		
B/SB-366	...	N12160	90 (620)	46	...	420	46	37Ni-30Co-28Cr-2.7Si		Fittings	...		
B/SB-366	...	R20033	109 (750)	45	111	420	45	33Cr-31Ni-32Fe-1.5Mo-0.6Cu-N		Fittings	...		
B/SB-366	...	R30556	100 (690)	45	111	420	45	21Ni-30Fe-22Cr-18Co-3Mo-3W		Fittings	...		
B/SB-367	C-2	R52550	50 (345)	51	115	500	51.4	Ti		Castings	...		
B/SB-367	C-3	R52550	65 (450)	52	115	500	51.4	Ti		Castings	...		
B/SB-369	...	C96200	45 (310)	34	107	500	34	87.5Cu-10Ni-Fe-Mn		Castings	...		
B/SB-381	F-1	R50250	35 (240)	51	115	500	51.1	Ti		Forgings	...		
B/SB-381	F-2	R50400	50 (345)	51	115	500	51.2	Ti		Forgings	...		
B/SB-381	F-2H	R50400	58 (400)	51	115	500	51.2	Ti		Forgings	...		
B/SB-381	F-3	R50550	65 (450)	52	115	500	51.3	Ti		Forgings	...		
B/SB-381	F-7	R52400	50 (345)	51	115	500	52	Ti-Pd		Forgings	...		
B/SB-381	F-7H	R52400	58 (400)	51	115	500	52	Ti-Pd		Forgings	...		
B/SB-381	F-16	R52402	50 (345)	51	115	500	51.2	Ti-Pd		Forgings	...		
B/SB-381	F-16H	R52402	58 (400)	51	115	500	51.2	Ti-Pd		Forgings	...		
B/SB-381	F-26	R52404	50 (345)	51	115	500	51.2	Ti-Ru		Forgings	...		
B/SB-381	F-26H	R52404	58 (400)	51	115	500	51.2	Ti-Ru		Forgings	...		
B/SB-381	F-12	R53400	70 (485)	52	115	500	52	Ti-0.3Mo-0.8Ni		Forgings	...		
B/SB-381	F-38	R54250	130 (895)	54	115	500	53	Ti-4Al-2.5V-1.5Fe		Forgings	...		
B/SB-381	F-9	R56320	90 (620)	53	115	500	53	Ti-3Al-2.5V		Forgings	...		
B/SB-381	F-28	R56323	90 (620)	53	115	500	53	Ti-3Al-2.5V-0.1Ru		Forgings	...		
B/SB-395	...	C10200	30 (205)	31	107	300	31	99.95Cu-P		Smls. tube	...		
B/SB-395	...	C12000	30 (205)	31	107	300	31	99.9Cu-P		Smls. tube	...		
B/SB-395	...	C12200	30 (205)	31	107	300	31	99.9Cu-P		Smls. tube	...		
B/SB-395	...	C14200	30 (205)	31	107	300	31	99.4Cu-As-P		Smls. tube	...		
B/SB-395	...	C19200	38 (260)	31	107	300	31	99.7Cu-Fe-P		Smls. tube	...		
B/SB-395	...	C23000	40 (275)	32	107	300	32.1	85Cu-15Zn		Smls. tube	...		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing		ISO 15608 Group	Nominal Composition	Typical Product Form	Thickness Limits, Nominal in. (mm)
					P-No.	AWS B2.2 BM				
Nonferrous (Cont'd)										
B/SB-395	...	C44300	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06As	Smls. tube	...
B/SB-395	...	C44400	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06Sb	Smls. tube	...
B/SB-395	...	C44500	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06P	Smls. tube	...
B/SB-395	...	C60800	50 (345)	35	108	360	35	95Cu-5Al	Smls. tube	...
B/SB-395	...	C68700	50 (345)	32	108	350	32.2	78Cu-20Zn-2Al	Smls. tube	...
B/SB-395	...	C70600	40 (275)	34	107	300	34	90Cu-10Ni	Smls. tube	...
B/SB-395	...	C70620	40 (275)	34	107	300	34	90Cu-10Ni	Smls. tube	...
B/SB-395	...	C71000	45 (310)	34	107	300	34	80Cu-20Ni	Smls. tube	...
B/SB-395	...	C71500	52 (360)	34	107	300	34	70Cu-30Ni	Smls. tube	...
B/SB-395	...	C71520	52 (360)	34	107	300	34	70Cu-30Ni	Smls. tube	...
B/SB-407	...	N08120	90 (620)	45	111	430	45	37Ni-33Fe-25Cr	Smls. pipe & tube	...
B/SB-407	...	N08800	75 (515)	45	111	430	45	33Ni-42Fe-21Cr	Smls. pipe & tube	...
B/SB-407	...	N08801	65 (450)	45	111	430	45	32Ni-45Fe-20.5Cr-Ti	Smls. pipe & tube	...
B/SB-407	...	N08810	65 (450)	45	111	430	45	33Ni-42Fe-21Cr	Smls. pipe & tube	...
B/SB-407	...	N08811	65 (450)	45	111	430	45	33Ni-42Fe-21Cr-Al-Ti	Smls. pipe & tube	...
B/SB-408	...	N08120	90 (620)	45	111	430	45	37Ni-33Fe-25Cr	Rod & bar	...
B/SB-408	...	N08800	75 (515)	45	111	430	45	33Ni-42Fe-21Cr	Rod & bar	...
B/SB-408	...	N08810	65 (450)	45	111	430	45	33Ni-42Fe-21Cr	Rod & bar	...
B/SB-408	...	N08811	65 (450)	45	111	430	45	33Ni-42Fe-21Cr-Al-Ti	Rod & bar	...
B/SB-409	...	N08120	90 (620)	45	111	430	45	37Ni-33Fe-25Cr	Plate, sheet & strip	...
B/SB-409	...	N08800	75 (515)	45	111	430	45	33Ni-42Fe-21Cr	Plate, sheet & strip	...
B/SB-409	...	N08810	65 (450)	45	111	430	45	33Ni-42Fe-21Cr	Plate, sheet & strip	...
B/SB-409	...	N08811	65 (450)	45	111	430	45	33Ni-42Fe-21Cr-Al-Ti	Plate, sheet & strip	...
B/SB-423	...	N08825	75 (515)	45	111	430	45	42Ni-21.5Cr-3Mo-2.3Cu	Smls. pipe & tube	...
B/SB-424	...	N08825	85 (585)	45	111	430	45	42Ni-21.5Cr-3Mo-2.3Cu	Plate, sheet & strip	...
B/SB-425	...	N08825	85 (585)	45	111	430	45	42Ni-21.5Cr-3Mo-2.3Cu	Rod & bar	...
B/SB-434	...	N10003	100 (690)	44	112	430	44	70Ni-16Mo-7Cr-5Fe	Plate, sheet & strip	...
B/SB-434	...	N10242	105 (725)	44	112	410	44	62Ni-25Mo-8Cr-2Fe	Plate, sheet & strip	...
B/SB-435	...	N06002	95 (655)	43	111	420	43	47Ni-22Cr-9Mo-18Fe	Plate, sheet & strip	...
B/SB-435	...	N06230	110 (760)	43	111	420	43	53Ni-22Cr-14W-Co-Fe-Mo	Plate, sheet & strip	...
B/SB-435	...	N12160	90 (620)	46	...	420	46	37Ni-30Co-28Cr-2.7Si	Plate, sheet & strip	...
B/SB-435	...	R30556	100 (690)	45	111	420	45	21Ni-30Fe-22Cr-18Co-3Mo-3W	Plate, sheet & strip	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing			ISO 15608 Group	Nominal Composition	Typical Product Form	Thickness Limits, Nominal in. (mm)
					P-No.	AWS B2.2 BM	Group				
Nonferrous (Cont'd)											
B/SB-443	1	N06625	110 (760)	43	111	430	43		60Ni-22Cr-9Mo-3.5Cb	Plate & hot-rolled sheet	...
B/SB-443	1	N06625	120 (825)	43	111	430	43		60Ni-22Cr-9Mo-3.5Cb	Cold-rolled sheet & strip	...
B/SB-443	2	N06625	100 (690)	43	111	430	43		60Ni-22Cr-9Mo-3.5Cb	Plate, sheet & strip	...
B/SB-444	1	N06625	120 (825)	43	111	430	43		60Ni-22Cr-9Mo-3.5Cb	Smls. pipe & tube	...
B/SB-444	2	N06625	100 (690)	43	111	430	43		60Ni-22Cr-9Mo-3.5Cb	Smls. pipe & tube	...
B/SB-446	1	N06625	100 (690)	43	111	430	43		60Ni-22Cr-9Mo-3.5Cb	Rod & bar	≥ 4 (100) ≤ 10 (250) dia.
B/SB-446	1	N06625	120 (825)	43	111	430	43		60Ni-22Cr-9Mo-3.5Cb	Rod & bar	< 4 (100) dia.
B/SB-446	2	N06625	100 (690)	43	111	430	43		60Ni-22Cr-9Mo-3.5Cb	Rod & bar	...
B/SB-462	...	N06022	100 (690)	43	111	420	43		55Ni-21Cr-13.5Mo	Forgings	...
B/SB-462	...	N06030	85 (585)	45	111	420	45		40Ni-29Cr-15Fe-5Mo	Forgings	...
B/SB-462	...	N06035	85 (585)	43	111	420	43		58Ni-33Cr-8Mo	Forgings	...
B/SB-462	...	N06045	90 (620)	46	111	420	45		46Ni-27Cr-23Fe-2.75Si	Forgings	...
B/SB-462	...	N06059	100 (690)	43	111	420	43		59Ni-23Cr-16Mo	Forgings	...
B/SB-462	...	N06200	100 (690)	43	111	420	43		59Ni-23Cr-16Mo-1.6Cu	Forgings	...
B/SB-462	...	N06686	100 (690)	43	111	430	43		58Ni-21Cr-16Mo-3.5N	Forgings	...
B/SB-462	...	N08020	80 (550)	45	111	420	45		35Ni-35Fe-20Cr-Cb	Forgings	...
B/SB-462	...	N08031	94 (650)	45	111	420	45		31Ni-33Fe-22Cr-6.5Mo-Cu-N	Forgings	...
B/SB-462	...	N08367	95 (655)	45	111	420	8.2		46Fe-24Ni-21Cr-6Mo-N	Forgings	...
B/SB-462	...	N10276	100 (690)	43	111	420	43		54Ni-16Mo-15Cr	Forgings	...
B/SB-462	...	N10362	105 (725)	43	111	420	43		62Ni-22Mo-15Cr	Forgings	...
B/SB-462	...	N10629	110 (760)	44	112	410	44		66Ni-28Mo-3Fe-1.3Cr-0.25Al	Forgings	...
B/SB-462	...	N10665	110 (760)	44	112	410	44		65Ni-28Mo-2Fe	Forgings	...
B/SB-462	...	N10675	110 (760)	44	112	410	44		65Ni-29.5Mo-2Fe-2Cr	Forgings	...
B/SB-462	...	R20033	109 (750)	45	111	420	45		33Cr-31Ni-32Fe-1.5Mo-0.6Cu-N	Forgings	...
B/SB-463	...	N08020	80 (550)	45	111	420	45		35Ni-35Fe-20Cr-Cb	Plate, sheet & strip	...
B/SB-463	...	N08024	80 (550)	45	111	420	45		37Ni-33Fe-23Cr-4Mo	Plate, sheet & strip	...
B/SB-463	...	N08026	80 (550)	45	111	420	45		35Ni-30Fe-24Cr-6Mo-3Cu	Plate, sheet & strip	...
B/SB-464	...	N08020	80 (550)	45	111	420	45		35Ni-35Fe-20Cr-Cb	Welded pipe	...
B/SB-464	...	N08024	80 (550)	45	111	420	45		37Ni-33Fe-23Cr-4Mo	Welded pipe	...
B/SB-464	...	N08026	80 (550)	45	111	420	45		35Ni-30Fe-24Cr-6Mo-3Cu	Welded pipe	...
B/SB-466	...	C70600	38 (260)	34	107	300	34		90Cu-10Ni	Smls. pipe & tube	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing			ISO 15608			Typical Product Form	Thickness Limits, Nominal in. (mm)	
					P-No.	AWS B2.2 BM	Group	Nominal Composition					
Nonferrous (Cont'd)													
B/SB-466	...	C70620	38 (260)	34	107	300	34	90Cu-10Ni			Smls. pipe & tube	...	
B/SB-466	...	C71000	45 (310)	34	107	300	34	80Cu-20Ni			Smls. pipe & tube	...	
B/SB-466	...	C71500	52 (360)	34	107	300	34	70Cu-30Ni			Smls. pipe & tube	...	
B/SB-466	...	C71520	52 (360)	34	107	300	34	70Cu-30Ni			Smls. pipe & tube	...	
B/SB-467	...	C70600	38 (260)	34	107	300	34	90Cu-10Ni			Welded pipe	>4.5 (115) O.D.	
B/SB-467	...	C70600	40 (275)	34	107	300	34	90Cu-10Ni			Welded pipe	≤4.5 (115) O.D.	
B/SB-467	...	C70620	38 (260)	34	107	300	34	90Cu-10Ni			Welded pipe	>4.5 (115) O.D.	
B/SB-467	...	C70620	40 (275)	34	107	300	34	90Cu-10Ni			Welded pipe	≤4.5 (115) O.D.	
B/SB-467	...	C71500	45 (310)	34	107	300	34	70Cu-30Ni			Welded pipe	>4.5 (115) O.D.	
B/SB-467	...	C71500	50 (345)	34	107	300	34	70Cu-30Ni			Welded pipe	≤4.5 (115) O.D.	
B/SB-467	...	C71520	45 (310)	34	107	300	34	70Cu-30Ni			Welded pipe	>4.5 (115) O.D.	
B/SB-467	...	C71520	50 (345)	34	107	300	34	70Cu-30Ni			Welded pipe	≤4.5 (115) O.D.	
B/SB-468	...	N08020	80 (550)	45	111	420	45	35Ni-35Fe-20Cr-Cb			Welded tube	...	
B/SB-468	...	N08024	80 (550)	45	111	420	45	37Ni-33Fe-23Cr-4Mo			Welded tube	...	
B/SB-468	...	N08026	80 (550)	45	111	420	45	35Ni-30Fe-24Cr-6Mo-3Cu			Welded tube	...	
B/SB-473	...	N08020	80 (550)	45	111	420	45	35Ni-35Fe-20Cr-Cb			Bar	...	
B491	3003	A93003	14 (97)	21	104	200	22.1	Al-Mn-Cu			Extruded tube	...	
B/SB-493	R60702	R60702	55 (380)	61	117	600	61	99.2Zr			Forgings	...	
B/SB-493	R60705	R60705	70 (485)	62	117	600	62	95.5Zr+2.5Cb			Forgings	...	
B/SB-505	...	C95200	68 (470)	35	108	360	35	88Cu-9Al-3Fe			Castings	...	
B/SB-511	...	N08330	70 (485)	46	111	420	45	35Ni-19Cr-1.25Si			Bars & shapes	...	
B/SB-514	...	N08120	90 (620)	45	111	430	45	37Ni-33Fe-25Cr			Welded pipe	...	
B/SB-514	...	N08800	75 (515)	45	111	430	45	33Ni-42Fe-21Cr			Welded pipe	...	
B/SB-514	...	N08810	65 (450)	45	111	430	45	33Ni-42Fe-21Cr			Welded pipe	...	
B/SB-515	...	N08120	90 (620)	45	111	430	45	37Ni-33Fe-25Cr			Welded tube	...	
B/SB-515	...	N08800	75 (515)	45	111	430	45	33Ni-42Fe-21Cr			Welded tube	...	
B/SB-515	...	N08810	65 (450)	45	111	430	45	33Ni-42Fe-21Cr			Welded tube	...	
B/SB-515	...	N08811	65 (450)	45	111	430	45	33Ni-42Fe-21Cr-Al-Ti			Welded tube	...	
B/SB-516	...	N06025	98 (675)	43	111	420	43	63Ni-25Cr-10Fe-2Al-Ti-Y-Zr			Welded tube	...	
B/SB-516	...	N06045	90 (620)	46	111	420	45	46Ni-27Cr-23Fe-2.75Si			Welded tube	...	
B/SB-516	...	N06600	80 (550)	43	111	420	43	72Ni-15Cr-8Fe			Welded tube	...	

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing			ISO 15608			Typical Product Form	Thickness Limits, Nominal in. (mm)	
					AWS P-No.	B2.2 BM	Group	Nominal Composition					
Nonferrous (Cont'd)													
B/SB-517	...	N06025	98 (675)	43	111	420	43	63Ni-25Cr-10Fe-2Al-Ti-Y-Zr			Welded pipe	...	
B/SB-517	...	N06045	90 (620)	46	111	420	45	46Ni-27Cr-23Fe-2.75Si			Welded pipe	...	
B/SB-517	...	N06600	80 (550)	43	111	420	43	72Ni-15Cr-8Fe			Welded pipe	...	
B/SB-523	R60702	R60702	55 (380)	61	117	600	61	99.2Zr			Smls. & welded tube	...	
B/SB-523	R60705	R60705	80 (550)	62	117	600	62	95.5Zr+2.5Cb			Smls. & welded tube	...	
B/SB-535	...	N08330	70 (485)	46	111	420	45	35Ni-19Cr-1.25Si			Smls. pipe & tube	...	
B/SB-536	...	N08330	70 (485)	46	111	420	45	35Ni-19Cr-1.25Si			Plate, sheet & strip	...	
B/SB-543	...	C12200	30 (205)	31	107	300	31	99.9Cu-P			Welded tube	...	
B/SB-543	...	C19400	45 (310)	31	107	300	31	97.5Cu-P			Welded tube	...	
B/SB-543	...	C23000	40 (275)	32	107	300	32.1	85Cu-15Zn			Welded tube	...	
B/SB-543	...	C44300	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06As			Welded tube	...	
B/SB-543	...	C44400	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06Sb			Welded tube	...	
B/SB-543	...	C44500	45 (310)	32	107	300	32.2	71Cu-28Zn-1Sn-0.06P			Welded tube	...	
B/SB-543	...	C68700	50 (345)	32	108	350	32.2	78Cu-20Zn-2Al			Welded tube	...	
B/SB-543	...	C70400	38 (260)	34	107	300	34	95Cu-5Ni			Welded tube	...	
B/SB-543	...	C70600	40 (275)	34	107	300	34	90Cu-10Ni			Welded tube	...	
B/SB-543	...	C70620	40 (275)	34	107	300	34	90Cu-10Ni			Welded tube	...	
B/SB-543	...	C71500	52 (360)	34	107	300	34	70Cu-30Ni			Welded tube	...	
B/SB-543	...	C71520	52 (360)	34	107	300	34	70Cu-30Ni			Welded tube	...	
B547	Alclad 3003	A83003	13 (90)	21	104	200	...	Al-Mn-Cu			Welded tube	...	
B547	3003	A93003	14 (97)	21	104	200	22.1	Al-Mn-Cu			Welded tube	...	
B547	5083	A95083	40 (275)	25	105	220	22.4	Al-4.4Mg-Mn			Welded tube	...	
B547	5454	A95454	31 (215)	22	105	220	22.3	Al-2.7Mg-Mn			Welded tube	...	
B547	6061	A96061	24 (165)	23	105	220	23.1	Al-Mg-Si-Cu			Welded tube	...	
B/SB-550	R60702	R60702	55 (380)	61	117	600	61	99.2Zr			Bar & wire	...	
B/SB-550	R60705	R60705	80 (550)	62	117	600	62	95.5Zr+2.5Cb			Bar & wire	...	
B/SB-551	R60702	R60702	55 (380)	61	117	600	61	99.2Zr			Plate, sheet & strip	...	
B/SB-551	R60705	R60705	80 (550)	62	117	600	62	95.5Zr+2.5Cb			Plate, sheet & strip	...	
B/SB-564	...	N04400	70 (485)	42	110	400	42	67Ni-30Cu			Forgings	...	
B/SB-564	...	N06022	100 (690)	43	111	420	43	55Ni-21Cr-13.5Mo			Forgings	...	
B/SB-564	...	N06025	84 (580)	43	111	420	43	63Ni-25Cr-10Fe-2Al-Ti-Y-Zr			Forgings	>4 (100) ≤12 (300)	

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing		ISO 15608		Typical Product Form	Thickness Limits, Nominal in. (mm)
					P-No.	AWS B2.2 BM	Group	Nominal Composition		
Nonferrous (Cont'd)										
B/SB-564	...	N06025	98 (675)	43	111	420	43	63Ni-25Cr-10Fe-2Al-Ti-Y-Zr	Forgings	≤4 (100)
B/SB-564	...	N06035	85 (585)	43	111	420	43	58Ni-33Cr-8Mo	Forgings	...
B/SB-564	...	N06045	90 (620)	46	111	420	45	46Ni-27Cr-23Fe-2.75Si	Forgings	...
B/SB-564	...	N06059	100 (690)	43	111	420	43	59Ni-23Cr-16Mo	Forgings	...
B/SB-564	...	N06200	100 (690)	43	111	420	43	59Ni-23Cr-16Mo-1.6Cu	Forgings	...
B/SB-564	...	N06210	100 (690)	43	111	420	43	60Ni-19Cr-19Mo-1.8Ta	Forgings	...
B/SB-564	...	N06230	110 (760)	43	111	420	43	53Ni-22Cr-14W-Co-Fe-Mo	Forgings	...
B/SB-564	...	N06600	80 (550)	43	111	420	43	72Ni-15Cr-8Fe	Forgings	...
B/SB-564	...	N06617	95 (655)	43	111	420	46	52Ni-22Cr-13Co-9Mo	Forgings	...
B/SB-564	...	N06625	110 (760)	43	111	430	43	60Ni-22Cr-9Mo-3.5Cb	Forgings	>4 (100) ≤10 (250)
B/SB-564	...	N06625	120 (825)	43	111	430	43	60Ni-22Cr-9Mo-3.5Cb	Forgings	≤4 (100)
B/SB-564	...	N06686	100 (690)	43	111	430	43	58Ni-21Cr-16Mo-3.5W	Forgings	...
B/SB-564	...	N06690	85 (585)	43	111	420	43	58Ni-29Cr-9Fe	Forgings	...
B/SB-564	...	N08031	94 (650)	45	111	420	45	31Ni-31Fe-27Cr-7Mo	Forgings	...
B/SB-564	...	N08120	90 (620)	45	111	430	45	37Ni-33Fe-25Cr	Forgings	...
B/SB-564	...	N08367	95 (655)	45	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Forgings	...
B/SB-564	...	N08800	75 (515)	45	111	430	45	33Ni-42Fe-21Cr	Forgings	...
B/SB-564	...	N08810	65 (450)	45	111	430	45	33Ni-42Fe-21Cr	Forgings	...
B/SB-564	...	N08811	65 (450)	45	111	430	44	33Ni-42Fe-21Cr-Al-Ti	Forgings	...
B/SB-564	...	N08825	85 (585)	45	111	430	45	42Ni-21.5Cr-3Mo-2.3Cu	Forgings	...
B/SB-564	...	N10242	105 (725)	44	112	410	44	62Ni-25Mo-8Cr-2Fe	Forgings	...
B/SB-564	...	N10276	100 (690)	43	111	420	43	54Ni-16Mo-15Cr	Forgings	...
B/SB-564	...	N10362	105 (725)	43	111	420	43	62Ni-22Mo-15Cr	Forgings	...
B/SB-564	...	N10629	110 (760)	44	112	410	44	66Ni-28Mo-3Fe-1.3Cr-0.25Al	Forgings	...
B/SB-564	...	N10665	110 (760)	44	112	410	44	65Ni-28Mo-2Fe	Forgings	...
B/SB-564	...	N10675	110 (760)	44	112	410	44	65Ni-29.5Mo-2Fe-2Cr	Forgings	...
B/SB-564	...	N12160	90 (620)	46	...	420	46	37Ni-30Co-28Cr-2.7Si	Forgings	...
B/SB-564	...	R20033	109 (750)	45	111	420	45	33Cr-31Ni-32Fe-1.5Mo-0.6Cu-N	Forgings	...
B/SB-572	...	N06002	95 (655)	43	111	420	43	47Ni-22Cr-9Mo-18Fe	Rod	...
B/SB-572	...	N06230	110 (760)	43	111	420	43	53Ni-22Cr-14W-Co-Fe-Mo	Rod	...
B/SB-572	...	N12160	90 (620)	46	...	420	46	37Ni-30Co-28Cr-2.7Si	Rod	...
B/SB-572	...	R30556	100 (690)	45	111	420	45	21Ni-30Fe-22Cr-18Co-3Mo-3W	Rod	...
B/SB-573	...	N10003	100 (690)	44	112	430	44	70Ni-16Mo-7Cr-5Fe	Rod	...
B/SB-573	...	N10242	105 (725)	44	112	410	44	62Ni-25Mo-8Cr-2Fe	Rod	...
B/SB-574	...	N06022	100 (690)	43	111	420	43	55Ni-21Cr-13.5Mo	Rod	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing			ISO 15608			Typical Product Form	Thickness Limits, Nominal in. (mm)	
					P-No.	AWS B2.2 BM	Group	Nominal Composition					
Nonferrous (Cont'd)													
B/SB-574	...	N06035	85 (585)	43	111	420	43	58Ni-33Cr-8Mo		Rod	...		
B/SB-574	...	N06059	100 (690)	43	111	420	43	59Ni-23Cr-16Mo		Rod	...		
B/SB-574	...	N06200	100 (690)	43	111	420	43	59Ni-23Cr-16Mo-1.6Cu		Rod	...		
B/SB-574	...	N06210	100 (690)	43	111	420	43	60Ni-19Cr-19Mo-1.8Ta		Rod	...		
B/SB-574	...	N06455	100 (690)	43	111	420	43	61Ni-16Mo-16Cr		Rod	...		
B/SB-574	...	N06686	100 (690)	43	111	430	43	58Ni-21Cr-16Mo-3.5W		Rod	...		
B/SB-574	...	N10276	100 (690)	43	111	420	43	54Ni-16Mo-15Cr		Rod	...		
B/SB-574	...	N10362	105 (725)	43	111	420	43	62Ni-22Mo-15Cr		Rod	...		
B/SB-575	...	N06022	100 (690)	43	111	420	43	55Ni-21Cr-13.5Mo		Plate, sheet & strip	...		
B/SB-575	...	N06035	85 (585)	43	111	420	43	58Ni-33Cr-8Mo		Plate, sheet & strip	...		
B/SB-575	...	N06059	100 (690)	43	111	420	43	59Ni-23Cr-16Mo		Plate, sheet & strip	...		
B/SB-575	...	N06200	100 (690)	43	111	420	43	59Ni-23Cr-16Mo-1.6Cu		Plate, sheet & strip	...		
B/SB-575	...	N06210	100 (690)	43	111	420	43	60Ni-19Cr-19Mo-1.8Ta		Plate, sheet & strip	...		
B/SB-575	...	N06455	100 (690)	43	111	420	43	61Ni-16Mo-16Cr		Plate, sheet & strip	...		
B/SB-575	...	N06686	100 (690)	43	111	430	43	58Ni-21Cr-16Mo-3.5W		Plate, sheet & strip	...		
B/SB-575	...	N10276	100 (690)	43	111	420	43	54Ni-16Mo-15Cr		Plate, sheet & strip	...		
B/SB-575	...	N10362	105 (725)	43	111	420	43	62Ni-22Mo-15Cr		Plate, sheet & strip	...		
B/SB-581	...	N06007	85 (585)	45	111	420	43	47Ni-22Cr-19Fe-6Mo		Rod	>0.75 (19) ≤3.5 (90) dia.		
B/SB-581	...	N06007	90 (620)	45	111	420	43	47Ni-22Cr-19Fe-6Mo		Rod	≥0.3125 (8) ≤0.75 (19) dia.		
B/SB-581	...	N06030	85 (585)	45	111	420	45	40Ni-29Cr-15Fe-5Mo		Rod	...		
B/SB-581	...	N06975	85 (585)	45	111	430	45	49Ni-25Cr-18Fe-6Mo		Rod	...		
B/SB-581	...	N06985	85 (585)	45	111	420	45	47Ni-22Cr-20Fe-7Mo		Rod	>0.75 (19) ≤3.5 (90) dia.		
B/SB-581	...	N06985	90 (620)	45	111	420	45	47Ni-22Cr-20Fe-7Mo		Rod	≥0.3125 (8) ≤0.75 (19) dia.		
B/SB-581	...	N08031	94 (650)	45	111	420	45	31Ni-31Fe-27Cr-7Mo		Rod	...		
B/SB-582	...	N06007	85 (585)	45	111	420	43	47Ni-22Cr-19Fe-6Mo		Plate, sheet & strip	>0.75 (19) ≤2.5 (65)		
B/SB-582	...	N06007	90 (620)	45	111	420	43	47Ni-22Cr-19Fe-6Mo		Plate, sheet & strip	≤0.75 (19)		
B/SB-582	...	N06030	85 (585)	45	111	420	45	40Ni-29Cr-15Fe-5Mo		Plate, sheet & strip	...		
B/SB-582	...	N06975	85 (585)	45	111	430	45	49Ni-25Cr-18Fe-6Mo		Plate, sheet & strip	...		
B/SB-582	...	N06985	85 (585)	45	111	420	45	47Ni-22Cr-20Fe-7Mo		Plate, sheet & strip	>0.75 (19) ≤2.5 (65)		
B/SB-582	...	N06985	90 (620)	45	111	420	45	47Ni-22Cr-20Fe-7Mo		Plate, sheet & strip	≤0.75 (19)		

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing		ISO 15608		Typical Product Form	Thickness Limits, Nominal in. (mm)
					P-No.	AWS B2.2 BM	Group	Nominal Composition		
Nonferrous (Cont'd)										
B/SB-599	...	N08700	80 (550)	45	111	420	8.2	25Ni-47Fe-21Cr-5Mo	Plate, sheet & strip	...
B/SB-619	...	N06002	100 (690)	43	111	420	43	47Ni-22Cr-9Mo-18Fe	Welded pipe	...
B/SB-619	...	N06007	90 (620)	45	111	420	43	47Ni-22Cr-19Fe-6Mo	Welded pipe	...
B/SB-619	...	N06022	100 (690)	43	111	420	43	55Ni-21Cr-13.5Mo	Welded pipe	...
B/SB-619	...	N06030	85 (585)	45	111	420	45	40Ni-29Cr-15Fe-5Mo	Welded pipe	...
B/SB-619	...	N06035	85 (585)	43	111	420	43	58Ni-33Cr-8Mo	Welded pipe	...
B/SB-619	...	N06059	100 (690)	43	111	420	43	59Ni-23Cr-16Mo	Welded pipe	...
B/SB-619	...	N06200	100 (690)	43	111	420	43	59Ni-23Cr-16Mo-1.6Cu	Welded pipe	...
B/SB-619	...	N06210	100 (690)	43	111	420	43	60Ni-19Cr-19Mo-1.8Ta	Welded pipe	...
B/SB-619	...	N06230	110 (760)	43	111	420	43	53Ni-22Cr-14W-Co-Fe-Mo	Welded pipe	...
B/SB-619	...	N06455	100 (690)	43	111	420	43	61Ni-16Mo-16Cr	Welded pipe	...
B/SB-619	...	N06686	100 (690)	43	111	430	43	58Ni-21Cr-16Mo-3.5W	Welded pipe	...
B/SB-619	...	N06975	85 (585)	45	111	430	45	49Ni-25Cr-18Fe-6Mo	Welded pipe	...
B/SB-619	...	N06985	90 (620)	45	111	420	45	47Ni-22Cr-20Fe-7Mo	Welded pipe	...
B/SB-619	...	N08031	94 (650)	45	111	420	45	31Ni-31Fe-27Cr-7Mo	Welded pipe	...
B/SB-619	...	N08320	75 (515)	45	111	430	8.2	26Ni-22Cr-5Mo-Ti	Welded pipe	...
B/SB-619	...	N10001	100 (690)	44	112	410	44	62Ni-28Mo-5Fe	Welded pipe	...
B/SB-619	...	N10242	105 (725)	44	112	410	44	62Ni-25Mo-8Cr-2Fe	Welded pipe	...
B/SB-619	...	N10276	100 (690)	43	111	420	43	54Ni-16Mo-15Cr	Welded pipe	...
B/SB-619	...	N10362	105 (725)	43	111	420	43	62Ni-22Mo-15Cr	Welded pipe	...
B/SB-619	...	N10629	110 (760)	44	112	410	44	66Ni-28Mo-3Fe-1.3Cr-0.25Al	Welded pipe	...
B/SB-619	...	N10665	110 (760)	44	112	410	44	65Ni-28Mo-2Fe	Welded pipe	...
B/SB-619	...	N10675	110 (760)	44	112	410	44	65Ni-29.5Mo-2Fe-2Cr	Welded pipe	...
B/SB-619	...	N12160	90 (620)	46	...	420	46	37Ni-30Co-28Cr-2.7Si	Welded pipe	...
B/SB-619	...	R20033	109 (750)	45	111	420	45	33Cr-31Ni-32Fe-1.5Mo-0.6Cu-N	Welded pipe	...
B/SB-619	...	R30556	100 (690)	45	111	420	45	21Ni-30Fe-22Cr-18Co-3Mo-3W	Welded pipe	...
B/SB-620	...	N08320	75 (515)	45	111	430	8.2	26Ni-22Cr-5Mo-Ti	Plate, sheet & strip	...
B/SB-621	...	N08320	75 (515)	45	111	420	8.2	26Ni-22Cr-5Mo-Ti	Rod	...
B/SB-622	...	N06002	100 (690)	43	111	420	43	47Ni-22Cr-9Mo-18Fe	Smls. pipe & tube	...
B/SB-622	...	N06007	90 (620)	45	111	420	43	47Ni-22Cr-19Fe-6Mo	Smls. pipe & tube	...
B/SB-622	...	N06022	100 (690)	43	111	420	43	55Ni-21Cr-13.5Mo	Smls. pipe & tube	...
B/SB-622	...	N06030	85 (585)	45	111	420	45	40Ni-29Cr-15Fe-5Mo	Smls. pipe & tube	...
B/SB-622	...	N06035	85 (585)	43	111	420	43	58Ni-33Cr-8Mo	Smls. pipe & tube	...
B/SB-622	...	N06059	100 (690)	43	111	420	43	59Ni-23Cr-16Mo	Smls. pipe & tube	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing		ISO 15608 Group	Nominal Composition	Typical Product Form	Thickness Limits, Nominal in. (mm)
					P-No.	AWS B2.2 BM				
Nonferrous (Cont'd)										
B/SB-622	...	N06200	100 (690)	43	111	420	43	59Ni-23Cr-16Mo-1.6Cu	Smls. pipe & tube	...
B/SB-622	...	N06210	100 (690)	43	111	420	43	60Ni-19Cr-19Mo-1.8Ta	Smls. pipe & tube	...
B/SB-622	...	N06230	110 (760)	43	111	420	43	53Ni-22Cr-14W-Co-Fe-Mo	Smls. pipe & tube	...
B/SB-622	...	N06455	100 (690)	43	111	420	43	61Ni-16Mo-16Cr	Smls. pipe & tube	...
B/SB-622	...	N06686	100 (690)	43	111	430	43	58Ni-21Cr-16Mo-3.5W	Smls. pipe & tube	...
B/SB-622	...	N06975	85 (585)	45	111	430	45	49Ni-25Cr-18Fe-6Mo	Smls. pipe & tube	...
B/SB-622	...	N06985	90 (620)	45	111	420	45	47Ni-22Cr-20Fe-7Mo	Smls. pipe & tube	...
B/SB-622	...	N08031	94 (650)	45	111	420	45	31Ni-31Fe-27Cr-7Mo	Smls. pipe & tube	...
B/SB-622	...	N08320	75 (515)	45	111	430	8.2	26Ni-22Cr-5Mo-Ti	Smls. pipe & tube	...
B/SB-622	...	N10001	100 (690)	44	112	410	44	62Ni-28Mo-5Fe	Smls. pipe & tube	...
B/SB-622	...	N10242	105 (725)	44	112	410	44	62Ni-25Mo-8Cr-2Fe	Smls. pipe & tube	...
B/SB-622	...	N10276	100 (690)	43	111	420	43	54Ni-16Mo-15Cr	Smls. pipe & tube	...
B/SB-622	...	N10362	105 (725)	43	111	420	43	62Ni-22Mo-15Cr	Smls. pipe & tube	...
B/SB-622	...	N10629	110 (760)	44	112	410	44	66Ni-28Mo-3Fe-1.3Cr-0.25Al	Smls. pipe & tube	...
B/SB-622	...	N10665	110 (760)	44	112	410	44	65Ni-28Mo-2Fe	Smls. pipe & tube	...
B/SB-622	...	N10675	110 (760)	44	112	410	44	65Ni-29.5Mo-2Fe-2Cr	Smls. pipe & tube	...
B/SB-622	...	N12160	90 (620)	46	...	420	46	37Ni-30Co-28Cr-2.7Si	Smls. pipe & tube	...
B/SB-622	...	R20033	109 (750)	45	111	420	45	33Cr-31Ni-32Fe-1.5Mo-0.6Cu-N	Smls. pipe & tube	...
B/SB-622	...	R30556	100 (690)	45	111	420	45	21Ni-30Fe-22Cr-18Co-3Mo-3W	Smls. pipe & tube	...
B/SB-625	...	N08031	94 (650)	45	111	420	45	31Ni-31Fe-27Cr-7Mo	Plate, sheet & strip	...
B/SB-625	...	N08904	71 (490)	45	111	420	8.2	44Fe-25Ni-21Cr-Mo	Plate, sheet & strip	...
B/SB-625	...	N08925	87 (600)	45	111	420	8.2	25Ni-20Cr-6Mo-Cu-N	Plate, sheet & strip	...
B/SB-625	...	N08926	94 (650)	45	111	420	8.2	25Ni-20Cr-6Mo-Co-N	Plate, sheet & strip	...
B/SB-625	...	R20033	109 (750)	45	111	420	45	33Cr-31Ni-32Fe-1.5Mo-0.6Cu-N	Plate, sheet & strip	...
B/SB-626	...	N06002	100 (690)	43	111	420	43	47Ni-22Cr-9Mo-18Fe	Welded tube	...
B/SB-626	...	N06007	90 (620)	45	111	420	43	47Ni-22Cr-19Fe-6Mo	Welded tube	...
B/SB-626	...	N06022	100 (690)	43	111	420	43	55Ni-21Cr-13.5Mo	Welded tube	...
B/SB-626	...	N06030	85 (585)	45	111	420	45	40Ni-29Cr-15Fe-5Mo	Welded tube	...
B/SB-626	...	N06035	85 (585)	43	111	420	43	58Ni-33Cr-8Mo	Welded tube	...
B/SB-626	...	N06059	100 (690)	43	111	420	43	59Ni-23Cr-16Mo	Welded tube	...
B/SB-626	...	N06200	100 (690)	43	111	420	43	59Ni-23Cr-16Mo-1.6Cu	Welded tube	...
B/SB-626	...	N06210	100 (690)	43	111	420	43	60Ni-19Cr-19Mo-1.8Ta	Welded tube	...
B/SB-626	...	N06230	110 (760)	43	111	420	43	53Ni-22Cr-14W-Co-Fe-Mo	Welded tube	...
B/SB-626	...	N06455	100 (690)	43	111	420	43	61Ni-16Mo-16Cr	Welded tube	...
B/SB-626	...	N06686	100 (690)	43	111	430	43	58Ni-21Cr-16Mo-3.5W	Welded tube	...
B/SB-626	...	N06975	85 (585)	45	111	430	45	49Ni-25Cr-18Fe-6Mo	Welded tube	...

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing		ISO 15608 Group	Nominal Composition	Typical Product Form	Thickness Limits, Nominal in. (mm)
					P-No.	AWS B2.2 BM				
Nonferrous (Cont'd)										
B/SB-626	...	N06985	90 (620)	45	111	420	45	47Ni-22Cr-20Fe-7Mo	Welded tube	...
B/SB-626	...	N08031	94 (650)	45	111	420	45	31Ni-31Fe-27Cr-7Mo	Welded tube	...
B/SB-626	...	N08320	75 (515)	45	111	430	8.2	26Ni-22Cr-5Mo-Ti	Welded tube	...
B/SB-626	...	N10001	100 (690)	44	112	410	44	62Ni-28Mo-5Fe	Welded tube	...
B/SB-626	...	N10242	105 (725)	44	112	410	44	62Ni-25Mo-8Cr-2Fe	Welded tube	...
B/SB-626	...	N10276	100 (690)	43	111	420	43	54Ni-16Mo-15Cr	Welded tube	...
B/SB-626	...	N10362	105 (725)	43	111	420	43	62Ni-22Mo-15Cr	Welded tube	...
B/SB-626	...	N10629	110 (760)	44	112	410	44	66Ni-28Mo-3Fe-1.3Cr-0.25Al	Welded tube	...
B/SB-626	...	N10665	110 (760)	44	112	410	44	65Ni-28Mo-2Fe	Welded tube	...
B/SB-626	...	N10675	110 (760)	44	112	410	44	65Ni-29.5Mo-2Fe-2Cr	Welded tube	...
B/SB-626	...	N12160	90 (620)	46	...	420	46	37Ni-30Co-28Cr-2.7Si	Welded tube	...
B/SB-626	...	R20033	109 (750)	45	111	420	45	33Cr-31Ni-32Fe-1.5Mo-0.6Cu-N	Welded tube	...
B/SB-626	...	R30556	100 (690)	45	111	420	45	21Ni-30Fe-22Cr-18Co-3Mo-3W	Welded tube	...
B/SB-649	...	N08904	71 (490)	45	111	420	8.2	44Fe-25Ni-21Cr-Mo	Bar & wire	...
B/SB-649	...	N08925	87 (600)	45	111	420	8.2	25Ni-20Cr-6Mo-Cu-N	Bar & wire	...
B/SB-649	...	N08926	94 (650)	45	111	420	8.2	25Ni-20Cr-6Mo-Cu-N	Bar & wire	...
B/SB-649	...	R20033	109 (750)	45	111	420	45	33Cr-31Ni-32Fe-1.5Mo-0.6Cu-N	Bar & wire	...
B/SB-653	R60702	R60702	55 (380)	61	117	600	61	99.2Zr	Smls. & welded fittings	...
B/SB-658	R60702	R60702	55 (380)	61	117	600	61	99.2Zr	Smls. & welded pipe	...
B/SB-658	R60705	R60705	80 (550)	62	117	600	62	95.5Zr+2.5Cb	Smls. & welded pipe	...
B/SB-668	...	N08028	73 (505)	45	111	420	45	31Ni-31Fe-29Cr-Mo	Smls. tube	...
B/SB-672	...	N08700	80 (550)	45	111	420	8.2	25Ni-47Fe-21Cr-5Mo	Bar & wire	...
B/SB-673	...	N08904	71 (490)	45	111	420	8.2	44Fe-25Ni-21Cr-Mo	Welded pipe	...
B/SB-673	...	N08925	87 (600)	45	111	420	8.2	25Ni-20Cr-6Mo-Cu-N	Welded pipe	...
B/SB-673	...	N08926	94 (650)	45	111	420	8.2	25Ni-20Cr-6Mo-Cu-N	Welded pipe	...
B/SB-674	...	N08354	93 (640)	45	111	420	45	35Ni-23Cr-7.5Mo-N	Welded tube	...
B/SB-674	...	N08904	71 (490)	45	111	420	8.2	44Fe-25Ni-21Cr-Mo	Welded tube	...
B/SB-674	...	N08925	87 (600)	45	111	420	8.2	25Ni-20Cr-6Mo-Cu-N	Welded tube	...
B/SB-674	...	N08926	94 (650)	45	111	420	8.2	25Ni-20Cr-6Mo-Cu-N	Welded tube	...
B/SB-675	...	N08367	95 (655)	45	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Welded pipe	>0.187 (5)
B/SB-675	...	N08367	100 (690)	45	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N	Welded pipe	≤0.187 (5)

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing			ISO 15608			Typical Product Form	Thickness Limits, Nominal in. (mm)	
					AWS P-No.	B2.2 BM	Group	Nominal Composition					
Nonferrous (Cont'd)													
B/SB-676	...	N08367	95 (655)	45	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N			Welded tube	>0.187 (5)	
B/SB-676	...	N08367	100 (690)	45	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N			Welded tube	≤0.187 (5)	
B/SB-677	...	N08904	71 (490)	45	111	420	8.2	44Fe-25Ni-21Cr-Mo			Smls. pipe & tube	...	
B/SB-677	...	N08925	87 (600)	45	111	420	8.2	25Ni-20Cr-6Mo-Cu-N			Smls. pipe & tube	...	
B/SB-677	...	N08926	94 (650)	45	111	420	8.2	25Ni-20Cr-6Mo-Cu-N			Smls. pipe & tube	...	
B/SB-688	...	N08367	95 (655)	45	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N			Plate, sheet & strip	>0.187 (5)	
B/SB-688	...	N08367	100 (690)	45	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N			Plate, sheet & strip	≤0.187 (5)	
B/SB-690	...	N08367	95 (655)	45	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N			Smls. pipe & tube	>0.187 (5)	
B/SB-690	...	N08367	100 (690)	45	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N			Smls. pipe & tube	≤0.187 (5)	
B/SB-691	...	N08367	95 (655)	45	111	420	8.2	46Fe-24Ni-21Cr-6Mo-N			Rod, bar & wire	...	
B/SB-704	1	N06625	120 (825)	43	111	430	43	60Ni-22Cr-9Mo-3.5Cb			Welded tube	...	
B/SB-704	2	N06625	100 (690)	43	111	430	43	60Ni-22Cr-9Mo-3.5Cb			Welded tube	...	
B/SB-704	...	N08825	85 (585)	45	111	430	45	42Ni-21.5Cr-3Mo-2.3Cu			Welded tube	...	
B/SB-705	1	N06625	120 (825)	43	111	430	43	60Ni-22Cr-9Mo-3.5Cb			Welded pipe	...	
B/SB-705	2	N06625	100 (690)	43	111	430	43	60Ni-22Cr-9Mo-3.5Cb			Welded pipe	...	
B/SB-705	...	N08825	85 (585)	45	111	430	45	42Ni-21.5Cr-3Mo-2.3Cu			Welded pipe	...	
B/SB-709	...	N08028	73 (505)	45	111	420	45	31Ni-31Fe-29Cr-Mo			Plate, sheet & strip	...	
B/SB-710	...	N08330	70 (485)	46	111	420	45	35Ni-19Cr-1.25Si			Welded pipe	...	
B725	...	N02200	55 (380)	41	110	400	41	99.0Ni			Welded pipe	...	
B725	...	N02201	50 (345)	41	110	400	41	99.0Ni-Low C			Welded pipe	...	
B725	...	N04400	70 (485)	42	110	400	42	67Ni-30Cu			Welded pipe	...	
B/SB-729	...	N08020	80 (550)	45	111	420	45	35Ni-35Fe-20Cr-Cb			Smls. pipe & tube	...	
B730	...	N02200	55 (380)	41	110	400	41	99.0Ni			Welded tube	...	
B730	...	N02201	50 (345)	41	110	400	41	99.0Ni-Low C			Welded tube	...	
B730	...	N04400	70 (485)	42	110	400	42	67Ni-30Cu			Welded tube	...	
B/SB-752	702C	R60702	55 (380)	61	117	600	61	99.2Zr			Castings	...	
B/SB-752	705C	R60705	70 (485)	62	117	600	62	95.5Zr + 2.5Cb			Castings	...	
B/SB-815	...	R31233	120 (825)	49	...	800	...	Co-26Cr-9Ni-5Mo-3Fe-2W			Rod	...	

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing			ISO 15608			Typical Product Form	Thickness Limits, Nominal in. (mm)
					AWS	P-No.	B2.2 BM	Group	Nominal Composition			
Nonferrous (Cont'd)												
B/SB-818	...	R31233	120 (825)	49	...	800	...	Co-26Cr-9Ni-5Mo-3Fe-2W		Plate, sheet & strip	...	
B819	C12200	C12200	30 (205)	...	107	300	NA	99.9Cu-P		Wrought pipe	...	
B/SB-861	1	R50250	35 (240)	51	115	500	51.1	Ti		Smls. pipe	...	
B/SB-861	2	R50400	50 (345)	51	115	500	51.2	Ti		Smls. pipe	...	
B/SB-861	2H	R50400	58 (400)	51	115	500	51.2	Ti		Smls. pipe	...	
B/SB-861	3	R50550	65 (450)	52	115	500	51.3	Ti		Smls. pipe	...	
B/SB-861	7	R52400	50 (345)	51	115	500	52	Ti-Pd		Smls. pipe	...	
B/SB-861	7H	R52400	58 (400)	51	115	500	52	Ti-Pd		Smls. pipe	...	
B/SB-861	16	R52402	50 (345)	51	115	500	51.2	Ti-Pd		Smls. pipe	...	
B/SB-861	16H	R52402	58 (400)	51	115	500	51.2	Ti-Pd		Smls. pipe	...	
B/SB-861	26	R52404	50 (345)	51	115	500	51.2	Ti-Ru		Smls. pipe	...	
B/SB-861	26H	R52404	58 (400)	51	115	500	51.2	Ti-Ru		Smls. pipe	...	
B/SB-861	12	R53400	70 (485)	52	115	500	52	Ti-0.3Mo-0.8Ni		Smls. pipe	...	
B/SB-861	38	R54250	130 (895)	54	115	500	53	Ti-4Al-2.5V-1.5Fe		Smls. pipe	...	
B/SB-861	9	R56320	90 (620)	53	115	500	53	Ti-3Al-2.5V		Smls. pipe	...	
B/SB-861	28	R56323	90 (620)	53	115	500	53	Ti-3Al-2.5V-0.1Ru		Smls. pipe	...	
B/SB-862	1	R50250	35 (240)	51	115	500	51.1	Ti		Welded pipe	...	
B/SB-862	2	R50400	50 (345)	51	115	500	51.2	Ti		Welded pipe	...	
B/SB-862	2H	R50400	58 (400)	51	115	500	51.2	Ti		Welded pipe	...	
B/SB-862	3	R50550	65 (450)	52	115	500	51.3	Ti		Welded pipe	...	
B/SB-862	7	R52400	50 (345)	51	115	500	52	Ti-Pd		Welded pipe	...	
B/SB-862	7H	R52400	58 (400)	51	115	500	52	Ti-Pd		Welded pipe	...	
B/SB-862	16	R52402	50 (345)	51	115	500	51.2	Ti-Pd		Welded pipe	...	
B/SB-862	16H	R52402	58 (400)	51	115	500	51.2	Ti-Pd		Welded pipe	...	
B/SB-862	26	R52404	50 (345)	51	115	500	51.2	Ti-Ru		Welded pipe	...	
B/SB-862	26H	R52404	58 (400)	51	115	500	51.2	Ti-Ru		Welded pipe	...	
B/SB-862	12	R53400	70 (485)	52	115	500	52	Ti-0.3Mo-0.8Ni		Welded pipe	...	
B/SB-862	38	R54250	130 (895)	54	115	500	53	Ti-4Al-2.5V-1.5Fe		Welded pipe	...	
B/SB-862	9	R56320	90 (620)	53	115	500	53	Ti-3Al-2.5V		Welded pipe	...	
B/SB-862	28	R56323	90 (620)	53	115	500	53	Ti-3Al-2.5V-0.1Ru		Welded pipe	...	
B/SB-928	5083	A95083	39 (270)	25	105	220	22.4	Al-4.4Mg-Mn		Plate & sheet	>1.5 (38) ≤3 (75)	
B/SB-928	5086	A95086	35 (240)	25	105	220	22.4	Al-4.0Mg-Mn		Plate & sheet	>0.05 (1.3) ≤2 (50)	
B/SB-928	5456	A95456	41 (285)	25	105	220	22.4	Al-5.1Mg-Mn		Plate & sheet	>1.5 (38) ≤3 (75)	

Table QW/QB-422
Ferrous and Nonferrous P-Numbers
Grouping of Base Metals for Qualification (Cont'd)

Spec. No.	Alloy, Type, or Grade	UNS No.	Minimum Specified Tensile, ksi (MPa)	Weld- ing P-No.	Brazing		ISO 15608		Typical Product Form	Thickness Limits, Nominal in. (mm)
					AWS P-No.	B2.2 BM	Group	Nominal Composition		
Nonferrous (Cont'd)										
B/SB-956	...	C70600	40 (275)	34	107	300	34	90Cu-10Ni	Finned welded tube	...
B/SB-956	...	C70620	40 (275)	34	107	300	34	90Cu-10Ni	Finned welded tube	...
B/SB-956	...	C71500	52 (360)	34	107	300	34	70Cu-30Ni	Finned welded tube	...
B/SB-956	...	C71520	52 (360)	34	107	300	34	70Cu-30Ni	Finned welded tube	...
EN or SB/EN 1706	EN AC 43000	...	22 (150)	26	104	210	24.2	Al-10Si-Mg	Castings	...

QW-423 ALTERNATE BASE MATERIALS FOR WELDER QUALIFICATION

QW-423.1 Base metal used for welder qualification may be substituted for the base metal specified in the WPS in accordance with the following table. Any base metal shown in the same row may be substituted in the performance qualification test coupon for the base metal(s) specified in the WPS followed during welder qualification. When a base metal shown in the left column of the table is used for welder qualification, the welder is qualified to weld all combinations of base metals shown in the right column, including unassigned metals of similar chemical composition to these metals.

Base Metal(s) Used for Performance Qualification	Base Metals Qualified
P-No. 1 through P-No. 15F, P-No. 34, or P-No. 41 through P-No. 49	P-No. 1 through P-No. 15F, P-No. 34, and P-No. 41 through P-No. 49
<u>P-No. 21 through P-No. 26</u>	<u>P-No. 21 through P-No. 26</u>
P-No. 51 through P-No. 53 or P-No. 61 or P-No. 62	P-No. 51 through P-No. 53 and P-No. 61 and P-No. 62
Any unassigned metal to the same unassigned metal	The unassigned metal to itself
Any unassigned metal to any P-Number metal	The unassigned metal to any metal assigned to the same P-Number as the qualified metal
Any unassigned metal to any other unassigned metal	The first unassigned metal to the second unassigned metal

Base Metal(s) Used for Procedure Qualification Coupon	Base Metals Qualified
One metal from a P-Number to any metal from the same P-Number	Any metals assigned that P-Number
One metal from a P-Number to any metal from any other P-Number	Any metal assigned the first P-Number to any metal assigned the second P-Number
One metal from P-No. 15E to any metal from P-No. 15E	Any P-No. 15E or 5B metal to any metal assigned P-No. 15E or 5B
One metal from P-No. 15E to any metal from any other P-Number	Any P-No. 15E or 5B metal to any metal assigned the second P-Number
One metal from P-No. 3 to any metal from P-No. 3	Any P-No. 3 metal to any metal assigned P-No. 3 or 1
One metal from P-No. 4 to any metal from P-No. 4	Any P-No. 4 metal to any metal assigned P-No. 4, 3, or 1
One metal from P-No. 5A to any metal from P-No. 5A	Any P-No. 5A metal to any metal assigned P-No. 5A, 4, 3, or 1
One metal from P-No. 5A to a metal from P-No. 4, or P-No. 3, or P-No. 1	Any P-No. 5A metal to any metal assigned to P-No. 4, 3, or 1
One metal from P-No. 4 to a metal from P-No. 3 or P-No. 1	Any P-No. 4 metal to any metal assigned to P-No. 3 or 1
Any unassigned metal to the same unassigned metal	The unassigned metal to itself
Any unassigned metal to any P-Number metal	The unassigned metal to any metal assigned to the same P-Number as the qualified metal
Any unassigned metal to any metal from P-No. 15E	The unassigned metal to any metal assigned P-No. 15E or 5B
Any unassigned metal to any other unassigned metal	The first unassigned metal to the second unassigned metal

- (21) **QW-423.2** A base metal used for welder qualification conforming to national or international standards or specifications may be considered as having the same P-Number as an assigned metal provided it meets the mechanical and chemical requirements of the assigned metal. The base metal specification and corresponding P-Number shall be recorded on the qualification record.

QW-424 BASE METALS USED FOR PROCEDURE QUALIFICATION

QW-424.1 Base metals are assigned P-Numbers in [Table QW/QB-422](#); metals that do not appear in [Table QW/QB-422](#) are considered to be unassigned metals except as otherwise defined for base metals having the same UNS numbers. Unassigned metals shall be identified in the WPS and on the PQR by specification, type, and grade, or by chemical analysis and mechanical properties. The minimum tensile strength shall be defined by the organization that specified the unassigned metal if the tensile strength of that metal is not defined by the material specification.

QW-424.2 For welds joining base metals to weld metal buildup or corrosion-resistant weld metal overlay, the buildup or overlay portion of the joint may be substituted in the test coupon by any P-Number base material that nominally matches the chemical analysis of the buildup or overlay.

QW-430 F-NUMBERS

QW-431 GENERAL

The following F-Number grouping of electrodes and welding rods in [Table QW-432](#) is based essentially on their usability characteristics, which fundamentally determine the ability of welders to make satisfactory welds with a given filler metal. This grouping is made to reduce the number of welding procedure and performance qualifications, where this can logically be done. The grouping does not imply that base metals or filler metals within a

group may be indiscriminately substituted for a metal that was used in the qualification test without consideration of the compatibility of the base and filler metals from

the standpoint of metallurgical properties, postweld heat treatment design and service requirements, and mechanical properties.

(21)

**Table QW-432
F-Numbers
Grouping of Electrodes and Welding Rods for Qualification**

F-No.	ASME Specification	AWS Classification	UNS No.
Steel and Steel Alloys			
1	SFA-5.1	EXX20	...
1	SFA-5.1	EXX22	...
1	SFA-5.1	EXX24	...
1	SFA-5.1	EXX27	...
1	SFA-5.1	EXX28	...
1	SFA-5.4	EXXX(X)-26	...
1	SFA-5.5	EXX20-X	...
1	SFA-5.5	EXX27-X	...
2	SFA-5.1	EXX12	...
2	SFA-5.1	EXX13	...
2	SFA-5.1	EXX14	...
2	SFA-5.1	EXX19	...
2	SFA-5.5	E(X)XX13-X	...
3	SFA-5.1	EXX10	...
3	SFA-5.1	EXX11	...
3	SFA-5.5	E(X)XX10-X	...
3	SFA-5.5	E(X)XX11-X	...
4	SFA-5.1	EXX15	...
4	SFA-5.1	EXX16	...
4	SFA-5.1	EXX18	...
4	SFA-5.1	EXX18M	...
4	SFA-5.1	EXX48	...
4	SFA-5.4 other than austenitic and duplex	EXXX(X)-15	...
4	SFA-5.4 other than austenitic and duplex	EXXX(X)-16	...
4	SFA-5.4 other than austenitic and duplex	EXXX(X)-17	...
4	SFA-5.5	E(X)XX15-X	...
4	SFA-5.5	E(X)XX16-X	...
4	SFA-5.5	E(X)XX18-X	...
4	SFA-5.5	E(X)XX18M	...
4	SFA-5.5	E(X)XX18M1	...
4	SFA-5.5	E(X)XX45	...
5	SFA-5.4 austenitic and duplex	EXXX(X)-15	...
5	SFA-5.4 austenitic and duplex	EXXX(X)-16	...
5	SFA-5.4 austenitic and duplex	EXXX(X)-17	...
6	SFA-5.2	All classifications	...
6	SFA-5.9	All classifications	...
6	SFA-5.17	All classifications	...
6	SFA-5.18	All classifications	...
6	SFA-5.20	All classifications	...
6	SFA-5.22	All classifications	...
6	SFA-5.23	All classifications	...
6	SFA-5.25	All classifications	...
6	SFA-5.26	All classifications	...
6	SFA-5.28	All classifications	...
6	SFA-5.29	All classifications	...
6	SFA-5.30	INMs-X	...

Table QW-432
F-Numbers
Grouping of Electrodes and Welding Rods for Qualification (Cont'd)

F-No.	ASME Specification	AWS Classification	UNS No.
Steel and Steel Alloys (Cont'd)			
6	SFA-5.30	IN5XX	...
6	SFA-5.30	IN3XX(X)	...
6	SFA-5.39	All classifications	...
Aluminum and Aluminum Alloys			
21	SFA-5.3	E1100	A91100
21	SFA-5.3	E3003	A93003
21	SFA-5.10	ER1070	A91070
21	SFA-5.10	ER1080A	A91080
21	SFA-5.10	ER1100	A91100
21	SFA-5.10	ER1188	A91188
21	SFA-5.10	ER1200	A91200
21	SFA-5.10	ER1450	A91450
21	SFA-5.10	ER3103	A93103
21	SFA-5.10	R1070	A91070
21	SFA-5.10	R1080A	A91080
21	SFA-5.10	R1100	A91100
21	SFA-5.10	R1188	A91188
21	SFA-5.10	R1200	A91200
21	SFA-5.10	R1450	A91450
21	SFA-5.10	R3103	A93103
22	SFA-5.10	ER5087	A95087
22	SFA-5.10	ER5183	A95183
22	SFA-5.10	ER5183A	A95183
22	SFA-5.10	ER5187	A95187
22	SFA-5.10	ER5249	A95249
22	SFA-5.10	ER5356	A95356
22	SFA-5.10	ER5356A	A95356
22	SFA-5.10	ER5554	A95554
22	SFA-5.10	ER5556	A95556
22	SFA-5.10	ER5556A	A95556
22	SFA-5.10	ER5556B	A95556
22	SFA-5.10	ER5556C	A95556
22	SFA-5.10	ER5654	A95654
22	SFA-5.10	ER5654A	A95654
22	SFA-5.10	ER5754	A95754
22	SFA-5.10	R5087	A95087
22	SFA-5.10	R5183	A95183
22	SFA-5.10	R5183A	A95183
22	SFA-5.10	R5187	A95187
22	SFA-5.10	R5249	A95249
22	SFA-5.10	R5356	A95356
22	SFA-5.10	R5356A	A95356
22	SFA-5.10	R5554	A95554
22	SFA-5.10	R5556	A95556
22	SFA-5.10	R5556A	A95556
22	SFA-5.10	R5556B	A95556
22	SFA-5.10	R5556C	A95556
22	SFA-5.10	R5654	A95654
22	SFA-5.10	R5654A	A95654
22	SFA-5.10	R5754	A95754

Table QW-432
F-Numbers
Grouping of Electrodes and Welding Rods for Qualification (Cont'd)

F-No.	ASME Specification	AWS Classification	UNS No.
Aluminum and Aluminum Alloys (Cont'd)			
23	SFA-5.3	E4043	A94043
23	SFA-5.10	ER4010	A94010
23	SFA-5.10	ER4018	A94018
23	SFA-5.10	ER4043	A94043
23	SFA-5.10	ER4043A	A94043
23	SFA-5.10	ER4046	A94046
23	SFA-5.10	ER4047	A94047
23	SFA-5.10	ER4047A	A94047
23	SFA-5.10	ER4643	A94643
23	SFA-5.10	ER4943	A94943
23	SFA-5.10	R4010	A94010
23	SFA-5.10	R4011	A94011
23	SFA-5.10	R4018	A94018
23	SFA-5.10	R-A356.0	A13560
23	SFA-5.10	R357.0	A03570
23	SFA-5.10	R-A357.0	A13570
23	SFA-5.10	R4043	A94043
23	SFA-5.10	R4043A	A94043
23	SFA-5.10	R4046	A94046
23	SFA-5.10	R4047A	A94047
23	SFA-5.10	R4047	A94047
23	SFA-5.10	R4643	A94643
23	SFA-5.10	R4943	A94943
25	SFA-5.10	ER2319	A92319
25	SFA-5.10	R2319	A92319
25	SFA-5.10	R206.0	A02060
26	SFA-5.10	ER4009	A94009
26	SFA-5.10	ER4145	A94145
26	SFA-5.10	R4009	A94009
26	SFA-5.10	R4145	A94145
26	SFA-5.10	R-C355.0	A33550
Copper and Copper Alloys			
31	SFA-5.6	ECu	W60189
31	SFA-5.7	ERCu	C18980
32	SFA-5.6	ECuSi	W60656
32	SFA-5.7	ERCuSi-A	C65600
33	SFA-5.6	ECuSn-A	W60518
33	SFA-5.6	ECuSn-C	W60521
33	SFA-5.7	ERCuSn-A	C51800
33	SFA-5.7	ERCuSn-C	C52100
34	SFA-5.6	ECuNi	W60715
34	SFA-5.7	ERCuNi	C71580
34	SFA-5.30	IN67	C71581
35	SFA-5.8	RBCuZn-A	C47000
35	SFA-5.8	RBCuZn-B	C68000
35	SFA-5.8	RBCuZn-C	C68100
35	SFA-5.8	RBCuZn-D	C77300
36	SFA-5.6	ECuAl-A2	W60614
36	SFA-5.6	ECuAl-B	W60619
36	SFA-5.7	ERCuAl-A1	C61000

Table QW-432
F-Numbers
Grouping of Electrodes and Welding Rods for Qualification (Cont'd)

F-No.	ASME Specification	AWS Classification	UNS No.
Copper and Copper Alloys (Cont'd)			
36	SFA-5.7	ERCuAl-A2	C61800
36	SFA-5.7	ERCuAl-A3	C62400
37	SFA-5.6	ECuMnNiAl	C60633
37	SFA-5.6	ECuNiAl	C60632
37	SFA-5.7	ERCuMnNiAl	C63380
37	SFA-5.7	ERCuNiAl	C63280
Nickel and Nickel Alloys			
41	SFA-5.11	ENi-1	W82141
41	SFA-5.14	ERNi-1	N02061
41	SFA-5.30	IN61	N02061
42	SFA-5.11	ENiCu-7	W84190
42	SFA-5.14	ERNiCu-7	N04060
42	SFA-5.14	ERNiCu-8	N05504
42	SFA-5.30	IN60	N04060
43	SFA-5.11	ENiCr-4	W86172
43	SFA-5.11	ENiCrCoMo-1	W86117
43	SFA-5.11	ENiCrFe-1	W86132
43	SFA-5.11	ENiCrFe-2	W86133
43	SFA-5.11	ENiCrFe-3	W86182
43	SFA-5.11	ENiCrFe-4	W86134
43	SFA-5.11	ENiCrFe-7	W86152
43	SFA-5.11	ENiCrFe-9	W86094
43	SFA-5.11	ENiCrFe-10	W86095
43	SFA-5.11	ENiCrFe-12	W86025
43	SFA-5.11	ENiCrFe-15	W86056
43	SFA-5.11	ENiCrMo-2	W86002
43	SFA-5.11	ENiCrMo-3	W86112
43	SFA-5.11	ENiCrMo-4	W80276
43	SFA-5.11	ENiCrMo-5	W80002
43	SFA-5.11	ENiCrMo-6	W86620
43	SFA-5.11	ENiCrMo-7	W86455
43	SFA-5.11	ENiCrMo-10	W86022
43	SFA-5.11	ENiCrMo-12	W86032
43	SFA-5.11	ENiCrMo-13	W86059
43	SFA-5.11	ENiCrMo-14	W86026
43	SFA-5.11	ENiCrMo-17	W86200
43	SFA-5.11	ENiCrMo-18	W86650
43	SFA-5.11	ENiCrMo-19	W86058
43	SFA-5.11	ENiCrWMo-1	W86231
43	SFA-5.11	ENiMoCr-1	N10362
43	SFA-5.14	ERNiCr-3	N06082
43	SFA-5.14	ERNiCr-4	N06072
43	SFA-5.14	ERNiCr-6	N06076
43	SFA-5.14	ERNiCr-7	N06073
43	SFA-5.14	ERNiCrCo-1	N07740
43	SFA-5.14	ERNiCrCoMo-1	N06617
43	SFA-5.14	ERNiCrCoMo-2	N07208
43	SFA-5.14	ERNiCrFe-5	N06062
43	SFA-5.14	ERNiCrFe-6	N07092
43	SFA-5.14	ERNiCrFe-7	N06052

Table QW-432
F-Numbers
Grouping of Electrodes and Welding Rods for Qualification (Cont'd)

F-No.	ASME Specification	AWS Classification	UNS No.
Nickel and Nickel Alloys (Cont'd)			
43	SFA-5.14	ERNiCrFe-7A	N06054
43	SFA-5.14	ERNiCrFe-8	N07069
43	SFA-5.14	ERNiCrFe-11	N06601
43	SFA-5.14	ERNiCrFe-12	N06025
43	SFA-5.14	ERNiCrFe-13	N06055
43	SFA-5.14	ERNiCrFe-14	N06043
43	SFA-5.14	ERNiCrFe-15	N06056
43	SFA-5.14	ERNiCrFeAl-1	N06693
43	SFA-5.14	ERNiCrMo-2	N06002
43	SFA-5.14	ERNiCrMo-3	N06625
43	SFA-5.14	ERNiCrMo-4	N10276
43	SFA-5.14	ERNiCrMo-7	N06455
43	SFA-5.14	ERNiCrMo-10	N06022
43	SFA-5.14	ERNiCrMo-13	N06059
43	SFA-5.14	ERNiCrMo-14	N06686
43	SFA-5.14	ERNiCrMo-16	N06057
43	SFA-5.14	ERNiCrMo-17	N06200
43	SFA-5.14	ERNiCrMo-18	N06650
43	SFA-5.14	ERNiCrMo-19	N06058
43	SFA-5.14	ERNiCrMo-20	N06660
43	SFA-5.14	ERNiCrMo-21	N06205
43	SFA-5.14	ERNiCrMo-22	N06035
43	SFA-5.14	ERNiCrWMo-1	N06231
43	SFA-5.14	ERNiCrMoWNb-1	N06680
43	SFA-5.30	IN52	N06052
43	SFA-5.30	IN62	N06062
43	SFA-5.30	IN6A	N07092
43	SFA-5.30	IN82	N06082
43	SFA-5.34	All classifications	...
44	SFA-5.11	ENiMo-1	W80001
44	SFA-5.11	ENiMo-3	W80004
44	SFA-5.11	ENiMo-7	W80665
44	SFA-5.11	ENiMo-8	W80008
44	SFA-5.11	ENiMo-9	W80009
44	SFA-5.11	ENiMo-10	W80675
44	SFA-5.11	ENiMo-11	W80629
44	SFA-5.14	ERNiMo-1	N10001
44	SFA-5.14	ERNiMo-2	N10003
44	SFA-5.14	ERNiMo-3	N10004
44	SFA-5.14	ERNiMo-7	N10665
44	SFA-5.14	ERNiMo-8	N10008
44	SFA-5.14	ERNiMo-9	N10009
44	SFA-5.14	ERNiMo-10	N10675
44	SFA-5.14	ERNiMo-11	N10629
44	SFA-5.14	ERNiMo-12	N10242
44	SFA-5.14	ERNiMoCr-1	N10362
45	SFA-5.11	ENiCrMo-1	W86007
45	SFA-5.11	ENiCrMo-9	W86985
45	SFA-5.11	ENiCrMo-11	W86030
45	SFA-5.14	ENiCrMo-1	N06007
45	SFA-5.14	ENiCrMo-8	N06975

Table QW-432
F-Numbers
Grouping of Electrodes and Welding Rods for Qualification (Cont'd)

F-No.	ASME Specification	AWS Classification	UNS No.
Nickel and Nickel Alloys (Cont'd)			
45	SFA-5.14	ERNiCrMo-9	N06985
45	SFA-5.14	ERNiCrMo-11	N06030
45	SFA-5.14	ERNiFeCr-1	N08065
45	SFA-5.14	ERNiFeCr-3	N09946
46	SFA-5.11	ENiCrFeSi-1	W86045
46	SFA-5.14	ERNiCrFeSi-1	N06045
46	SFA-5.14	ERNiCoCrSi-1	N12160
Titanium and Titanium Alloys			
51	SFA-5.16	ERTi-1	R50100
51	SFA-5.16	ERTi-11	R52251
51	SFA-5.16	ERTi-13	R53423
51	SFA-5.16	ERTi-17	R52253
51	SFA-5.16	ERTi-27	R52255
51	SFA-5.16	ERTi-2	R50120
51	SFA-5.16	ERTi-7	R52401
51	SFA-5.16	ERTi-14	R53424
51	SFA-5.16	ERTi-16	R52403
51	SFA-5.16	ERTi-26	R52405
51	SFA-5.16	ERTi-30	R53531
51	SFA-5.16	ERTi-33	R53443
51	SFA-5.16	ERTi-3	R50125
51	SFA-5.16	ERTi-15A	R53416
51	SFA-5.16	ERTi-31	R53533
51	SFA-5.16	ERTi-34	R53444
52	SFA-5.16	ERTi-4	R50130
53	SFA-5.16	ERTi-9	R56320
53	SFA-5.16	ERTi-9ELI	R56321
53	SFA-5.16	ERTi-18	R56326
53	SFA-5.16	ERTi-28	R56324
54	SFA-5.16	ERTi-12	R53400
55	SFA-5.16	ERTi-5	R56400
55	SFA-5.16	ERTi-23	R56408
55	SFA-5.16	ERTi-29	R56414
55	SFA-5.16	ERTi-24	R56415
55	SFA-5.16	ERTi-25	R56413
55	SFA-5.16	ERTi-38	R54251
56	SFA-5.16	ERTi-32	R55112
Zirconium and Zirconium Alloys			
61	SFA-5.24	ERZr2	R60702
61	SFA-5.24	ERZr3	R60704
61	SFA-5.24	ERZr4	R60705
Hard-Facing Weld Metal Overlay			
71	SFA-5.13	ECoCr-A	W73006
71	SFA-5.13	ECoCr-B	W73012
71	SFA-5.13	ECoCr-C	W73001
71	SFA-5.13	ECoCr-E	W73021
71	SFA-5.13	ECuAl-A2	W60617
71	SFA-5.13	ECuAl-B	W60619

Table QW-432
F-Numbers
Grouping of Electrodes and Welding Rods for Qualification (Cont'd)

F-No.	ASME Specification	AWS Classification	UNS No.
Hard-Facing Weld Metal Overlay (Cont'd)			
71	SFA-5.13	ECuAl-C	W60625
71	SFA-5.13	ECuAl-D	W61625
71	SFA-5.13	ECuAl-E	W62625
71	SFA-5.13	ECuMnNiAl	W60633
71	SFA-5.13	ECuNi	W60715
71	SFA-5.13	ECuNiAl	W60632
71	SFA-5.13	ECuSi	W60656
71	SFA-5.13	ECuSn-A	W60518
71	SFA-5.13	ECuSn-C	W60521
71	SFA-5.13	EFe1	W74001
71	SFA-5.13	EFe2	W74002
71	SFA-5.13	EFe3	W74003
71	SFA-5.13	EFe4	W74004
71	SFA-5.13	EFe5	W75110
71	SFA-5.13	EFe6	W77510
71	SFA-5.13	EFe7	W77610
71	SFA-5.13	EFeCr-A1A	W74011
71	SFA-5.13	EFeCr-A2	W74012
71	SFA-5.13	EFeCr-A3	W74013
71	SFA-5.13	EFeCr-A4	W74014
71	SFA-5.13	EFeCr-A5	W74015
71	SFA-5.13	EFeCr-A6	W74016
71	SFA-5.13	EFeCr-A7	W74017
71	SFA-5.13	EFeCr-A8	W74018
71	SFA-5.13	EFeCr-E1	W74211
71	SFA-5.13	EFeCr-E2	W74212
71	SFA-5.13	EFeCr-E3	W74213
71	SFA-5.13	EFeCr-E4	W74214
71	SFA-5.13	EFeMn-A	W79110
71	SFA-5.13	EFeMn-B	W79310
71	SFA-5.13	EFeMn-C	W79210
71	SFA-5.13	EFeMn-D	W79410
71	SFA-5.13	EFeMn-E	W79510
71	SFA-5.13	EFeMn-F	W79610
71	SFA-5.13	EFeMnCr	W79710
71	SFA-5.13	ENiCr-C	W89606
71	SFA-5.13	ENiCrFeCo	W83002
71	SFA-5.13	ENiCrMo-5A	W80002
71	SFA-5.13	EWCX-12/30	...
71	SFA-5.13	EWCX-20/30	...
71	SFA-5.13	EWCX-30/40	...
71	SFA-5.13	EWCX-40	...
71	SFA-5.13	EWCX-40/120	...
72	SFA-5.21	ERCCoCr-A	W73036
72	SFA-5.21	ERCCoCr-B	W73042
72	SFA-5.21	ERCCoCr-C	W73031
72	SFA-5.21	ERCCoCr-E	W73041
72	SFA-5.21	ERCCoCr-G	W73032
72	SFA-5.21	ERCCuAl-A2	W60618
72	SFA-5.21	ERCCuAl-A3	W60624

Table QW-432
F-Numbers
Grouping of Electrodes and Welding Rods for Qualification (Cont'd)

F-No.	ASME Specification	AWS Classification	UNS No.
Hard-Facing Weld Metal Overlay (Cont'd)			
72	SFA-5.21	ERCCuAl-C	W60626
72	SFA-5.21	ERCCuAl-D	W61626
72	SFA-5.21	ERCCuAl-E	W62626
72	SFA-5.21	ERCCuSi-A	W60657
72	SFA-5.21	ERCCuSn-A	W60518
72	SFA-5.21	ERCCuSn-D	W60524
72	SFA-5.21	ERCFe-1	W74030
72	SFA-5.21	ERCFe-1A	W74031
72	SFA-5.21	ERCFe-2	W74032
72	SFA-5.21	ERCFe-3	W74033
72	SFA-5.21	ERCFe-5	W74035
72	SFA-5.21	ERCFe-6	W77530
72	SFA-5.21	ERCFe-8	W77538
72	SFA-5.21	ERCFeCr-A	W74531
72	SFA-5.21	ERCFeCr-A1A	W74530
72	SFA-5.21	ERCFeCr-A3A	W74533
72	SFA-5.21	ERCFeCr-A4	W74534
72	SFA-5.21	ERCFeCr-A5	W74535
72	SFA-5.21	ERCFeCr-A9	W74539
72	SFA-5.21	ERCFeCr-A10	W74540
72	SFA-5.21	ERCFeMn-C	W79230
72	SFA-5.21	ERCFeMn-F	W79630
72	SFA-5.21	ERCFeMn-G	W79231
72	SFA-5.21	ERCFeMn-H	W79232
72	SFA-5.21	ERCFeMnCr	W79730
72	SFA-5.21	ERCNiCr-A	W89634
72	SFA-5.21	ERCNiCr-B	W89635
72	SFA-5.21	ERCNiCr-C	W89636
72	SFA-5.21	ERCNiCrFeCo	W83032
72	SFA-5.21	ERCNiCrMo-5A	W80036
72	SFA-5.21	ERCoCr-A	R30006
72	SFA-5.21	ERCoCr-B	R30012
72	SFA-5.21	ERCoCr-C	R30001
72	SFA-5.21	ERCoCr-E	R30021
72	SFA-5.21	ERCoCr-F	R30002
72	SFA-5.21	ERCoCr-G	R30014
72	SFA-5.21	ERCuAl-A2	C61800
72	SFA-5.21	ERCuAl-A3	C62400
72	SFA-5.21	ERCuAl-C	C62580
72	SFA-5.21	ERCuAl-D	C62581
72	SFA-5.21	ERCuAl-E	C62582
72	SFA-5.21	ERCuSi-A	C65600
72	SFA-5.21	ERCuSn-A	C51800
72	SFA-5.21	ERCuSn-D	C52400
72	SFA-5.21	ERFe-1	T74000
72	SFA-5.21	ERFe-1A	T74001
72	SFA-5.21	ERFe-2	T74002
72	SFA-5.21	ERFe-3	T74003
72	SFA-5.21	ERFe-5	T74005
72	SFA-5.21	ERFe-6	T74006

Table QW-432
F-Numbers
Grouping of Electrodes and Welding Rods for Qualification (Cont'd)

F-No.	ASME Specification	AWS Classification	UNS No.
Hard-Facing Weld Metal Overlay (Cont'd)			
72	SFA-5.21	ERFe-8	T74008
72	SFA-5.21	ERFeCr-A	...
72	SFA-5.21	ERFeCr-A1A	...
72	SFA-5.21	ERFeCr-A3A	...
72	SFA-5.21	ERFeCr-A4	...
72	SFA-5.21	ERFeCr-A5	...
72	SFA-5.21	ERFeCr-A9	...
72	SFA-5.21	ERFeCr-A10	...
72	SFA-5.21	ERFeMn-C	...
72	SFA-5.21	ERFeMn-F	...
72	SFA-5.21	ERFeMn-G	...
72	SFA-5.21	ERFeMn-H	...
72	SFA-5.21	ERFeMnCr	...
72	SFA-5.21	ERNiCr-A	N99644
72	SFA-5.21	ERNiCr-B	N99645
72	SFA-5.21	ERNiCr-C	N99646
72	SFA-5.21	ERNiCr-D	N99647
72	SFA-5.21	ERNiCr-E	N99648
72	SFA-5.21	ERNiCrFeCo	F46100
72	SFA-5.21	ERNiCrMo-5A	N10006
72	SFA-5.21	ERWCX-20/30	...
72	SFA-5.21	ERWCX-30/40	...
72	SFA-5.21	ERWCX-40	...
72	SFA-5.21	ERWCX-40/120	...
72	SFA-5.21	RWCX-20/30	...
72	SFA-5.21	RWCX-30/40	...
72	SFA-5.21	RWCX-40	...
72	SFA-5.21	RWCX-40/120	...

QW-433 ALTERNATE F-NUMBERS FOR WELDER PERFORMANCE QUALIFICATION

The following tables identify the filler metal or electrode that the welder used during qualification testing as "Qualified With," and the electrodes or filler metals that the welder is qualified to use in production welding as "Qualified For." See [Table QW-432](#) for the F-Number assignments.

Qualified With →	F-No. 1 With Backing	F-No. 1 Without Backing	F-No. 2 With Backing	F-No. 2 Without Backing	F-No. 3 With Backing	F-No. 3 Without Backing	F-No. 4 With Backing	F-No. 4 Without Backing	F-No. 5 With Backing	F-No. 5 Without Backing
Qualified For ↓										
F-No. 1 With Backing	X	X	X	X	X	X	X	X	X	X
F-No. 1 Without Backing		X								
F-No. 2 With Backing			X	X	X	X	X	X		
F-No. 2 Without Backing				X						
F-No. 3 With Backing					X	X	X	X		
F-No. 3 Without Backing						X				
F-No. 4 With Backing							X	X		
F-No. 4 Without Backing								X		
F-No. 5 With Backing									X	X
F-No. 5 Without Backing										X
Qualified With					Qualified For					
Any F-No. 6					All F-No. 6 [Note (1)]					
Any F-No. 21 through F-No. 26					All F-No. 21 through F-No. 26					
Any F-No. 31, F-No. 32, F-No. 33, F-No. 35, F-No. 36, or F-No. 37					Only the same F-Number as was used during the qualification test					
F-No. 34 or any F-No. 41 through F-No. 46					F-No. 34 and all F-No. 41 through F-No. 46					
Any F-No. 51 through F-No. 55					All F-No. 51 through F-No. 55					
Any F-No. 61					All F-No. 61					
Any F-No. 71 through F-No. 72					Only the same F-Number as was used during the qualification test					
NOTE:										
(1) Deposited weld metal made using a bare rod not covered by an SFA Specification but which conforms to an analysis listed in Table QW-442 shall be considered to be classified as F-No. 6.										

QW-440 WELD METAL CHEMICAL COMPOSITION**QW-441 GENERAL**

Identification of weld metal chemical composition designated on the PQR and WPS shall be as given in [QW-404.5](#).

A-No.	Types of Weld Deposit	Analysis, % [Note (1)] and [Note (2)]					
		C	Cr	Mo	Ni	Mn	Si
1	Mild Steel	0.20	0.20	0.30	0.50	1.60	1.0
2	Carbon-Molybdenum	0.15	0.50	0.40–0.65	0.50	1.60	1.0
3	Chrome (0.4% to 2%)-Molybdenum	0.15	0.40–2.00	0.40–0.65	0.50	1.60	1.0
4	Chrome (2% to 4%)-Molybdenum	0.15	2.00–4.00	0.40–1.50	0.50	1.60	2.0
5	Chrome (4% to 10.5%)-Molybdenum	0.15	4.00–10.5	0.40–1.50	0.80	1.20	2.0
6	Chrome-Martensitic	0.15	11.0–15.0	0.70	0.80	2.00	1.0
7	Chrome-Ferritic	0.15	11.0–30.0	1.00	0.80	1.00	3.0
8	Chromium-Nickel	0.15	14.5–30.0	4.00	7.50–15.0	2.50	1.0
9	Chromium-Nickel	0.30	19.0–30.0	6.00	15.0–37.0	2.50	1.0
10	Nickel to 4%	0.15	0.50	0.55	0.80–4.00	1.70	1.0
11	Manganese-Molybdenum	0.17	0.50	0.25–0.75	0.85	1.25–2.25	1.0
12	Nickel-Chrome—Molybdenum	0.15	1.50	0.25–0.80	1.25–2.80	0.75–2.25	1.0

NOTES:

- (1) Single values shown above are maximum.
- (2) Only listed elements are used to determine A-numbers.

QW-450 SPECIMENS**QW-451 PROCEDURE QUALIFICATION THICKNESS LIMITS AND TEST SPECIMENS**

(21)

Table QW-451.1
Groove-Weld Tension Tests and Transverse-Bend Tests

Thickness T of Test Coupon, Welded, in. (mm)	Range of Thickness T of Base Metal, Qualified, in. (mm) [Note (1)] and [Note (2)]		Maximum Thickness t of Deposited Weld Metal, Qualified, in. (mm) [Note (1)] and [Note (2)]	Type and Number of Tests Required (Tension and Guided-Bend Tests) [Note (2)]			
	Min.	Max.		Tension, QW-150	Side Bend, QW-160	Face Bend, QW-160	Root Bend, QW-160
Less than $\frac{1}{16}$ (1.5)	T	$2T$	$2t$	2	...	2	2
$\frac{1}{16}$ to $\frac{3}{8}$ (1.5 to 10), incl.	$\frac{1}{16}$ (1.5)	$2T$	$2t$	2	[Note (5)]	2	2
Over $\frac{3}{8}$ (10), but less than $\frac{3}{4}$ (19)	$\frac{3}{16}$ (5)	$2T$	$2t$	2	[Note (5)]	2	2
$\frac{3}{4}$ (19) to less than $1\frac{1}{2}$ (38)	$\frac{3}{16}$ (5)	$2T$	$2t$ when $t < \frac{3}{4}$ (19)	2 [Note (4)]	4
$\frac{3}{4}$ (19) to less than $1\frac{1}{2}$ (38)	$\frac{3}{16}$ (5)	$2T$	$2T$ when $t \geq \frac{3}{4}$ (19)	2 [Note (4)]	4
$1\frac{1}{2}$ (38) to 6 (150), incl.	$\frac{3}{16}$ (5)	8 (200) [Note (3)]	$2t$ when $t < \frac{3}{4}$ (19)	2 [Note (4)]	4
$1\frac{1}{2}$ (38) to 6 (150), incl.	$\frac{3}{16}$ (5)	8 (200) [Note (3)]	8 (200) [Note (3)] when $t \geq \frac{3}{4}$ (19)	2 [Note (4)]	4
Over 6 (150) [Note (6)]	$\frac{3}{16}$ (5)	$1.33T$	$2t$ when $t < \frac{3}{4}$ (19)	2 [Note (4)]	4
Over 6 (150) [Note (6)]	$\frac{3}{16}$ (5)	$1.33T$	$1.33T$ when $t \geq \frac{3}{4}$ (19)	2 [Note (4)]	4

NOTES:

- (1) The following variable further restricts the limits shown in this table when they are referenced in QW-250 for the process under consideration: QW-403.9. Also, QW-202.2, QW-202.3, and QW-202.4 provide exemptions that supersede the limits of this table. Supplementary essential variable requirements may also further limit thickness ranges in this table.
- (2) For combination of welding procedures, see QW-200.4.
- (3) For the SMAW, SAW, GMAW, PAW, LLBW, and GTAW welding processes only; otherwise per Note (1) or $2T$, or $2t$, whichever is applicable.
- (4) see QW-151.1, QW-151.2, and QW-151.3 for details on multiple specimens when coupon thicknesses are over 1 in. (25 mm).
- (5) Four side-bend tests may be substituted for the required face- and root-bend tests, when thickness T is $\frac{3}{8}$ in. (10 mm) and over.
- (6) For test coupons over 6 in. (150 mm) thick, the full thickness of the test coupon shall be welded.

(21)

Table QW-451.2
Groove-Weld Tension Tests and Longitudinal-Bend Tests

Thickness T of Test Coupon Welded, in. (mm)	Thickness t of Deposited Weld Metal		Type and Number of Tests Required (Tension and Guided-Bend Tests) [Note (2)]
	Range of Thickness T of Base Metal Qualified, in. (mm) [Note (1)] and [Note (2)]	Qualified, in. (mm) [Note (1)] and [Note (2)]	
Less than $\frac{1}{16}$ (1.5)	T	$2T$	Tension, QW-150 Face Bend, QW-160 Root Bend, QW-160 2
$\frac{1}{16}$ to $\frac{3}{8}$ (1.5 to 10), incl.	$\frac{1}{16}$ (1.5)	$2T$	2
Over $\frac{3}{8}$ (10)	$\frac{3}{16}$ (5)	$2T$	2

NOTES:

- (1) The following variable further restricts the limits shown in this table when they are referenced in [QW-250](#) for the process under consideration: [QW-403.9](#). Also, [QW-202.2](#), [QW-202.3](#), and [QW-202.4](#) provide exemptions that supersede the limits of this table. Supplementary essential variable requirements may also further limit thickness ranges in this table.
- (2) For combination of welding procedures, see [QW-200.4](#).

Table QW-451.3
Fillet-Weld Tests

Type of Joint	Thickness of Test Coupons as Welded, in.	Range Qualified	Type and Number of Tests Required [Figure QW-462.4(a) or Figure QW-462.4(d)] Macro
Fillet	Per Figure QW-462.4(a)	All fillet sizes on all base metal thicknesses and all diameters	5
Fillet	Per Figure QW-462.4(d)		4

GENERAL NOTE: A production assembly mockup may be substituted in accordance with [QW-181.1.1](#).

Table QW-451.4
Fillet Welds Qualified by Groove-Weld Tests

Thickness T of Test Coupon (Plate or Pipe) as Welded	Range Qualified	Type and Number of Tests Required
All groove tests	All fillet sizes on all base metal thicknesses and all diameters	Fillet welds are qualified when the groove weld is qualified in accordance with either Table QW-451.1 or Table QW-451.2 (see QW-202.2)

QW-452 PERFORMANCE QUALIFICATION THICKNESS LIMITS AND TEST SPECIMENS

QW-452.1 Groove-Weld Test. The following tables identify the required type and number of tests and the thickness of weld metal qualified.

Table QW-452.1(a)
Test Specimens

Thickness of Weld Metal, in. (mm)	Type and Number of Examinations and Test Specimens Required			
	Visual Examination per QW-302.4	Side Bend Figure QW-462.2 [Note (1)]	Face Bend Figure QW-462.3(a) or Figure QW-462.3(b) [Note (1)], [Note (2)]	Root Bend Figure QW-462.3(a) or Figure QW-462.3(b) [Note (1)], [Note (2)]
Less than $\frac{3}{8}$ (10)	X	...	1	1
$\frac{3}{8}$ (10) to less than $\frac{3}{4}$ (19)	X	2 [Note (3)]
$\frac{3}{4}$ (19) and over	X	2

GENERAL NOTE: The "Thickness of Weld Metal" is the total weld metal thickness deposited by all welders and all processes in the test coupon exclusive of the weld reinforcement.

NOTES:

- (1) To qualify using positions 5G or 6G, a total of four bend specimens are required. To qualify using a combination of 2G and 5G in a single test coupon, a total of six bend specimens are required. see [QW-302.3](#). The type of bend test shall be based on weld metal thickness.
- (2) Coupons tested by face and root bends shall be limited to weld deposit made by one welder with one or two processes or two welders with one process each. Weld deposit by each welder and each process shall be present on the convex surface of the appropriate bent specimen.
- (3) One face and root bend may be substituted for the two side bends. For a test coupon welded in the 5G or 6G position, two face and two root bends may be substituted for the four side bends in accordance with [Figure QW-463.2\(d\)](#). For a test coupon welded using a combination of 2G and 5G positions, three face and three root bends may be substituted for the six side bends in accordance with [Figure QW-463.2\(f\)](#) or [Figure QW-463.2\(g\)](#).

Table QW-452.1(b)
Thickness of Weld Metal Qualified

Thickness, t , of Weld Metal in the Coupon, in. (mm) [Note (1)] and [Note (2)]	Thickness of Weld Metal Qualified [Note (3)]
All	$2t$
$\frac{1}{2}$ (13) and over with a minimum of three layers	Maximum to be welded

NOTES:

- (1) When more than one welder, process, or set of essential variables is used during welding of a test coupon, the thickness, t , of the weld metal in the coupon deposited by each welder, for each process, and with each set of essential variables shall be determined and used individually in the "Thickness, t , of Weld Metal in the Coupon" column to determine the "Thickness of Weld Metal Qualified."
- (2) Two or more pipe test coupons with different weld metal thickness may be used to determine the weld metal thickness qualified and that thickness may be applied to production welds to the smallest diameter for which the welder is qualified in accordance with [Table QW-452.3](#).
- (3) Thickness of test coupon of $\frac{3}{4}$ in. (19 mm) or over shall be used for qualifying a combination of three or more welders each of whom may use the same or a different welding process.

Table QW-452.3
Groove-Weld Diameter Limits

Outside Diameter of Test Coupon, in. (mm)	Outside Diameter Qualified, in. (mm)	
	Min.	Max.
Less than 1 (25)	Size welded	Unlimited
1 (25) to $2\frac{7}{8}$ (73)	1 (25)	Unlimited
Over $2\frac{7}{8}$ (73)	$2\frac{7}{8}$ (73)	Unlimited

GENERAL NOTES:

- (a) Type and number of tests required shall be in accordance with [QW-452.1](#).
- (b) $2\frac{7}{8}$ in. (73 mm) O.D. is the equivalent of NPS $2\frac{1}{2}$ (DN 65).

Table QW-452.4
Small Diameter Fillet-Weld Test

Outside Diameter of Test Coupon, in. (mm)	Minimum Outside Diameter, Qualified, in. (mm)	Qualified Thickness
Less than 1 (25)	Size welded	All
1 (25) to $2\frac{7}{8}$ (73)	1 (25)	All
Over $2\frac{7}{8}$ (73)	$2\frac{7}{8}$ (73)	All

GENERAL NOTES:

- (a) Type and number of tests required shall be in accordance with [Table QW-452.5](#).
- (b) $2\frac{7}{8}$ in. (73 mm) O.D. is considered the equivalent of NPS $2\frac{1}{2}$ (DN 65).

Table QW-452.5
Fillet-Weld Test

Type of Joint	Thickness of Test Coupon as Welded, in. (mm)	Qualified Range	Type and Number of Tests Required [Figure QW-462.4(b) or Figure QW-462.4(c)]	
			Macro	Fracture
Tee fillet [Figure QW-462.4(b)]	$\frac{3}{16}$ (5) or greater	All base material thicknesses, fillet sizes, and diameters $2\frac{7}{8}$ (73) O.D. and over [Note (1)]	1	1
	Less than $\frac{3}{16}$ (5)	T to 2 T base material thickness, T maximum fillet size, and all diameters $2\frac{7}{8}$ (73) O.D. and over [Note (1)]	1	1

GENERAL NOTE: Production assembly mockups may be substituted in accordance with [QW-181.2.1](#).

NOTES:

- (1) Test coupon prepared as shown in [Figure QW-462.4\(b\)](#) for plate or [Figure QW-462.4\(c\)](#) for pipe.
- (2) $2\frac{7}{8}$ in. (73 mm) O.D. is considered the equivalent of NPS $2\frac{1}{2}$ (DN 65). For smaller diameter qualifications, refer to [Table QW-452.4](#) or [Table QW-452.6](#).

Table QW-452.6
Fillet Qualification by Groove-Weld Tests

Type of Joint	Thickness of Test Coupon as Welded, in. (mm)	Qualified Range	Type and Number of Tests Required
Any groove	All thicknesses	All base material thicknesses, fillet sizes, and diameters	Fillet welds are qualified when a welder or welding operator qualifies on a groove weld test

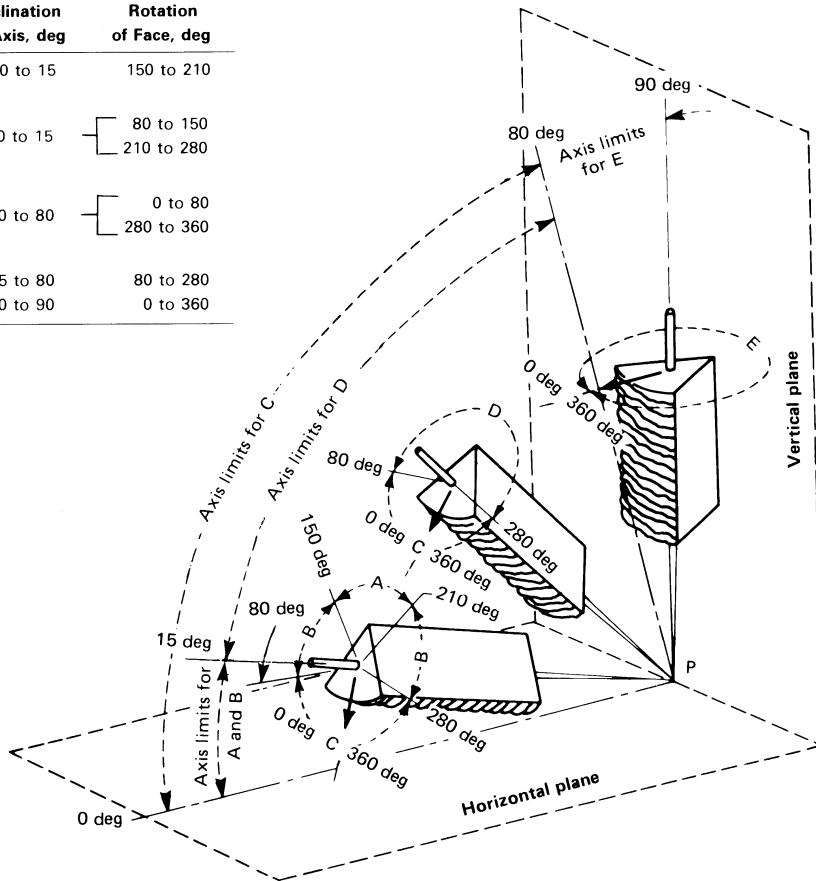
Table QW-453
Procedure and Performance Qualification Thickness Limits and Test Specimens for Hard-Facing (Wear-Resistant) and Corrosion-Resistant Overlays

Thickness of Test Coupon (T)	Corrosion-Resistant Overlay		Hard-facing Overlay (Wear-Resistant)	
	Nominal Base Metal Thickness Qualified (T)	Type and Number of Tests Required	Nominal Base Metal Thickness Qualified (T)	Type and Number of Tests Required
Procedure Qualification Testing				
Less than 1 in. (25 mm) T	T qualified to unlimited	Liquid penetrant	T qualified up to 1 in. (25 mm)	Liquid penetrant 3 hardness readings per specimen
1 in. (25 mm) and over T	1 in. (25 mm) to unlimited		2 transverse side bend and 2 longitudinal side bend, or 4 transverse side bend	1 in. (25 mm) to unlimited Macro test
Performance Qualification Testing				
Less than 1 in. (25 mm) T	T qualified to unlimited	2 transverse side bend per position	T qualified to unlimited	Liquid penetrant
1 in. (25 mm) and over T	1 in. (25 mm) to unlimited		1 in. (25 mm) to unlimited	Macro test

QW-460 GRAPHICS**QW-461 POSITIONS**

Figure QW-461.1
Positions of Welds — Groove Welds

Tabulation of Positions of Welds			
Position	Diagram Reference	Inclination of Axis, deg	Rotation of Face, deg
Flat	A	0 to 15	150 to 210
Horizontal	B	0 to 15	80 to 150 210 to 280
Overhead	C	0 to 80	0 to 80 280 to 360
Vertical	D	15 to 80	80 to 280
	E	80 to 90	0 to 360

**GENERAL NOTES:**

- (a) The horizontal reference plane is taken to lie always below the weld under consideration.
- (b) Inclination of axis is measured from the horizontal reference plane toward the vertical.
- (c) Angle of rotation of face is measured from a line perpendicular to the axis of the weld and lying in a vertical plane containing this axis. The reference position (0 deg) of rotation of the face invariably points in the direction opposite to that in which the axis angle increases. The angle of rotation of the face of weld is measured in a clockwise direction from this reference position (0 deg) when looking at point P.

Figure QW-461.2
Positions of Welds — Fillet Welds

Tabulation of Positions of Fillet Welds			
Position	Diagram Reference	Inclination of Axis, deg	Rotation of Face, deg
Flat	A	0 to 15	150 to 210
Horizontal	B	0 to 15	125 to 150 210 to 235
Overhead	C	0 to 80	0 to 125 235 to 360
Vertical	D	15 to 80	125 to 235
	E	80 to 90	0 to 360

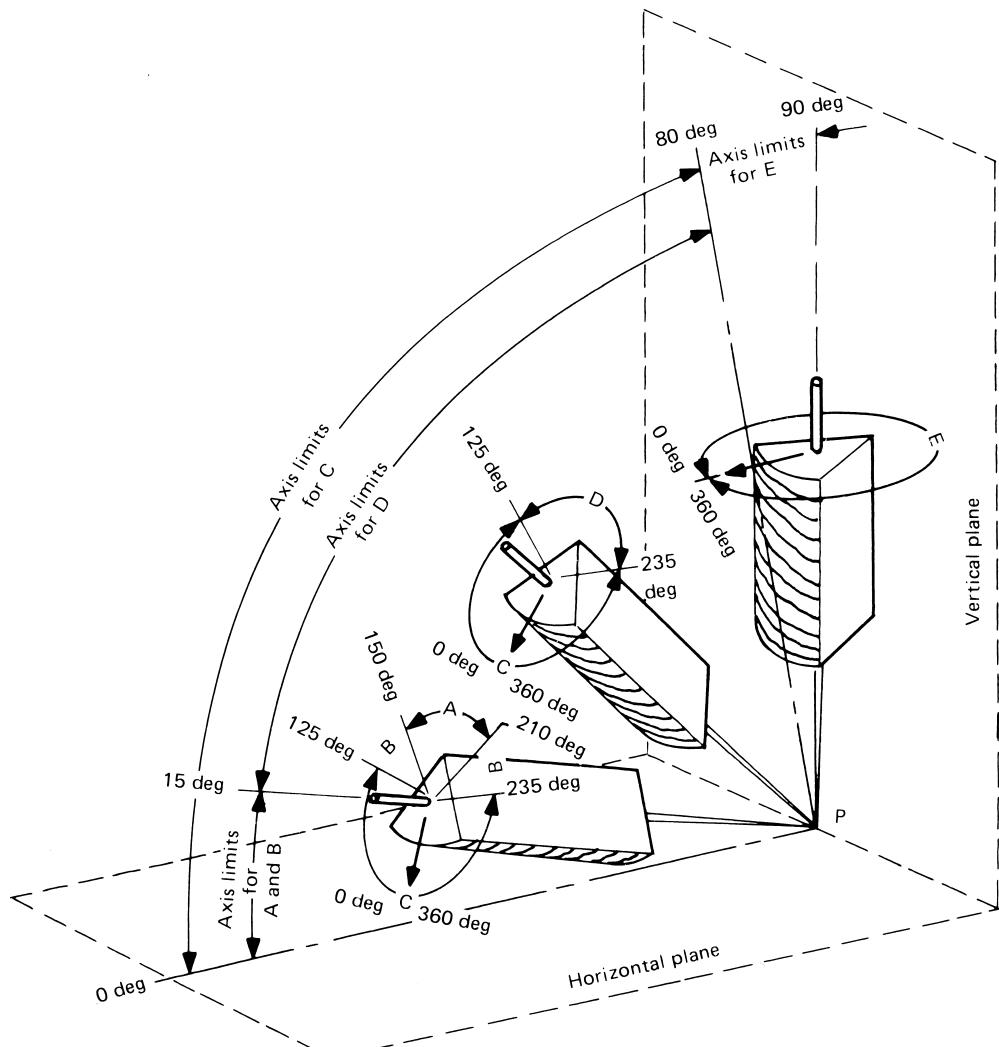


Figure QW-461.3

Groove Welds in Plate — Test Positions

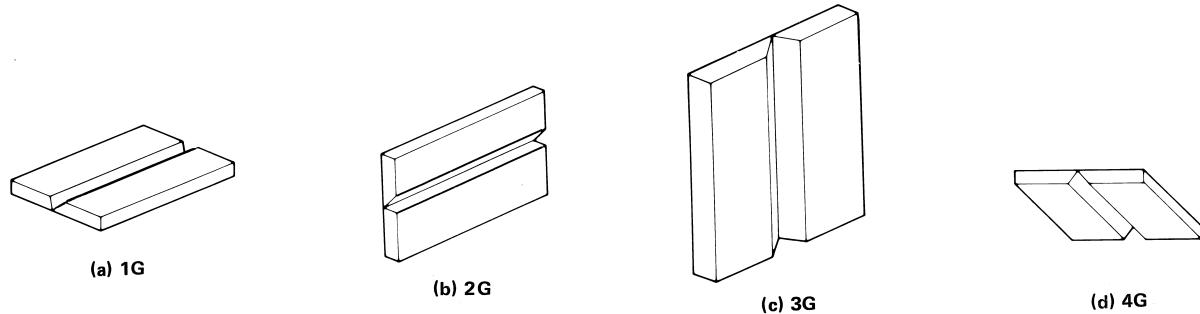


Figure QW-461.4
Groove Welds in Pipe — Test Positions

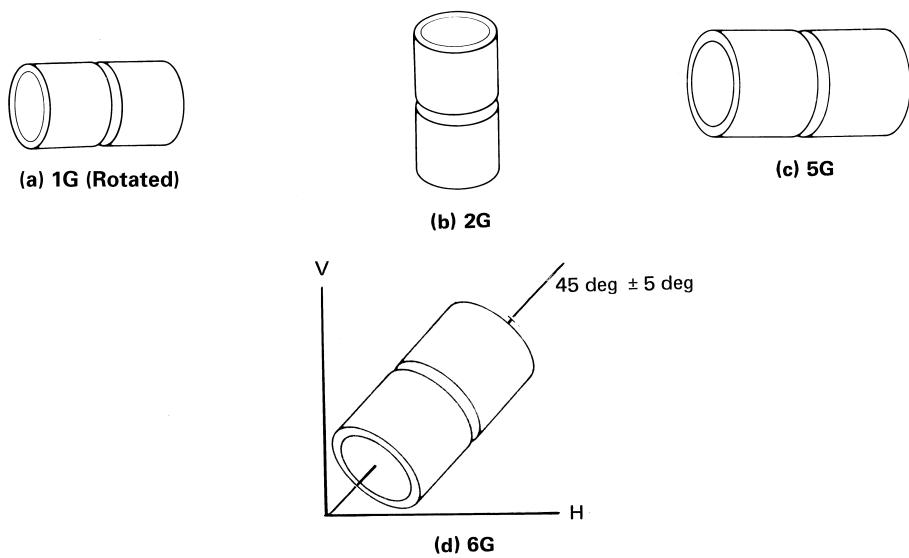


Figure QW-461.5
Fillet Welds in Plate — Test Positions

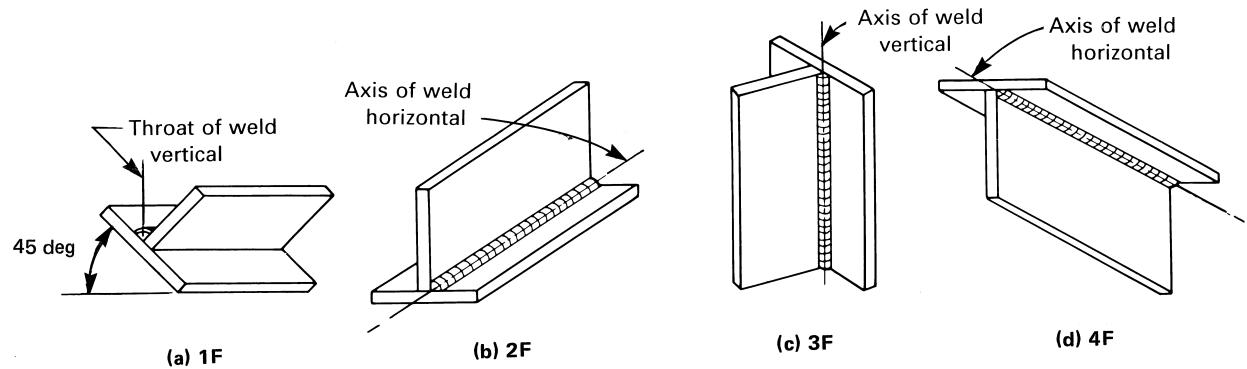


Figure QW-461.6
Fillet Welds in Pipe — Test Positions

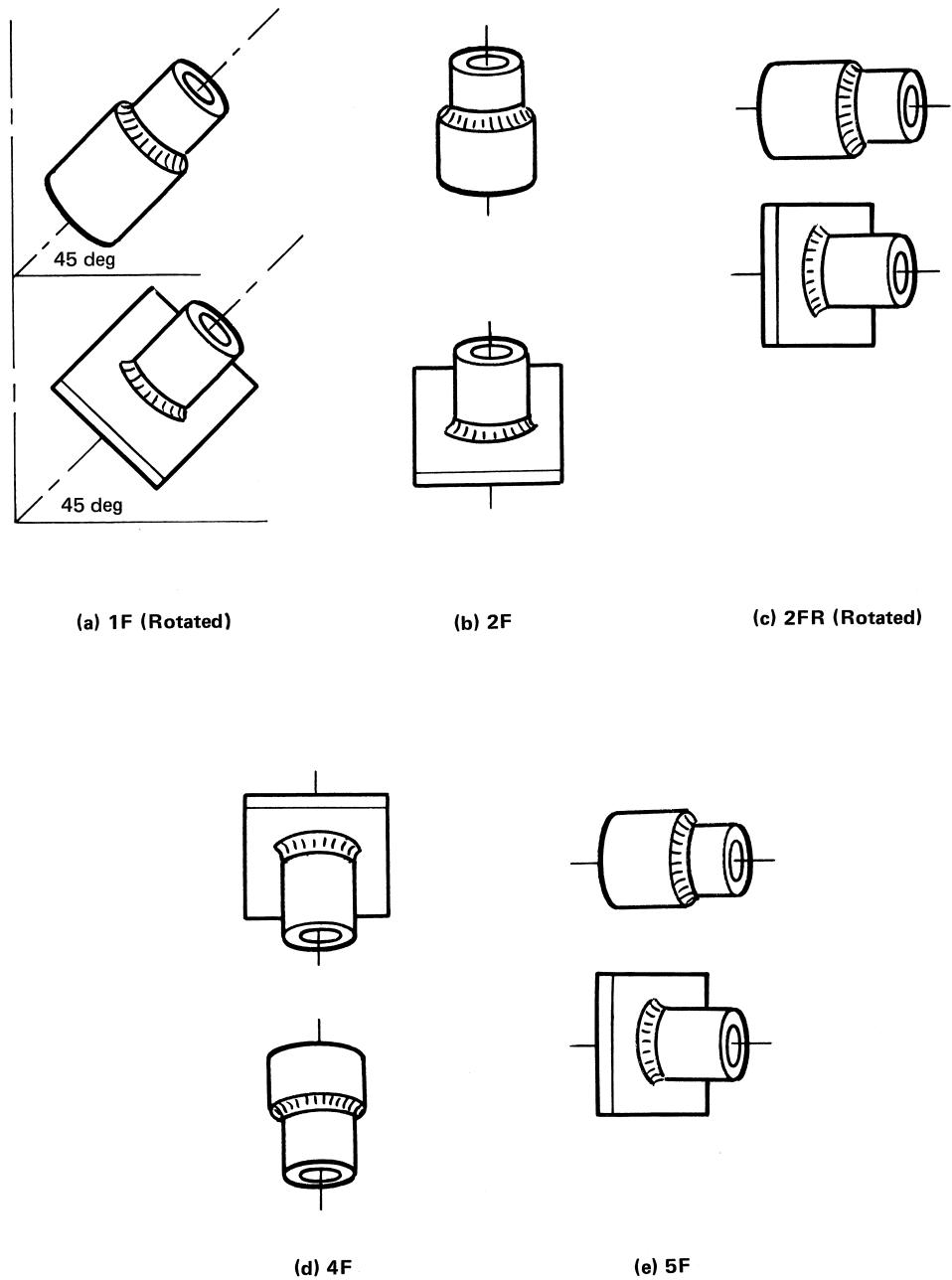


Figure QW-461.7
Stud Welds — Test Positions

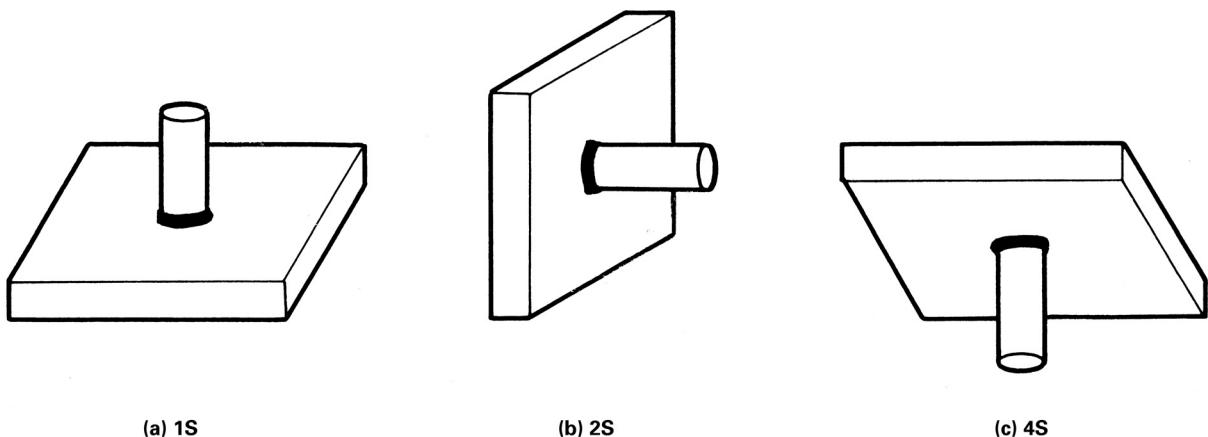


Figure QW-461.8
Stud Welds — Welding Positions

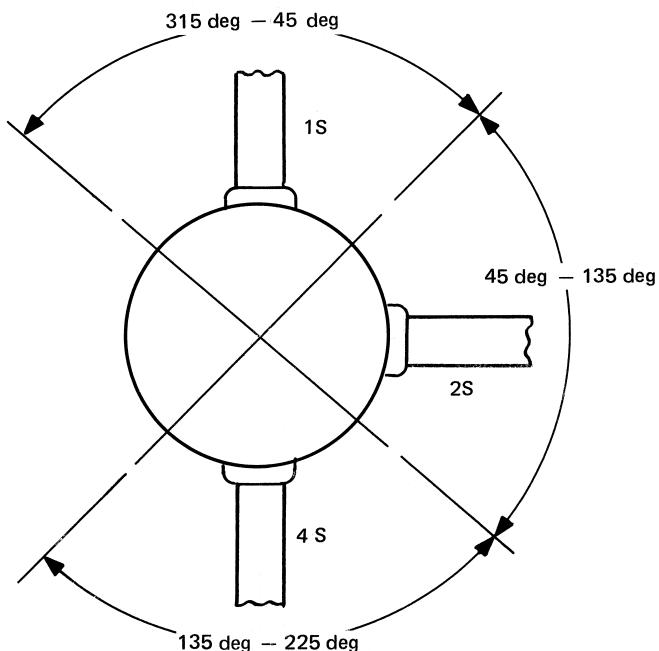


Table QW-461.9
Performance Qualification — Position and Diameter Limitations
(Within the Other Limitations of QW-303)

Qualification Test		Position and Type Weld Qualified [Note (1)]		
		Groove		Fillet or Tack [Note (2)]
Weld	Position	Plate and Pipe Over 24 in. (610 mm) O.D.	Pipe ≤ 24 in. (610 mm) O.D.	Plate and Pipe
Plate — Groove	1G	F	F [Note (3)]	F
	2G	F, H	F, H [Note (3)]	F, H
	3G	F, V	F [Note (3)]	F, H, V
	4G	F, O	F [Note (3)]	F, H, O
	3G and 4G	F, V, O	F [Note (3)]	All
	2G, 3G, and 4G	All	F, H [Note (3)]	All
	Special Positions (SP)	SP, F	SP, F	SP, F
Plate — Fillet	1F	F [Note (3)]
	2F	F, H [Note (3)]
	3F	F, H, V [Note (3)]
	4F	F, H, O [Note (3)]
	3F and 4F	All [Note (3)]
	Special Positions (SP)	SP, F [Note (3)]
Pipe — Groove [Note (4)]	1G	F	F	F
	2G	F, H	F, H	F, H
	5G	F, V, O	F, V, O	All
	6G	All	All	All
	2G and 5G	All	All	All
	Special Positions (SP)	SP, F	SP, F	SP, F
Pipe — Fillet [Note (4)]	1F	F
	2F	F, H
	2FR	F, H
	4F	F, H, O
	5F	All
	Special Positions (SP)	SP, F

NOTES:

(1) Positions of welding as shown in QW-461.1 and QW-461.2.

F = Flat

H = Horizontal

V = Vertical

O = Overhead

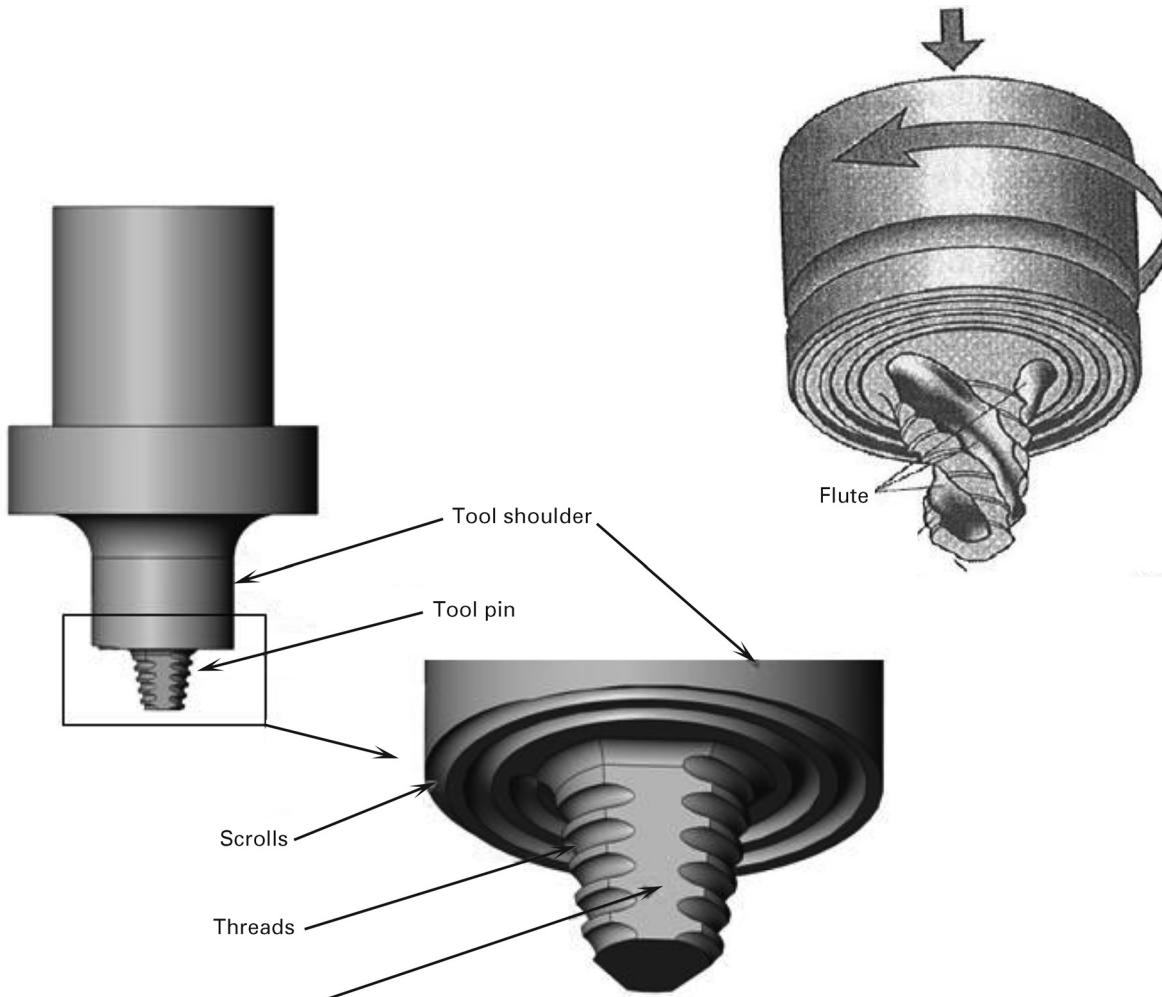
SP = Special Positions (see QW-303.3)

(2) Tack welds are not limited by pipe or tube diameters when their aggregate length does not exceed 25% of the weld circumference.

(3) Pipe 2 $\frac{7}{8}$ in. (73 mm) O.D. and over.

(4) See diameter restrictions in QW-452.3, QW-452.4, and QW-452.6.

Figure QW-461.10
Rotating Tool Design Characteristics (FSW) Referenced in QW-410



(21) **QW-462 TEST SPECIMENS**

The purpose of the QW-462 figures is to give the organization guidance in dimensioning test specimens for tests required for procedure and performance qualifications. Unless a minimum, maximum, or tolerance is given in the figures (or as QW-150, QW-160, or QW-180 requires), the dimensions are to be considered approximate. All welding processes and filler material to be qualified must be included in the test specimen.

The following nomenclature is in reference to Figures QW-462.1(a) through QW-462.1(e):

T = coupon thickness excluding reinforcement
 W = specimen width, $\frac{3}{4}$ in. (19 mm)

x = coupon thickness including reinforcement

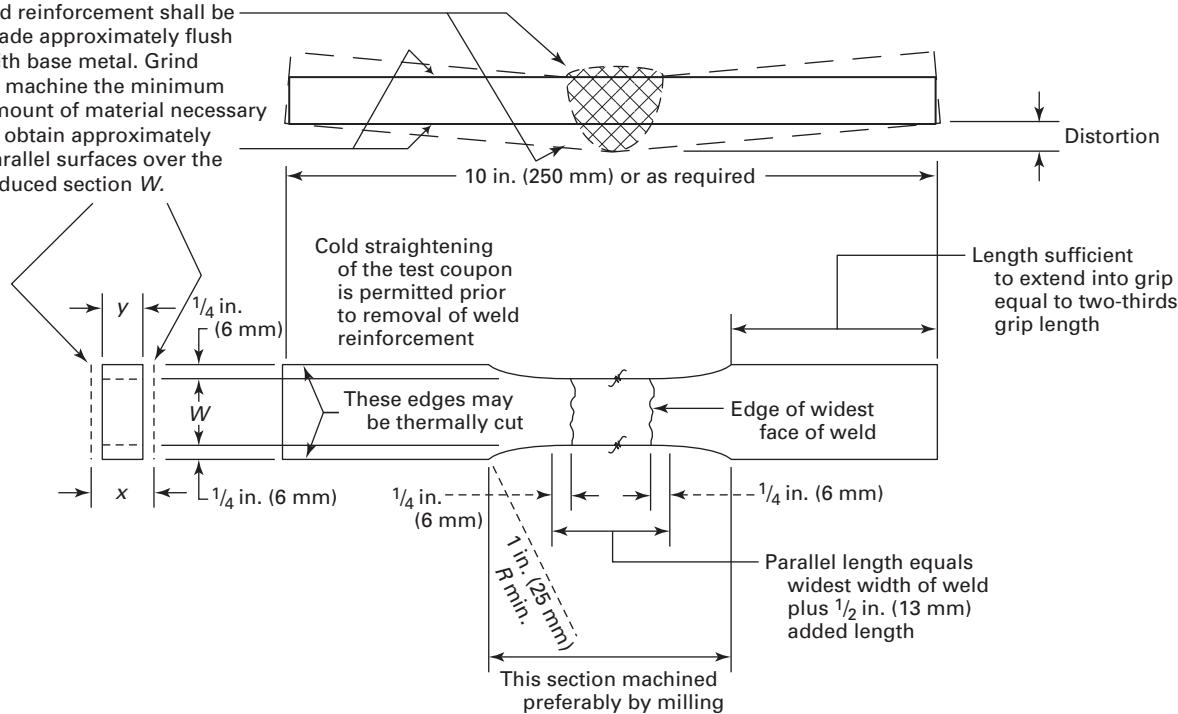
y = specimen thickness

As an alternative, any tension specimen dimensional geometry meeting the requirements of another welding qualification standard is acceptable as long as a cross section can be measured so that an ultimate tensile strength can be determined. All welding processes, filler materials, and heat-affected zones to be qualified shall be included in the test specimen. Weld reinforcement shall be removed prior to testing.

Single or multiple bend test specimens and jigs meeting the dimensional requirements of ISO 5173 are also acceptable, provided the bend-radius-to-specimen-thickness ratios shown in Figure QW-466.1 are met.

Figure QW-462.1(a)
Tension — Reduced Section — Plate

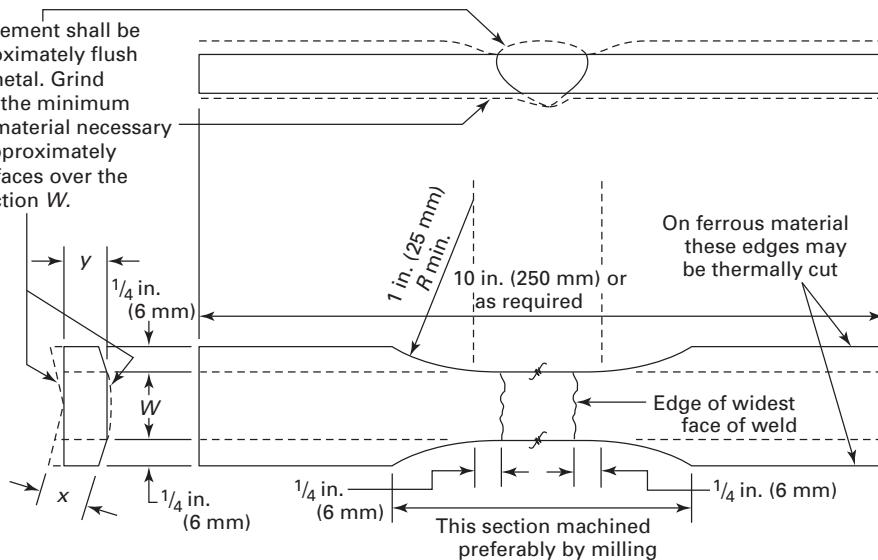
Weld reinforcement shall be made approximately flush with base metal. Grind or machine the minimum amount of material necessary to obtain approximately parallel surfaces over the reduced section W .



GENERAL NOTE: Specimens having a reduced section nominal width, W , that is greater than the nominal $\frac{3}{4}$ -in. (19-mm) width may be used.

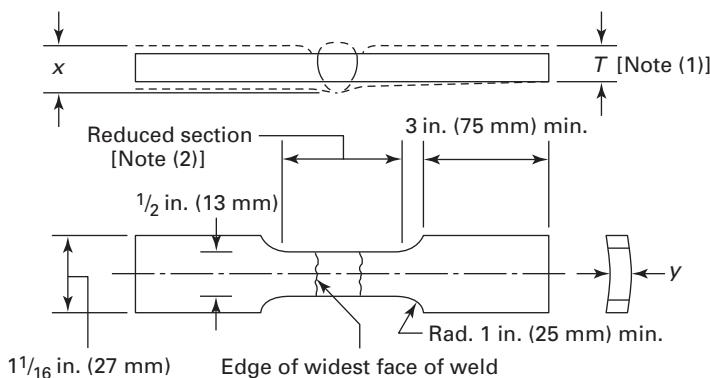
Figure QW-462.1(b)
Tension — Reduced Section — Pipe

Weld reinforcement shall be made approximately flush with base metal. Grind or machine the minimum amount of material necessary to obtain approximately parallel surfaces over the reduced section W .



GENERAL NOTE: Specimens having a reduced section nominal width, W , that is greater than the nominal $\frac{3}{4}$ -in. (19-mm) width may be used.

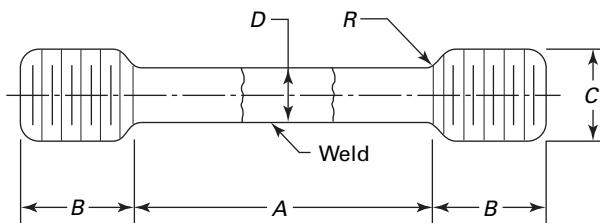
Figure QW-462.1(c)
Tension — Reduced Section Alternate for Pipe



NOTES:

- (1) The weld reinforcement shall be ground or machined so that the weld thickness does not exceed the base metal thickness T . Machine minimum amount to obtain approximately parallel surfaces.
- (2) The reduced section shall not be less than the width of the weld plus $2y$.

Figure QW-462.1(d)
Tension — Reduced Section — Turned Specimens



Standard Dimensions, in. (mm)				
	(a) 0.505 Specimen	(b) 0.353 Specimen	(c) 0.252 Specimen	(d) 0.188 Specimen
A - Length of reduced section	[Note (1)]	[Note (1)]	[Note (1)]	[Note (1)]
D - Diameter	0.500 ± 0.010 (12.7 ± 0.25)	0.350 ± 0.007 (8.89 ± 0.18)	0.250 ± 0.005 (6.35 ± 0.13)	0.188 ± 0.003 (4.78 ± 0.08)
R - Radius of fillet	$\frac{3}{8}$ (10) min.	$\frac{1}{4}$ (6) min.	$\frac{3}{16}$ (5) min.	$\frac{1}{8}$ (3) min.
B - Length of end section	$1\frac{3}{8}$ (35) approx.	$1\frac{1}{8}$ (29) approx.	$\frac{7}{8}$ (22) approx.	$\frac{1}{2}$ (13) approx.
C - Diameter of end section	$\frac{3}{4}$ (19)	$\frac{1}{2}$ (13)	$\frac{3}{8}$ (10)	$\frac{1}{4}$ (6)

GENERAL NOTES:

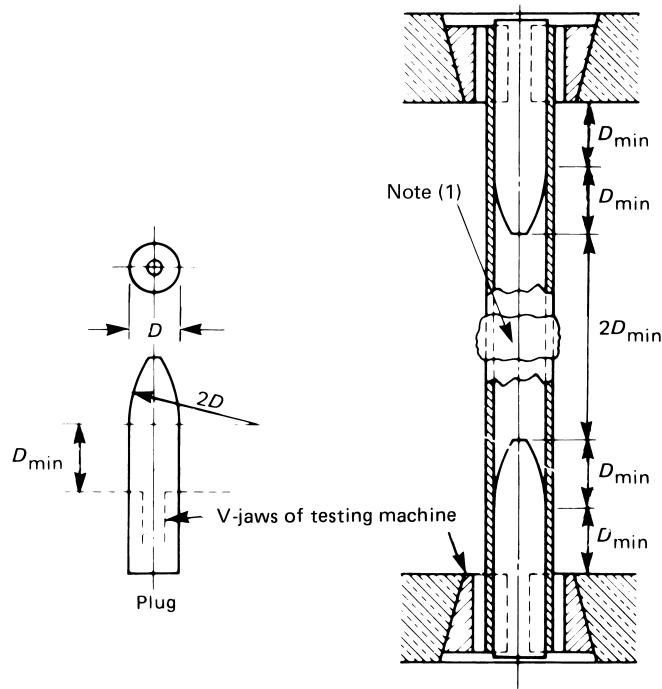
- (a) Use maximum diameter specimen (a), (b), (c), or (d) that can be cut from the section.
- (b) Weld should be in center of reduced section.
- (c) Where only a single coupon is required, the center of the specimen should be midway between the surfaces.
- (d) The ends may be of any shape to fit the holders of the testing machine in such a way that the load is applied axially.
- (e) When the diameter, D , of the reduced section is measured and the actual value is used to calculate the tensile stress, specimens of nominal diameters other than those shown above may be used.

NOTE:

- (1) Reduced section A should not be less than width of weld plus $2D$.

(21)

Figure QW-462.1(e)
Tension — Full Section — Small Diameter Pipe

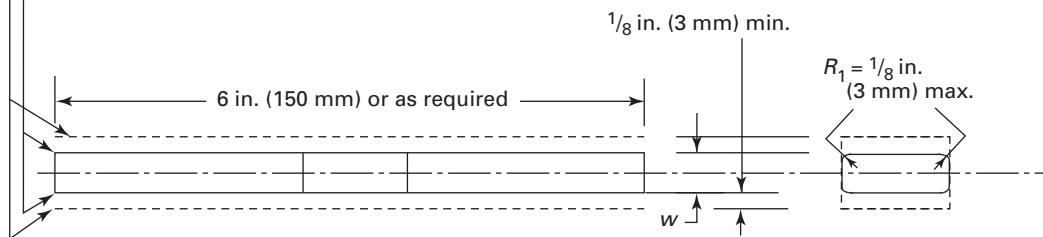


NOTE:

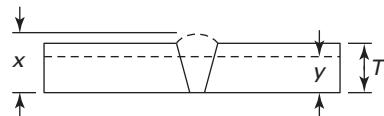
- (1) The outside surface of the weld shall be made approximately flush with the base metal to obtain a uniform cross section. The average of four equally spaced wall thickness measurements shall be used to calculate the tensile strength.

**Figure QW-462.2
Side Bend**

- (1a) For procedure qualification of materials other than P-No. 1 in Table QW/QB-422 if the surfaces of the side-bend test specimens are gas cut, removal by machining or grinding of not less than $\frac{1}{8}$ in. (3 mm) from the surface shall be required.
- (1b) Such removal is not required for P-No. 1 materials, but any resulting roughness shall be dressed by machining or grinding.
- (2) For performance qualification of all materials in Table QW/QB-422, if the surfaces of specimens are gas cut, any resulting roughness shall be dressed by machining or grinding.



T , in. (mm)	y , in. (mm)	w , in. (mm)	
		P-No. 23, F-No. 23, F-No. 26, or P-No. 35	All other metals
$\frac{3}{8}$ to $< \frac{11}{2}$ (10 to < 38)	T [Note (1)]	$\frac{1}{8}$ (3)	$\frac{3}{8}$ (10)
$\geq 1\frac{1}{2}$ (≥ 38)	Notes (1) and (2)	$\frac{1}{8}$ (3)	$\frac{3}{8}$ (10)



GENERAL NOTE: Weld reinforcement and backing strip or backing ring, if any, may be removed flush with the surface of the specimen. Thermal cutting, machining, or grinding may be employed. Cold straightening is permitted prior to removal of the reinforcement.

NOTES:

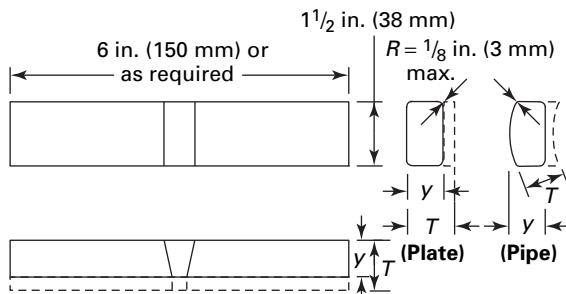
- (1) When weld deposit t is less than coupon thickness T , side-bend specimen thickness may be t .
- (2) When coupon thickness T equals or exceeds $1\frac{1}{2}$ in. (38 mm), use one of the following:
 - (a) Cut specimen into multiple test specimens of thickness y of approximately equal dimensions $\frac{3}{4}$ in. to $1\frac{1}{2}$ in. (19 mm to 38 mm).

y = tested specimen thickness when multiple specimens are taken from one coupon.

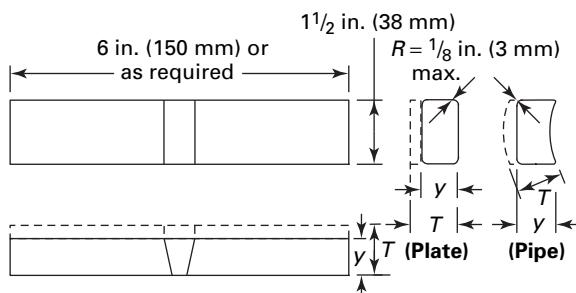
- (b) The specimen may be bent at full width. See requirements on jig width in [Figure QW-466.1](#).

(21)

Figure QW-462.3(a)
Face and Root Bends — Transverse



Face-Bend Specimen — Plate and Pipe



Root-Bend Specimen — Plate and Pipe

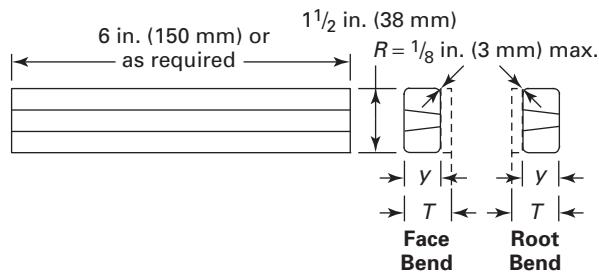
<i>T</i> , in. (mm)	<i>Y</i> , in. (mm)	
	P-No. 23, F-No. 23, All Other F-No. 26, or P-No. 35 Metals	
<1/8 (3)	<i>T</i>	<i>T</i>
1/8 to 3/8 (3 to 10)	1/8 (3)	<i>T</i>
>3/8 (10)	1/8 (3)	3/8 (10)

GENERAL NOTES:

- (a) Weld reinforcement and backing strip or backing ring, if any, may be removed flush with the surface of the specimen. If a recessed ring is used, this surface of the specimen may be machined to a depth not exceeding the depth of the recess to remove the ring, except that in such cases the thickness of the finished specimen shall be that specified above. Do not flame-cut nonferrous material.
- (b) If the pipe being tested has a diameter of NPS 4 (DN 100) or less, the width of the bend specimen may be 3/4 in. (19 mm) for pipe diameters NPS 2 (DN 50) to and including NPS 4 (DN 100). The bend specimen width may be 3/8 in. (10 mm) for pipe diameters less than NPS 2 (DN 50) down to and including NPS 3/8 (DN 10) and as an alternative, if the pipe being tested is equal to or less than NPS 1 (DN 25) pipe size, the width of the bend specimens may be that obtained by cutting the pipe into quarter sections, less an allowance for saw cuts or machine cutting. These specimens cut into quarter sections are not required to have one surface machined flat as shown in QW-462.3(a). Bend specimens taken from tubing of comparable sizes may be handled in a similar manner.

(21)

Figure QW-462.3(b)
Face and Root Bends — Longitudinal

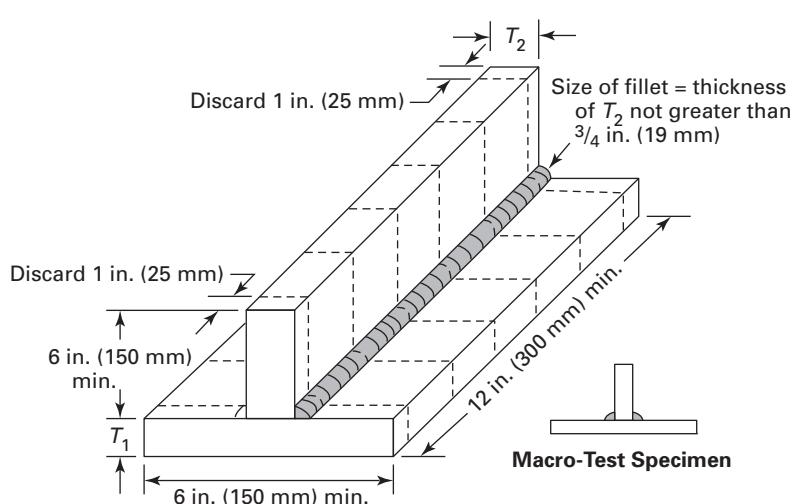


y, in. (mm)		
T, in. (mm)	P-No. 23, F-No. 23, All Other or P-No. 35 Metals	
<1/8 (3)	T	T
1/8 to 3/8 (3 to 10)	1/8 (3)	T
>3/8 (10)	1/8 (3)	3/8 (10)

GENERAL NOTE: Weld reinforcements and backing strip or backing ring, if any, shall be removed essentially flush with the undisturbed surface of the base material. If a recessed strip is used, this surface of the specimen may be machined to a depth not exceeding the depth of the recess to remove the strip, except that in such cases the thickness of the finished specimen shall be that specified above.

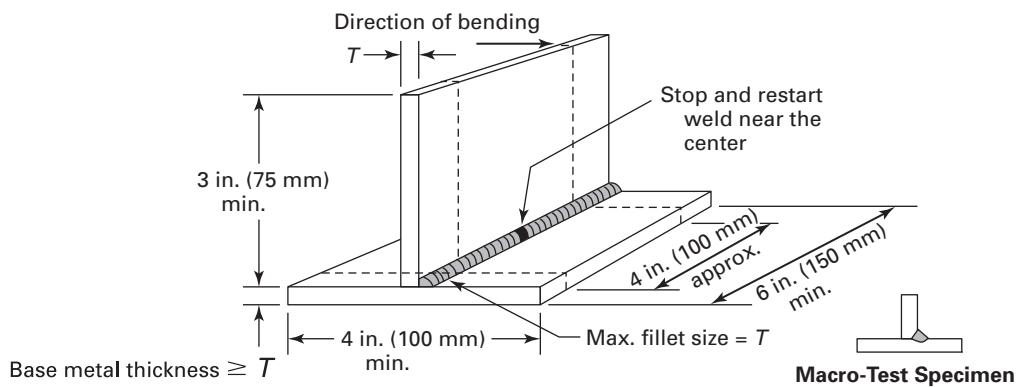
Figure QW-462.4(a)
Fillet Welds in Plate — Procedure

T_1	T_2
1/8 in. (3 mm) and less	T_1
Over 1/8 in. (3 mm)	Equal to or less than T_1 , but not less than 1/8 in. (3 mm)



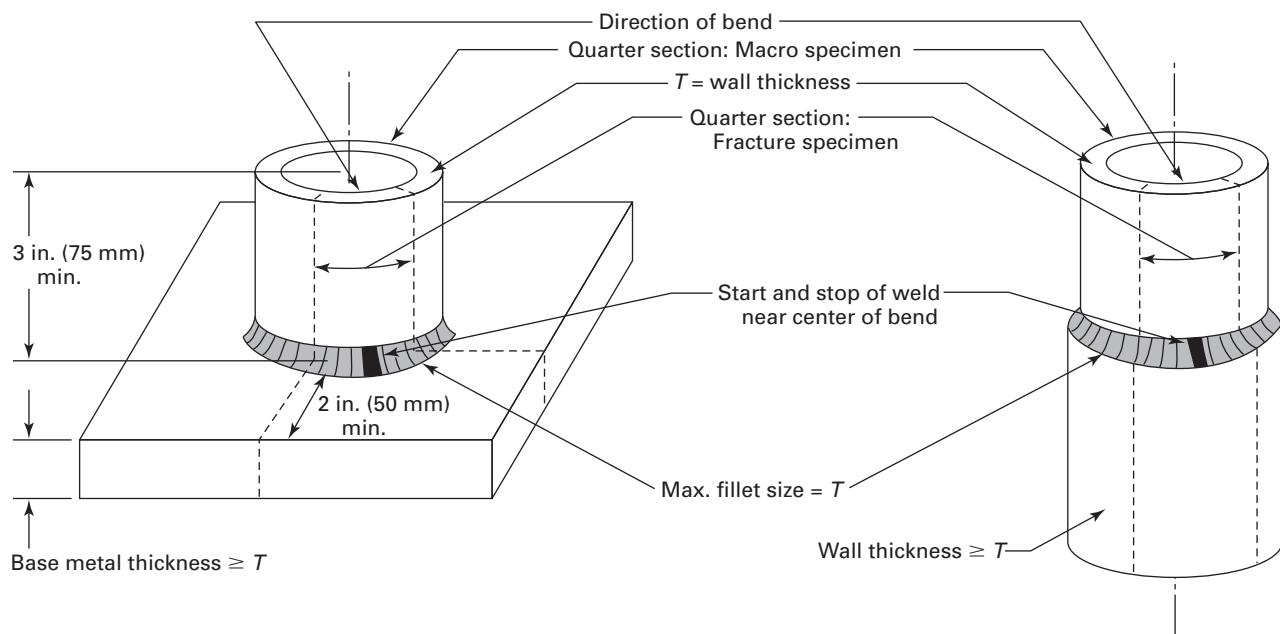
GENERAL NOTE: Macro test — the fillet shall show fusion at the root of the weld but not necessarily beyond the root. The weld metal and heat-affected zone shall be free of cracks.

Figure QW-462.4(b)
Fillet Welds in Plate — Performance



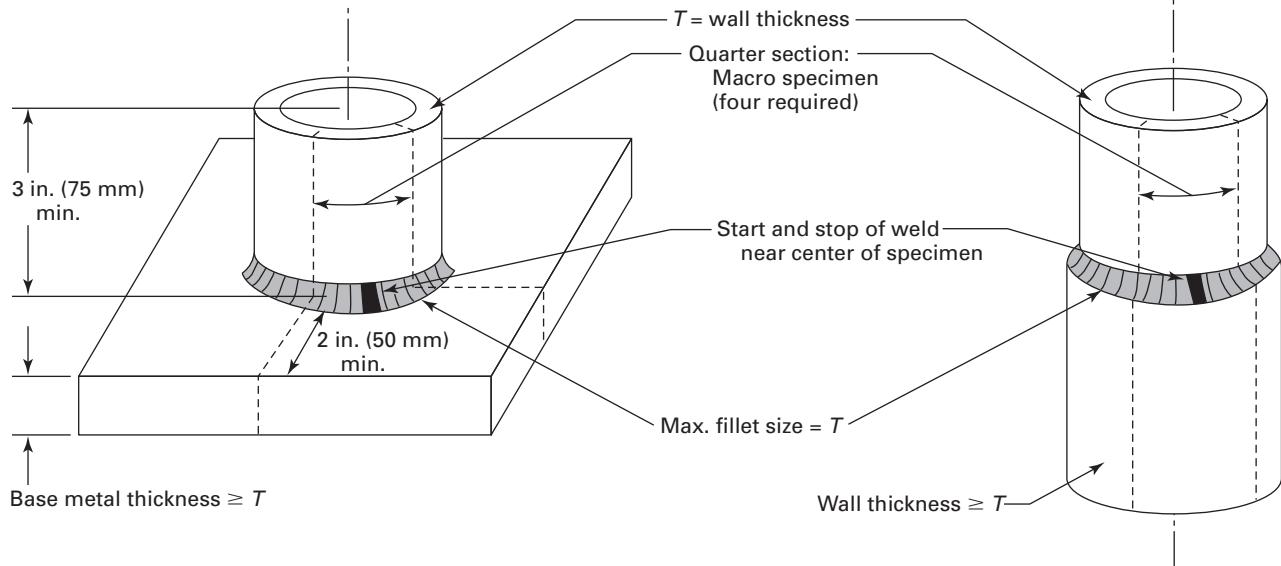
GENERAL NOTE: Refer to [Table QW-452.5](#) for T thickness and qualification ranges.

Figure QW-462.4(c)
Fillet Welds in Pipe — Performance



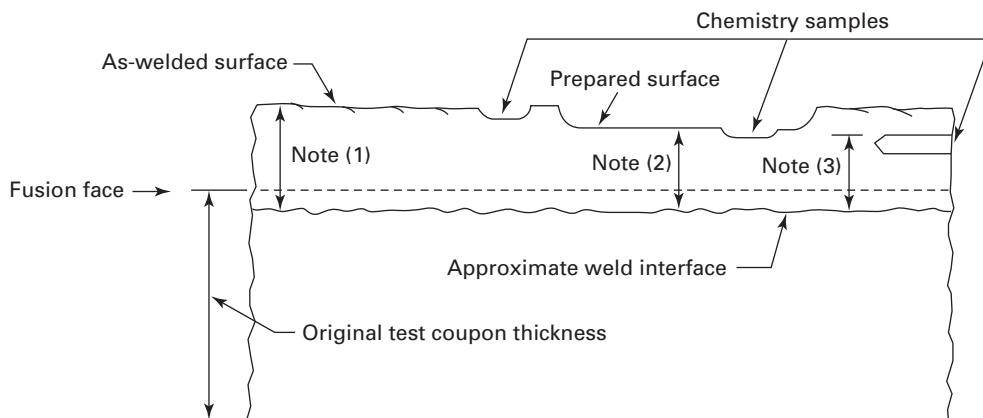
GENERAL NOTE: Either pipe-to-plate or pipe-to-pipe may be used as shown.

Figure QW-462.4(d)
Fillet Welds in Pipe — Procedure



GENERAL NOTE: Either pipe-to-plate or pipe-to-pipe may be used as shown.

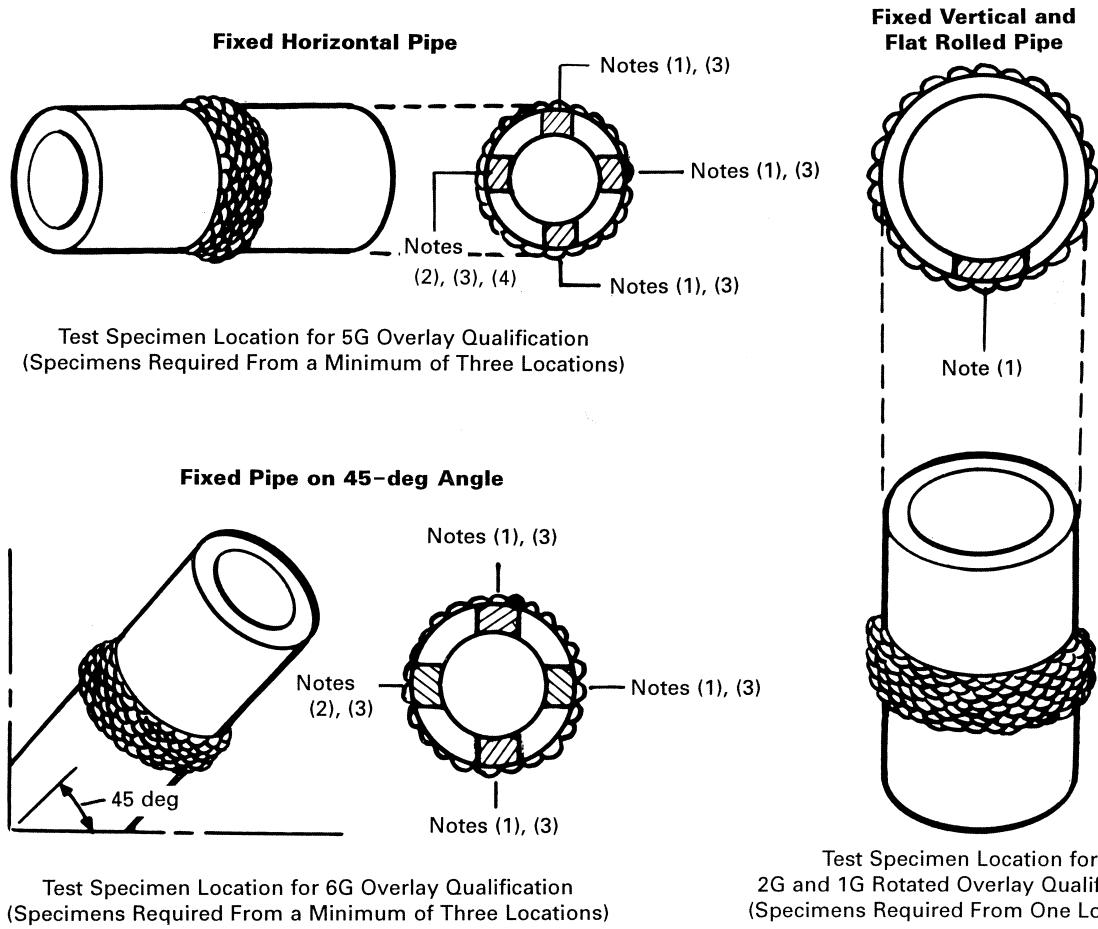
Figure QW-462.5(a)
Chemical Analysis and Hardness Specimen Corrosion-Resistant and Hard-Facing Weld Metal Overlay



NOTES:

- (1) When a chemical analysis or hardness test is conducted on the as-welded surface, the distance from the approximate weld interface to the final as-welded surface shall become the minimum qualified overlay thickness. The chemical analysis may be performed directly on the as-welded surface or on chips of material taken from the as-welded surface.
- (2) When a chemical analysis or hardness test is conducted after material has been removed from the as-welded surface, the distance from the approximate weld interface to the prepared surface shall become the minimum qualified overlay thickness. The chemical analysis may be made directly on the prepared surface or from chips removed from the prepared surface.
- (3) When a chemical analysis test is conducted on material removed by a horizontal drilled sample, the distance from the approximate weld interface to the uppermost side of the drilled cavity shall become the minimum qualified overlay thickness. The chemical analysis shall be performed on chips of material removed from the drilled cavity.

Figure QW-462.5(b)
Chemical Analysis Specimen, Hard-Facing Overlay Hardness, and Macro Test Location(s) for Corrosion-Resistant and Hard-Facing Weld Metal Overlay

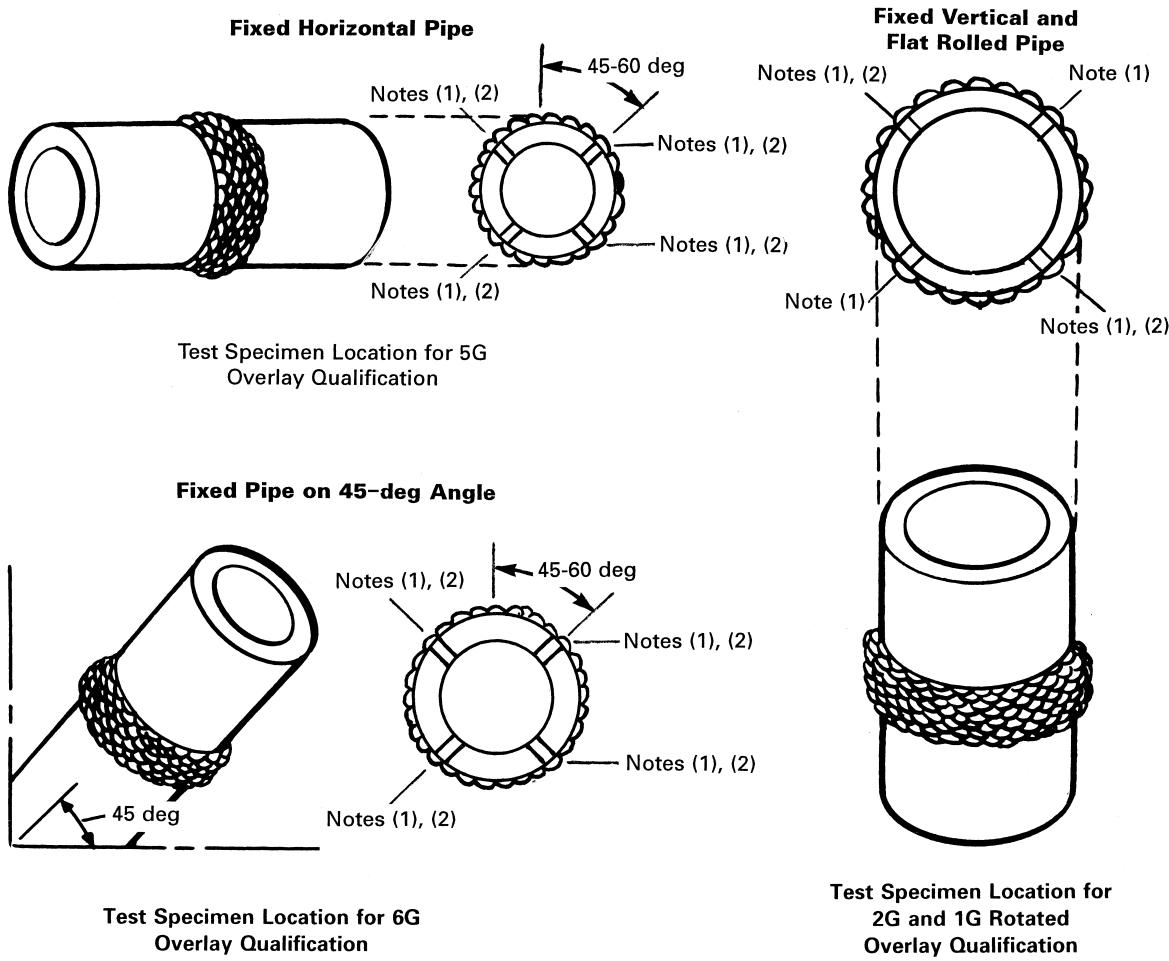


GENERAL NOTE: Overlay may be on the inside or outside of pipe.

NOTES:

- (1) Location of required test specimen removal ([Table QW-453](#)). Refer to [Figure QW-462.5\(a\)](#) for chemical analysis and hardness test surface locations and minimum qualified thickness.
- (2) Testing of circumferential hard-facing weld metal on pipe procedure qualification coupons may be limited to a single segment (completed utilizing the vertical, up-hill progression) for the chemical analysis, hardness, and macro-etch tests required in [Table QW-453](#). Removal is required for a change from vertical down to vertical up-hill progression (but not vice-versa).
- (3) Location of test specimens shall be in accordance with the angular position limitations of [QW-120](#).
- (4) When overlay welding is performed using machine or automatic welding and the vertical travel direction of adjacent weld beads is reversed on alternate passes, only one chemical analysis or hardness specimen is required to represent the vertical portion. Qualification is then restricted in production to require alternate pass reversal of rotation direction method.

Figure QW-462.5(c)
Pipe Bend Specimen — Corrosion-Resistant Weld Metal Overlay

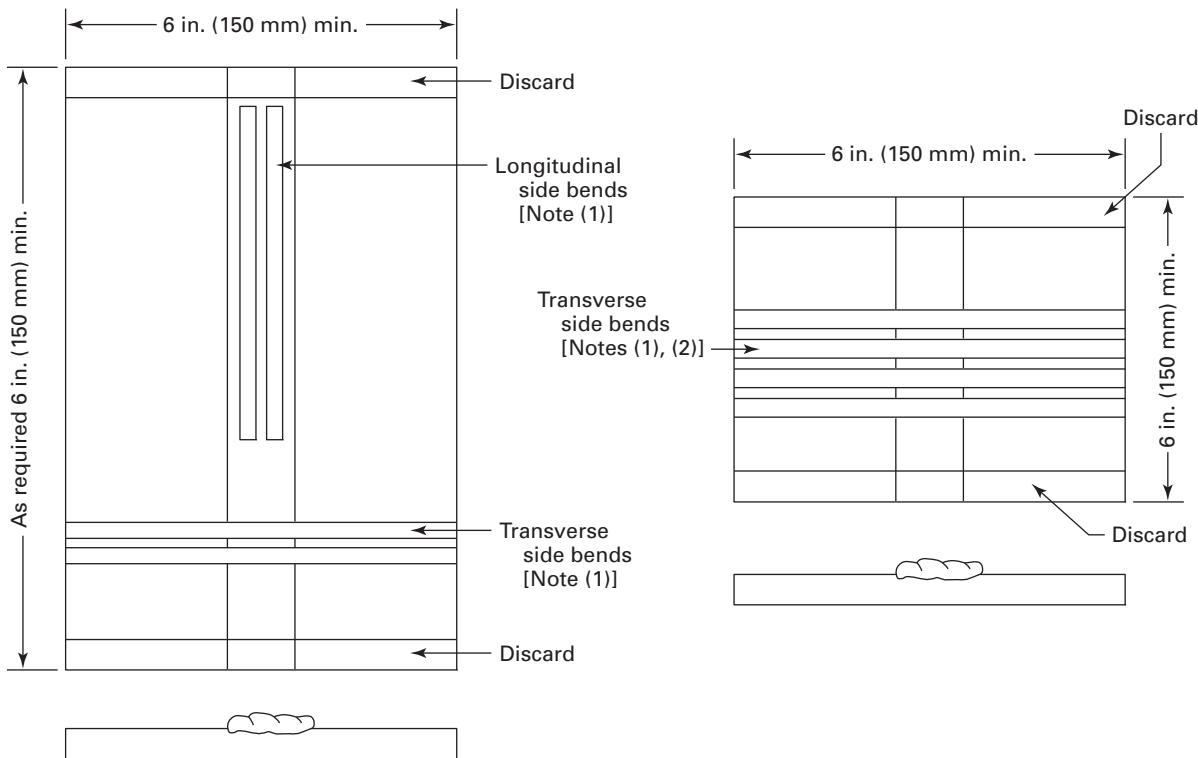


GENERAL NOTE: Overlay may be on the inside or outside of pipe.

NOTES:

- (1) Location for required test specimen removal — Procedure ([Table QW-453](#)).
- (2) Location for required test specimen removal — Performance ([Table QW-453](#)).

Figure QW-462.5(d)
Plate Bend Specimens — Corrosion-Resistant Weld Metal Overlay

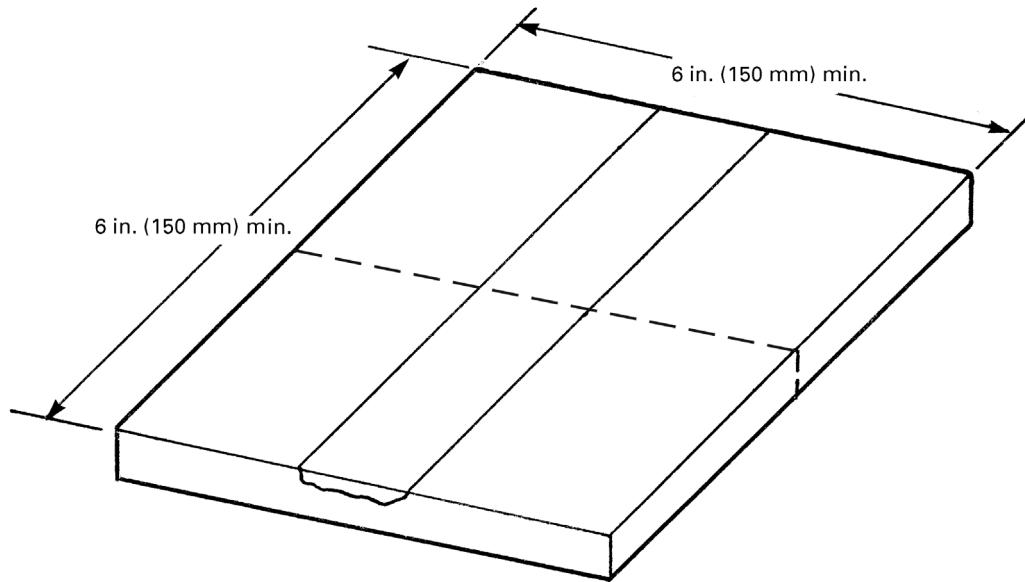


NOTES:

- (1) Location for required test specimen removal — Procedure ([Table QW-453](#)). Four side-bend test specimens are required for each position.
- (2) Location for required test specimen removal — Performance ([Table QW-453](#)). Two side-bend test specimens are required for each position.

Figure QW-462.5(e)

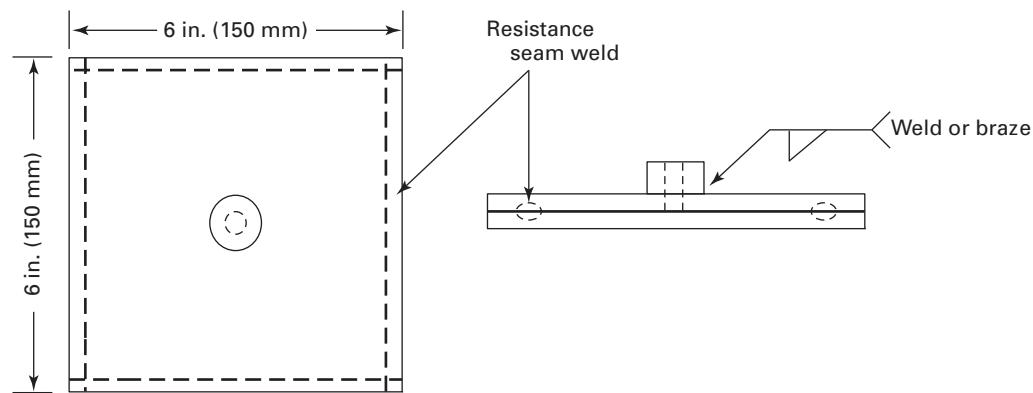
Plate Macro, Hardness, and Chemical Analysis Specimens — Corrosion-Resistant and Hard-Facing Weld Metal Overlay

**GENERAL NOTES:**

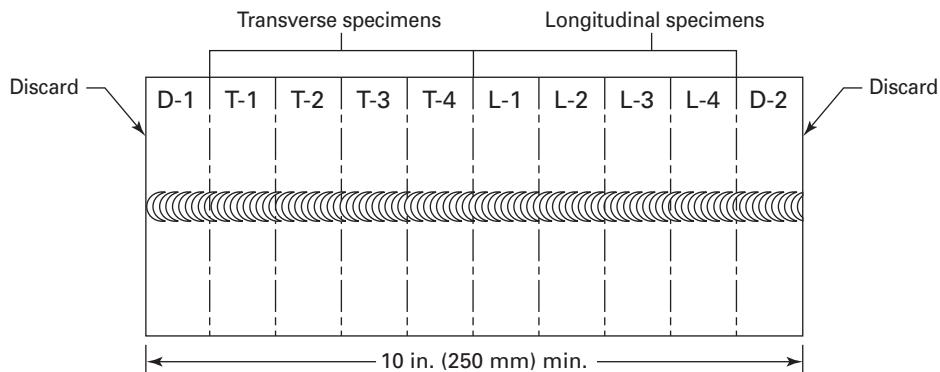
- (a) Location of required test specimen removal ([Table QW-453](#)). One required for each position. Refer to [Figure QW-462.5\(a\)](#) for chemical analysis and hardness test surface locations and minimum qualified thickness.
- (b) Removal required for a change from vertical up to vertical down and vice versa.

Figure QW-462.7.1

Resistance Seam Weld Test Coupon



**Figure QW-462.7.2
Seam Weld Section Specimen Removal**



GENERAL NOTE: Mark the coupon into ten equal length specimens, label one end of the coupon D-1 the other end D-2. Cut the 10 in. (250 mm) coupon (transverse to the weld length) into pieces 5 in. (125 mm) long each.

(1) *Transverse Weld Cross Section Instructions*

(a) Cut five specimens each approximately 1 in. (25 mm) in length from the coupon labeled D-1 and discard the piece marked D-1.

(b) Mark the remaining four specimens T-1 through T-4, prepare the specimens as detailed in (2)(b)(-1) below for examination, adjacent faces at the cut shall not be used.

(2) *Longitudinal Weld Cross Section Instructions*

(a) Cut five specimens each approximately 1 in. (25 mm) in length from the coupon labeled D-2 and discard the piece marked D-2.

(b) Mark the remaining four specimens L-1 through L-4, cut the specimens at approximately $\frac{1}{3}$ of the weld width from the weld center-line through the length of each specimen in the longitudinal weld direction. Discard the four specimens containing approximately the $\frac{1}{3}$ weld width, the remaining four specimens containing approximately the $\frac{2}{3}$ weld width shall be prepared as detailed in (-1) below for examination.

(-1) The specimens shall be smoothed and etched with a suitable etchant (see [QW-470](#)) to give a clear definition to the weld metal and heat-affected zone.

**Figure QW-462.7.3
Resistance Weld Nugget Section Test Specimens**

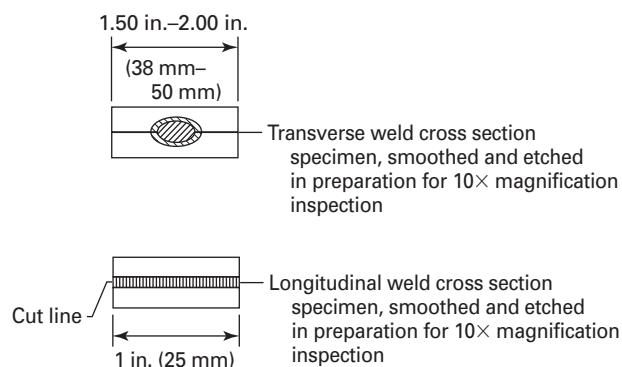
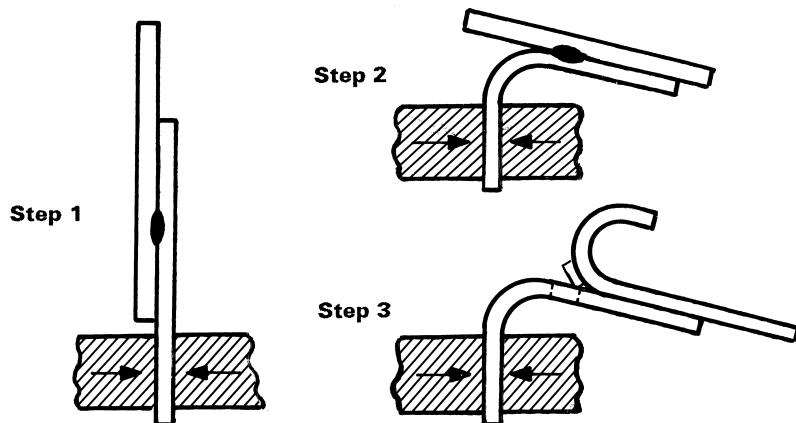


Figure QW-462.8.1
Spot Welds in Sheets



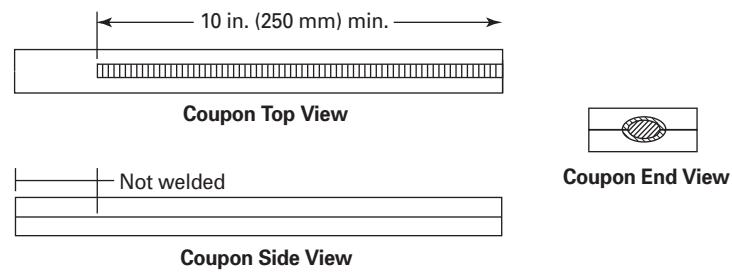
Peel Test

Step 1 - Grip in vise or other suitable device.

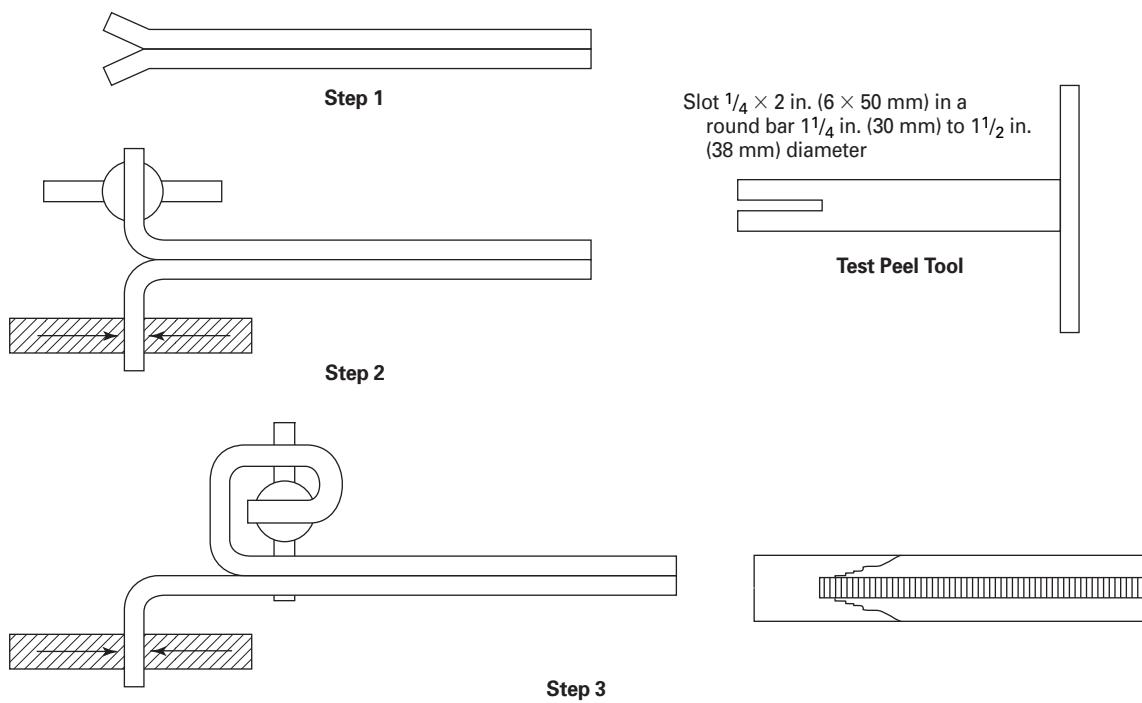
Step 2 - Bend specimen.

Step 3 - Peel pieces apart with pincers or other suitable tool.

Figure QW-462.8.2
Seam Weld Peel Test Specimen and Method

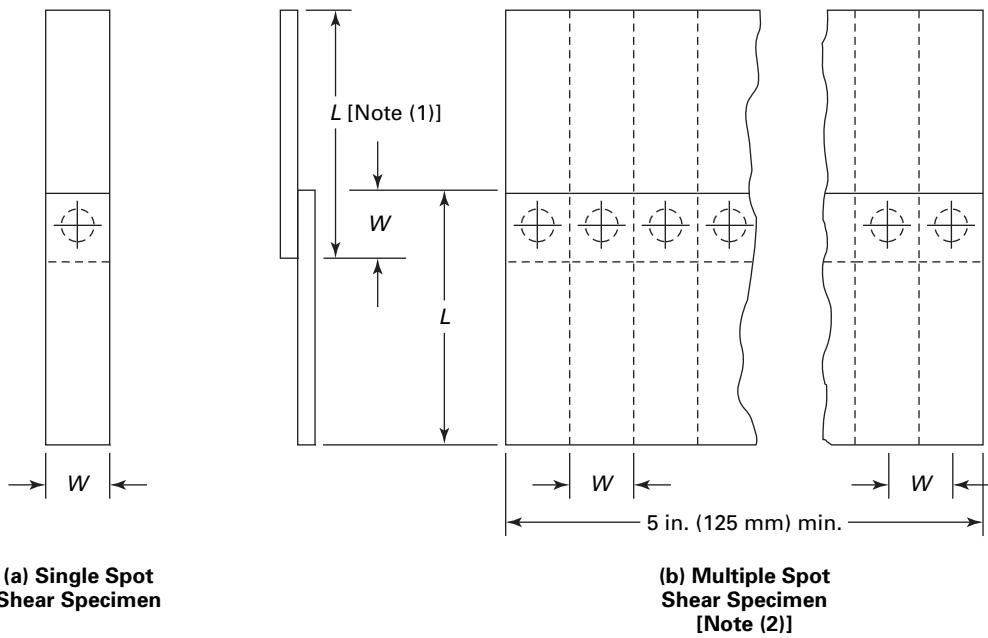


Prior to Peel Test

**Peel Test**

- Step 1 — Separate coupon plies in nonwelded end.
- Step 2 — Grip in vise or other suitable device, bend specimen.
- Step 3 — Peel pieces apart with pincers or other suitable tool.

Figure QW-462.9
Spot Welds in Sheet

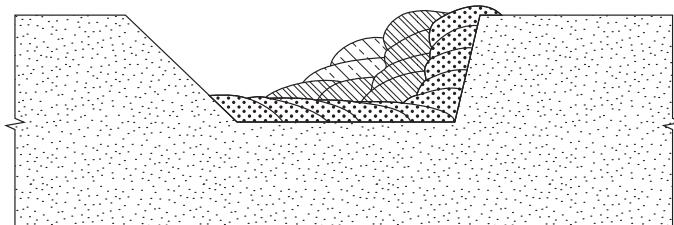


Nominal Thickness of Thinner Sheet, in. (mm)	W, in. (mm) Min.
Over 0.008 to 0.030 (0.20 to 0.8)	0.68 (17)
Over 0.030 to 0.100 (0.8 to 2.5)	1.00 (25)
Over 0.100 to 0.130 (2.5 to 3)	1.25 (30)
Over 0.130 (3)	1.50 (38)

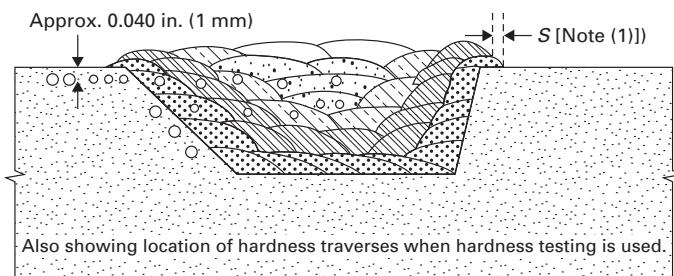
NOTES:

- (1) L shall be not less than $4W$.
- (2) Sketch (b) shall be made of 5 specimens or more.

Figure QW-462.12
Nomenclature for Temper Bead Welding



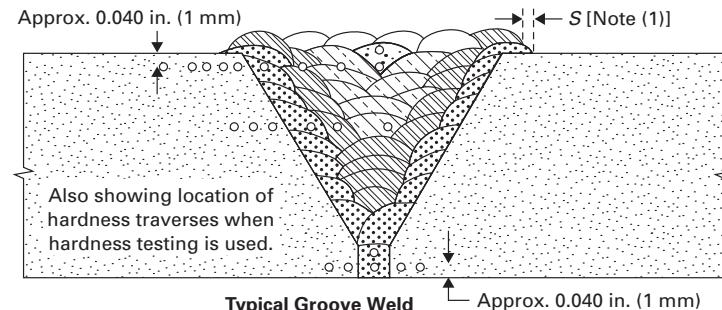
Partially Completed Partial-Penetration Weld



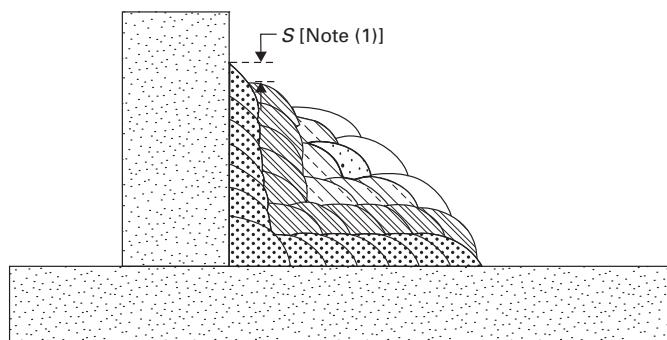
Completed Partial-Penetration Weld

LEGEND
See Note (2)

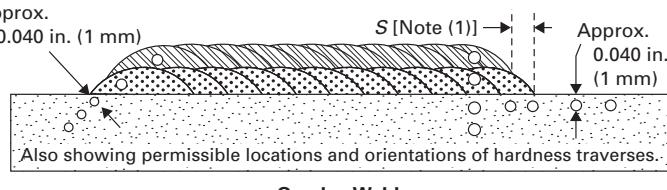
[Dotted Pattern]	Weld Beads Against Base Metal
[Cross-Hatch Pattern]	First Layer Tempering Beads
[Vertical Hatching Pattern]	Second Layer Tempering Beads
[Dotted Pattern]	Fill Weld Beads
[Solid White Box]	Surface Temper Weld Reinforcing Beads



Typical Groove Weld



Typical Fillet Weld



Overlay Weld

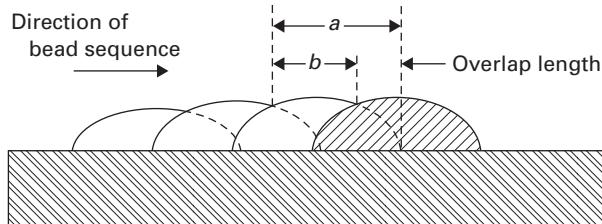
GENERAL NOTES:

- (a) Weld beads shown above may be deposited in any sequence that will result in placement of the beads as shown.
- (b) Surface temper reinforcing beads may cover the entire weld surface, or may only be placed at the toe of the weld; they may or may not be mechanically removed.

NOTES:

- (1) The distance, S , is measured from the toe of the weld to the edge of the temper beads. Measurements shall be made parallel to the base metal surface.
- (2) Beads near the finished surface may be both tempering beads and surface temper reinforcing beads.

Figure QW-462.13
Measurement of Temper Bead Overlap



GENERAL NOTE: Measurement of bead overlap - % overlap length = $(a - b)/a \times 100\%$. In this figure, the shaded bead overlaps previous bead by 30% to 40%. The distance a is measured before the next bead is deposited.

Figure QW-463.1(a)
Plates — Less Than $\frac{3}{4}$ in. (19 mm) Thickness Procedure Qualification

Discard		this piece
Reduced section		tensile specimen
Root bend		specimen
Face bend		specimen
Root bend		specimen
Face bend		specimen
Reduced section		tensile specimen
Discard		this piece



Figure QW-463.1(b)
Plates — $\frac{3}{4}$ in. (19 mm) and Over Thickness and Alternate From $\frac{3}{8}$ in. (10 mm) but Less Than $\frac{3}{4}$ in. (19 mm) Thickness Procedure Qualification

Discard		this piece
Side bend		specimen
Reduced section		tensile specimen
Side bend		specimen
Side bend		specimen
Reduced section		tensile specimen
Side bend		specimen
Discard		this piece



Figure QW-463.1(c)
Plates — Longitudinal Procedure Qualification

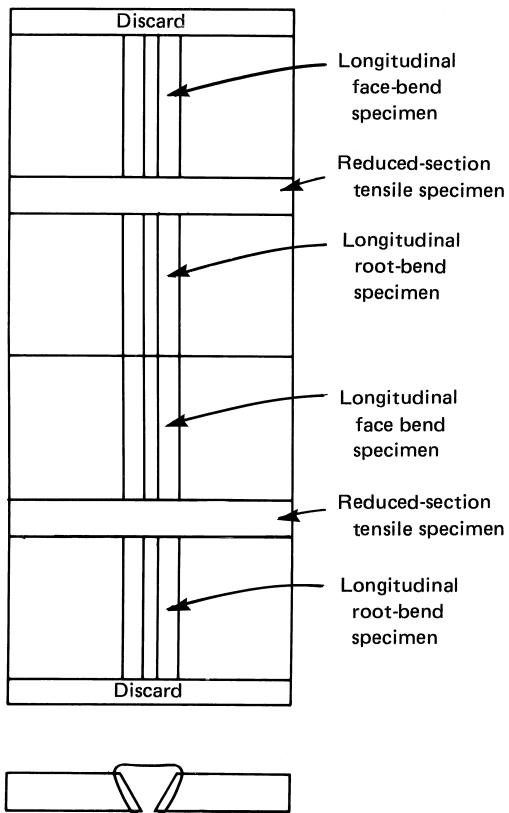


Figure QW-463.1(d)
Procedure Qualification

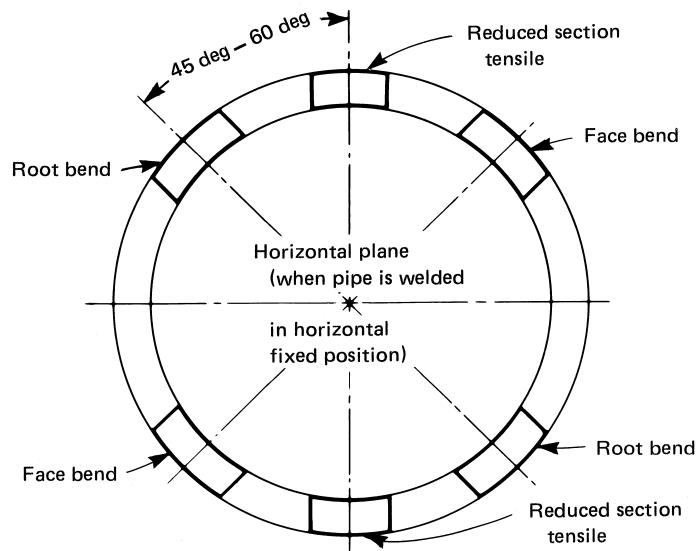


Figure QW-463.1(e)
Procedure Qualification

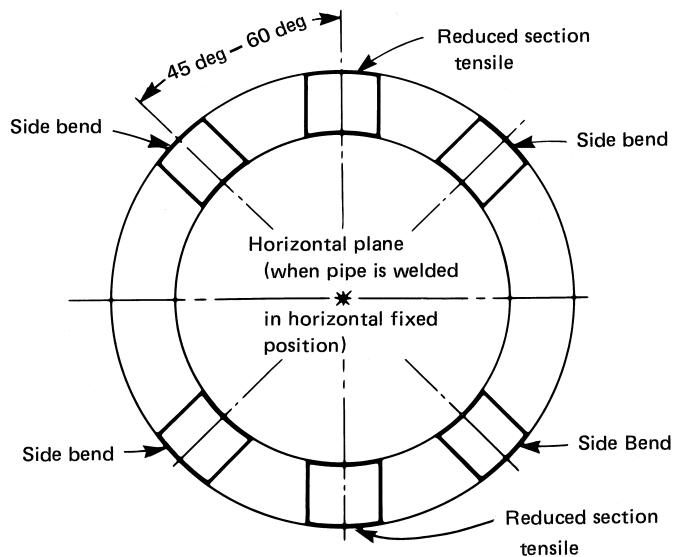


Figure QW-463.1(f)
Toughness Test Specimen Location

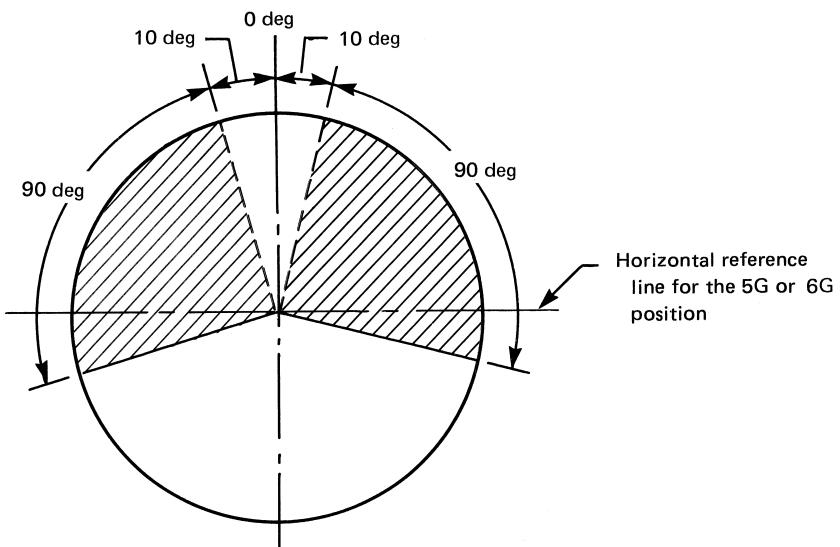


Figure QW-463.2(a)
Plates — Less Than $\frac{3}{4}$ in. (19 mm) Thickness Performance Qualification

Discard	this piece
Root-bend	specimen
Face-bend	specimen
Discard	this piece

**Figure QW-463.2(b)**

Plates — $\frac{3}{4}$ in. (19 mm) and Over Thickness and Alternate From $\frac{3}{8}$ in. (10 mm) but Less Than $\frac{3}{4}$ in. (19 mm) Thickness Performance Qualification

Discard	this piece
Side-bend	specimen
Side-bend	specimen
Discard	this piece

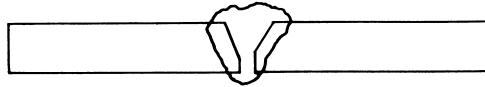


Figure QW-463.2(c)
Plates — Longitudinal Performance Qualification

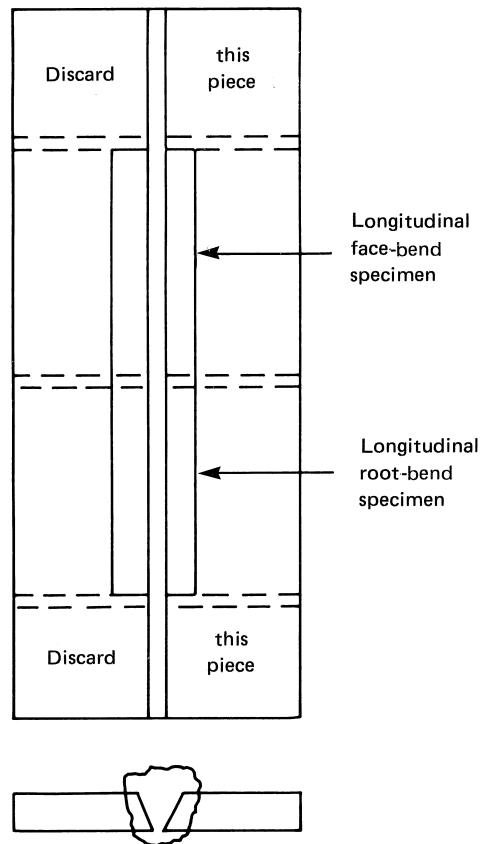


Figure QW-463.2(d)
Performance Qualification

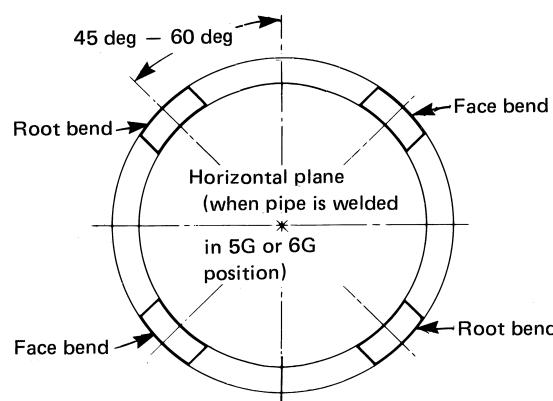


Figure QW-463.2(e)
Performance Qualification

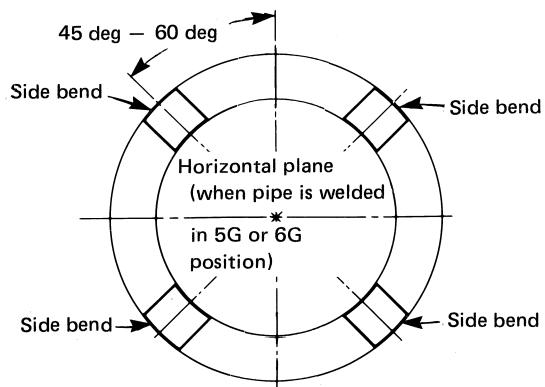


Figure QW-463.2(f)
Pipe — NPS 10 (DN 250) Assembly Performance Qualification

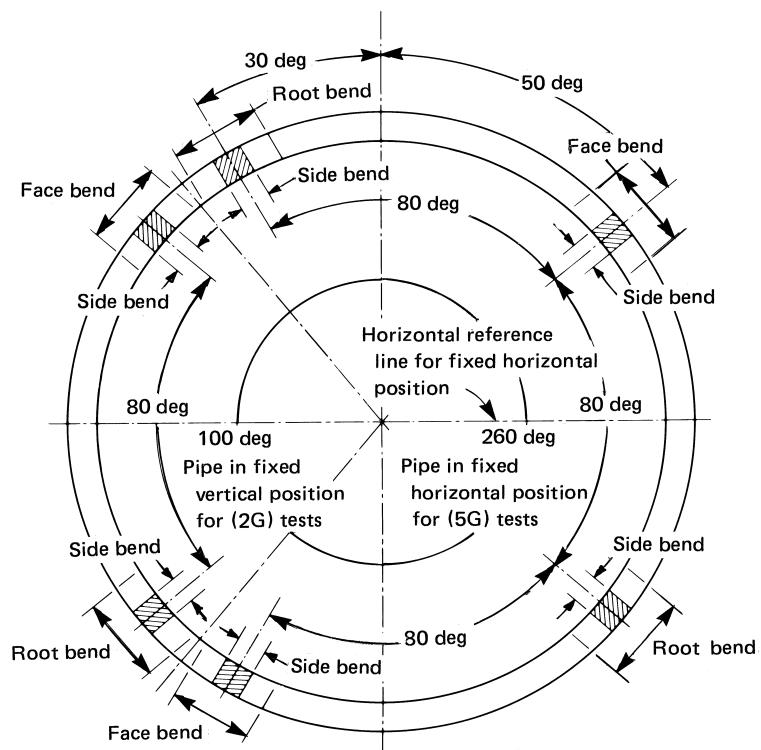


Figure QW-463.2(g)
NPS 6 (DN 150) or NPS 8 (DN 200) Assembly Performance Qualification

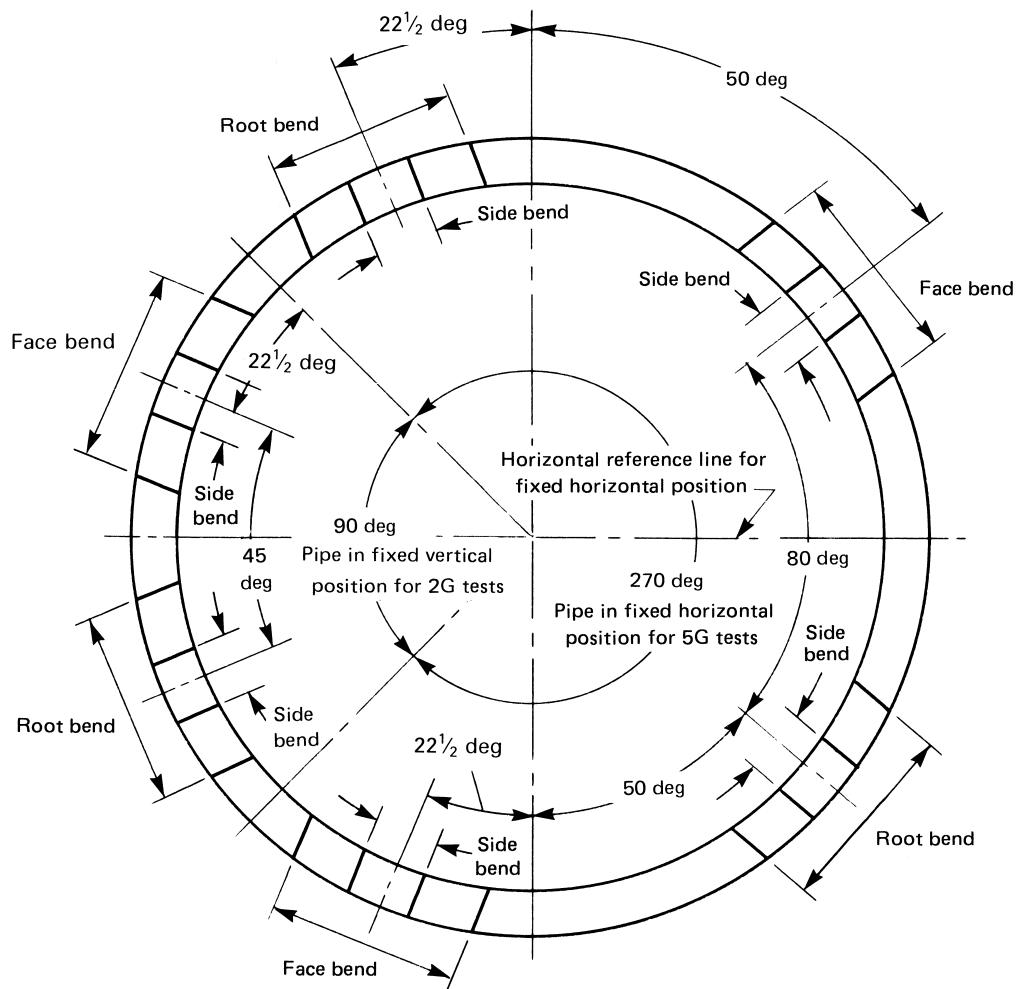
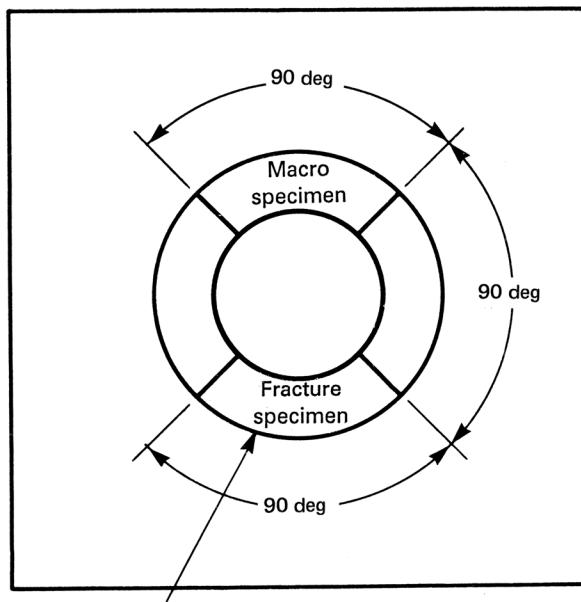
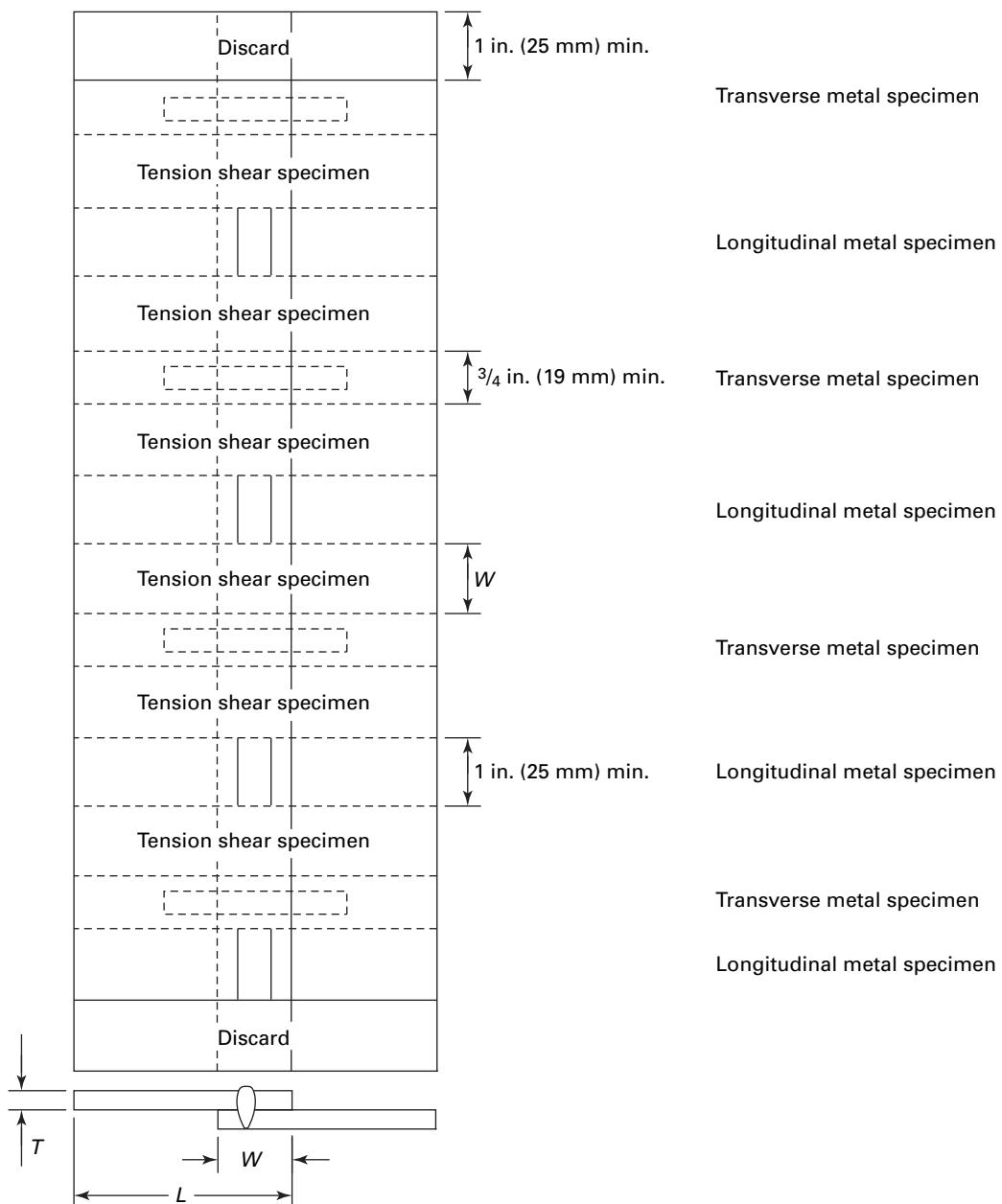


Figure QW-463.2(h)
Performance Qualification



Fracture specimen to be removed from lower 90 deg section in position 5F

Figure QW-464.1
Procedure Qualification Test Coupon and Test Specimens



Thickness of Thinner, Sheet, T , in. (mm)	Specimen Width, W , in. (mm)	Recommended Length, L , in. (mm)
Up to 0.029 (0.74)	5/8 (16)	3 (75)
0.031 to 0.050 (0.79 to 1.2)	3/4 (19)	3 (75)
0.051 to 0.100 (1.3 to 2.54)	1 (25)	4 (100)
0.101 to 0.130 (2.57 to 3.30)	1 1/4 (32)	5 (125)
0.131 to 0.190 (3.33 to 4.83)	1 1/2 (38)	5 (125)
0.191 (4.85) and over	2 (50)	6 (150)

Figure QW-464.2
Performance Qualification Test Coupons and Test Specimens

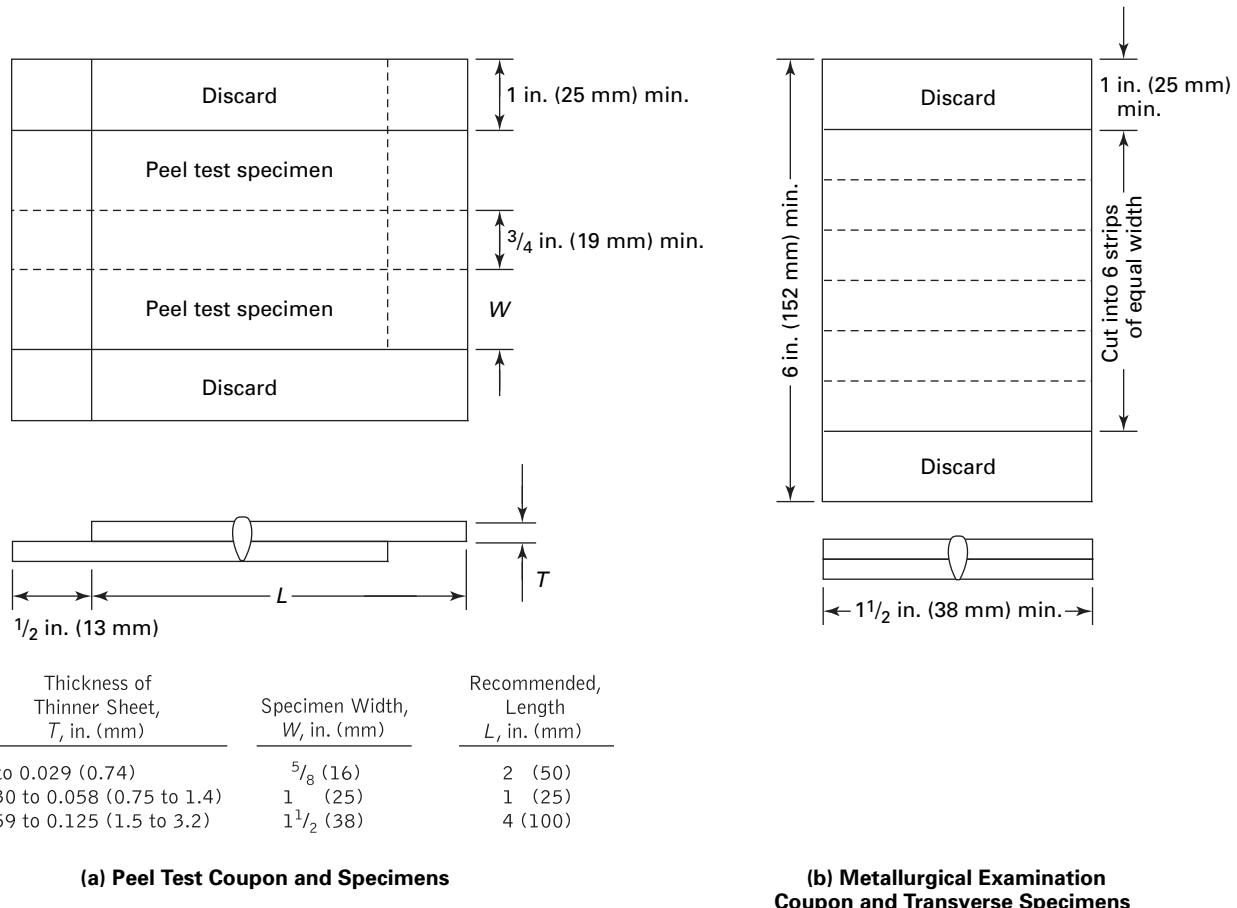
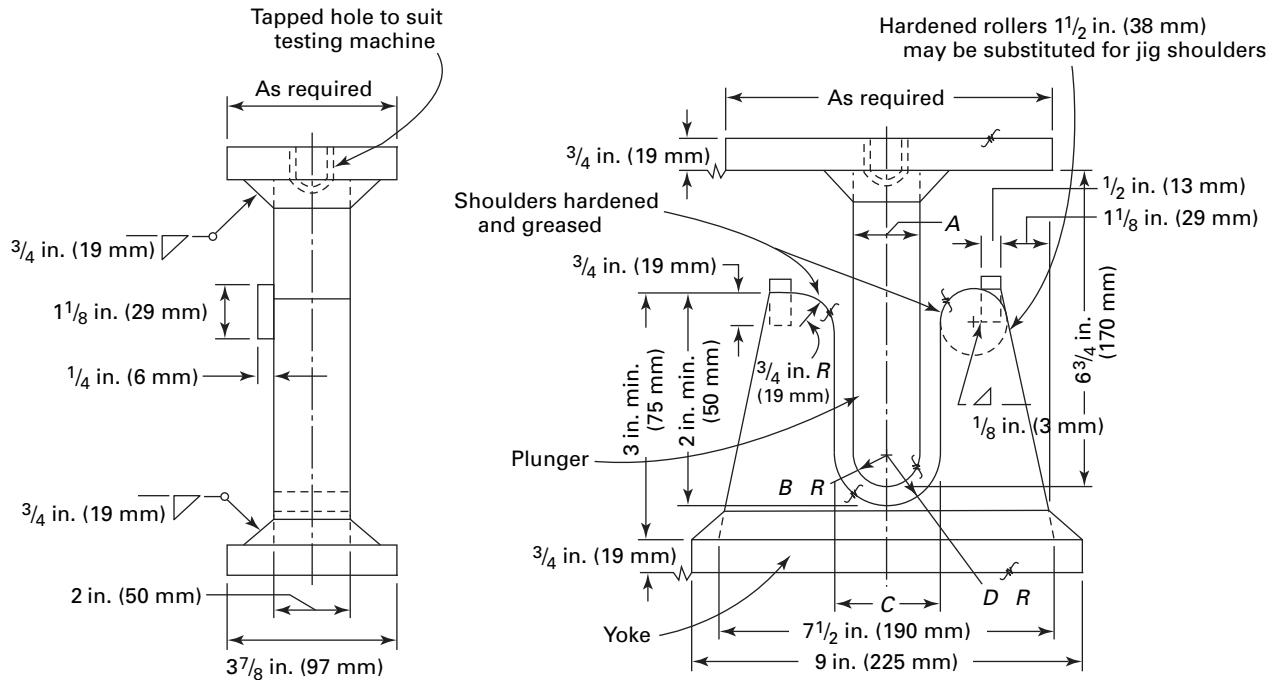


Figure QW-466.1
Test Jig Dimensions



U.S. Customary Units

Material	Thickness of Specimen, t , in.	A , in. Max.	B , in. Max.	C , in.	D , in.
P-No. 23 to P-No. 21 through P-No. 25; P-No. 21 through P-No. 25 with F-No. 23 or 26; P-No. 35; any P-No. metal with F-No. 33, 36, or 37	1/8 Less than 1/8	2 1/16 16 1/2 t	1 1/32 8 1/4 t	2 3/8 max. $A + 2t + \frac{1}{8}$	1 3/16 max. $C/2 + \frac{1}{16}$
P-No. 11A, P-No. 11B; P-No. 25 to P-No. 21 or P-No. 22 or P-No. 25	3/8 Less than 3/8	2 1/2 6 2/3 t	1 1/4 3 1/3 t	3 3/8 max. $A + 2t + \frac{1}{8}$	1 11/16 max. $C/2 + \frac{1}{16}$
P-No. 51; P-No. 49	3/8 Less than 3/8	3 8t	1 1/2 4t	3 7/8 max. $A + 2t + \frac{1}{8}$	1 15/16 max. $C/2 + \frac{1}{16}$
P-No. 52; P-No. 53; P-No. 61; P-No. 62	3/8 Less than 3/8	3 3/4 10t	1 7/8 5t	4 5/8 max. $A + 2t + \frac{1}{8}$	2 5/16 max. $C/2 + \frac{1}{16}$
All others with greater than or equal to 20% elongation	3/8 Less than 3/8	1 1/2 4t	3/4 2t	2 3/8 max. $A + 2t + \frac{1}{8}$	3/16 max. $C/2 + \frac{1}{16}$
All others with 3% to less than 20% elongation	[Note (1)]	32 3/8 t	16 3/16 t	$A + 2t + \frac{1}{8}$	$C/2 + \frac{1}{16}$

Figure QW-466.1
Test Jig Dimensions (Cont'd)

Material	Thickness of Specimen, <i>t</i>, mm	SI Units			
		<i>A</i>, mm Max.	<i>B</i>, mm Max.	<i>C</i>, mm	<i>D</i>, mm
P-No. 23 to P-No. 21 through P-No. 25; P-No. 21 through P-No. 25 with F-No. 23 or 26; P-No. 35; any P-No. metal with F-No. 33, 36, or 37	3 Less than 3	50 $16\frac{1}{2}t$	25 $8\frac{1}{4}t$	57 max. $A + 2t + 3.0$	29 max. $C/2 + 1.5$
P-No. 11A, P-No. 11B; P-No. 25 to P-No. 21 or P-No. 22 or P-No. 25	10 Less than 10	67 $6\frac{2}{3}t$	33 $3\frac{1}{3}t$	90 max. $A + 2t + 3.0$	45 max. $C/2 + 1.5$
P-No. 51; P-No. 49	10 Less than 10	80 $8t$	40 $4t$	103 max. $A + 2t + 3.0$	52 max. $C/2 + 1.5$
P-No. 52; P-No. 53; P-No. 61; P-No. 62	10 Less than 10	100 $10t$	50 $5t$	123 max. $A + 2t + 3.0$	62 max. $C/2 + 1.5$
All others with greater than or equal to 20% elongation	10 Less than 10	40 $4t$	20 $2t$	63 max. $A + 2t + 3.0$	32 max. $C/2 + 1.5$
All others with 3% to less than 20% elongation	[Note (1)]	$32\frac{3}{8}t$	$16\frac{3}{16}t$	$A + 2t + 3.0$	$C/2 + 1.5$

GENERAL NOTES:

- (a) For P-Numbers, see [Table QW/QB-422](#); for F-Numbers, see [Table QW-432](#).
- (b) For guided-bend jig configuration, see [Figures QW-466.2](#), [QW-466.3](#), and [QW-466.4](#).
- (c) The weld and heat-affected zone, in the case of a transverse weld bend specimen, shall be completely within the bend portion of the specimen after testing.
- (d) When the bending properties of the weldment make it unlikely that the requirements of [General Note \(c\)](#) can be met, the wrap around jig shown in [Figure QW-466.3](#) should be considered.

NOTE:

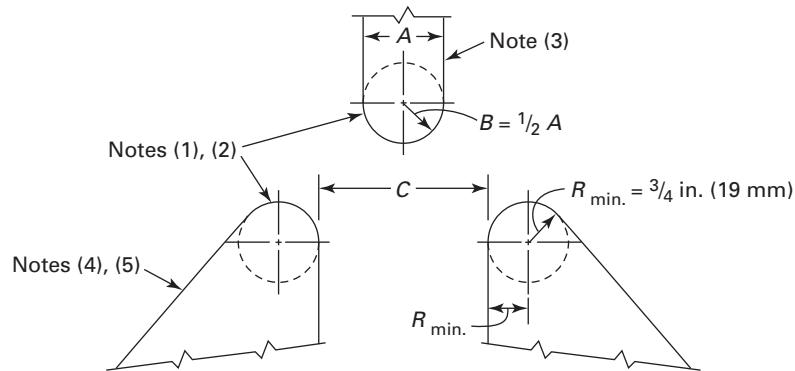
- (1) The dimensions of the test jig shall be such as to give the bend test specimen a calculated percent outer fiber elongation equal to at least that of the base material with the lower minimum elongation as specified in the base material specification.

$$\text{percent outer fiber elongation} = \frac{100t}{A + t}$$

The following equation is provided for convenience in calculating the bend specimen thickness:

$$\text{thickness of specimen, } t = \frac{A \times \text{percent elongation}}{\left[100 - (\text{percent elongation}) \right]}$$

**Figure QW-466.2
Guided-Bend Roller Jig**



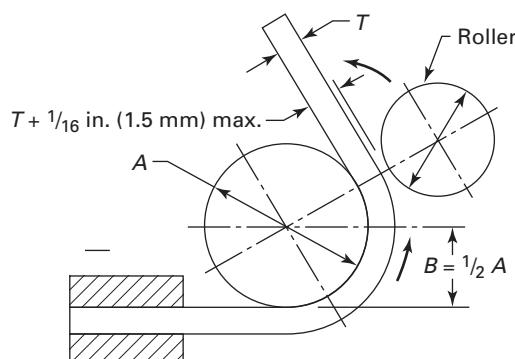
GENERAL NOTES:

- (a) See [Figure QW-466.1](#) for jig dimensions and general notes.
- (b) When the bending properties of the weldment make it unlikely that the requirements of General Note (c) of [Figure QW-466.1](#) can be met, the wrap around jig shown in [Figure QW-466.3](#) should be considered.

NOTES:

- (1) Either hardened and greased shoulders or hardened rollers free to rotate shall be used.
- (2) The shoulders or rollers shall have a minimum bearing surface of 2 in. (50 mm) for placement of the specimen. The rollers shall be high enough above the bottom of the jig so that the specimens will clear the rollers when the ram is in the low position.
- (3) The ram shall be fitted with an appropriate base and provision made for attachment to the testing machine, and shall be of a sufficiently rigid design to prevent deflection and misalignment while making the bend test. The body of the ram may be less than the dimensions shown in column A of [Figure QW-466.1](#).
- (4) If desired, either the rollers or the roller supports may be made adjustable in the horizontal direction so that specimens of t thickness may be tested on the same jig.
- (5) The roller supports shall be fitted with an appropriate base designed to safeguard against deflection and misalignment and equipped with means for maintaining the rollers centered midpoint and aligned with respect to the ram.

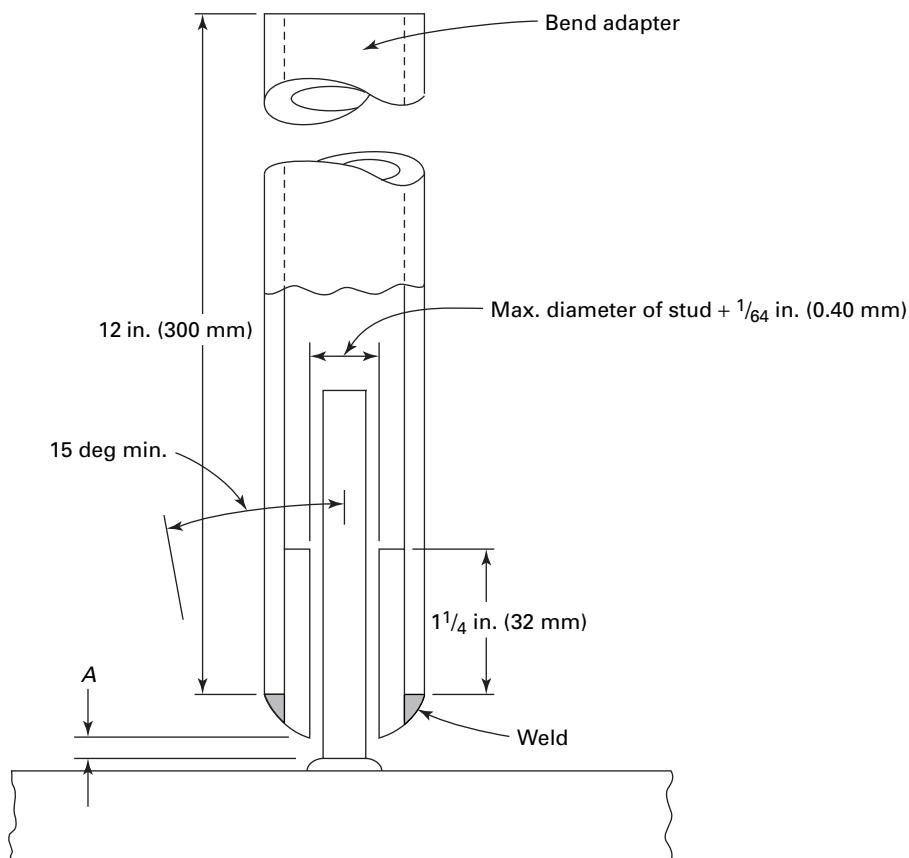
**Figure QW-466.3
Guided-Bend Wrap Around Jig**



GENERAL NOTES:

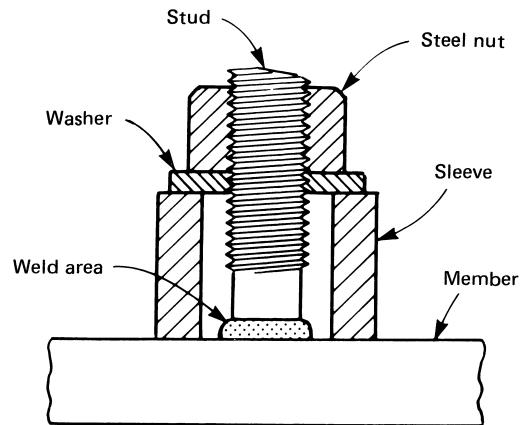
- (a) See [Figure QW-466.1](#) for jig dimensions and other general notes.
- (b) Dimensions not shown are the option of the designer. The essential consideration is to have adequate rigidity so that the jig parts will not spring.
- (c) The specimen shall be firmly clamped on one end so that there is no sliding of the specimen during the bending operation.
- (d) Test specimens shall be removed from the jig when the outer roll has been removed 180 deg from the starting point.

Figure QW-466.4
Stud-Weld Bend Jig



For Stud Diameter, in. (mm)	Use Adapter Gap, A, in. (mm)
1/8 (3)	1/8 (3)
3/16 (5)	1/8 (3)
1/4 (6)	3/16 (5)
3/8 (10)	7/32 (5.5)
1/2 (13)	5/16 (8)
5/8 (16)	11/32 (9)
3/4 (19)	15/32 (12)
7/8 (22)	15/32 (12)
1 (25)	19/32 (15)

Figure QW-466.5
Torque Testing Arrangement for Stud Welds



GENERAL NOTES:

- (a) Dimensions are appropriate to the size of the stud.
- (b) Threads of the stud shall be clean and free of lubricant other than residual cutting oil.

Figure QW-466.6
Suggested Type Tensile Test Figure for Stud Welds

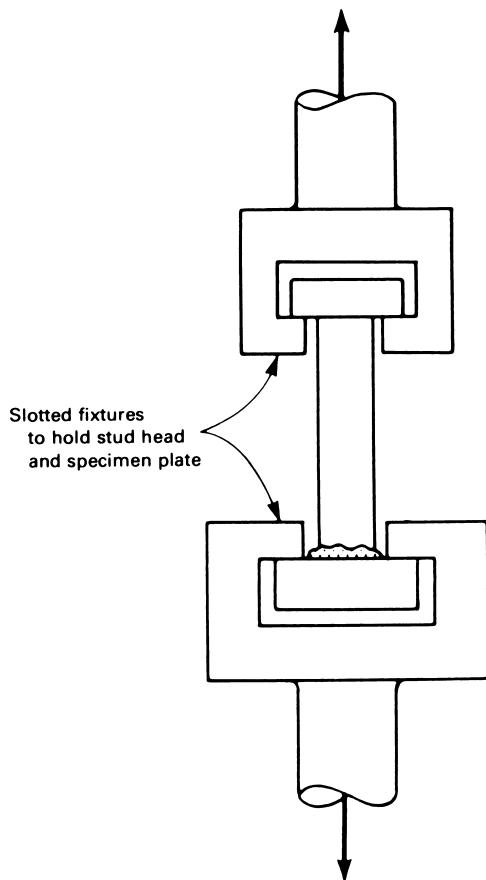


Figure QW-469.1
Butt Joint

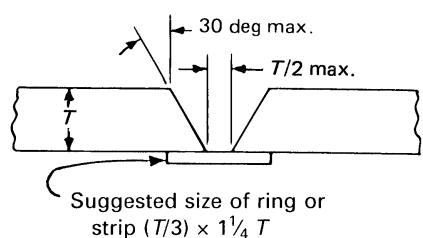
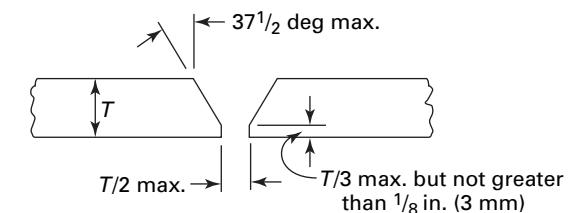


Figure QW-469.2
Alternative Butt Joint



QW-470 ETCHING — PROCESSES AND REAGENTS

QW-471 GENERAL

The surfaces to be etched should be prepared by filing, machining, grinding, or polishing to delineate the macro-features of the specimen's weld and HAZ after etching. With different alloys and tempers, the etching period will vary from a few seconds to several minutes, and should be continued until the desired contrast is obtained. As a protection from the fumes liberated during the etching process, this work should be done under a hood. After etching, the specimens should be thoroughly rinsed and then dried with a blast of warm air. Coating the surface with a thin clear lacquer will preserve the appearance. (Reference ASTM E340, Standard Test Method for Macro-etching Metals and Alloys, or other industry-accepted standards.)

QW-472 FOR FERROUS METALS

Etching solutions suitable for carbon and low alloy steels, together with directions for their use, are suggested in QW-472.1 through QW-472.4.

QW-472.1 Hydrochloric Acid. Hydrochloric (muriatic) acid and water, equal parts, by volume. The solution should be kept at or near the boiling temperature during the etching process. The specimens are to be immersed in the solution for a sufficient period of time to reveal all lack of soundness that might exist at their cross-sectional surfaces.

QW-472.2 Ammonium Persulfate. One part of ammonium persulfate to nine parts of water, by weight. The solution should be used at room temperature, and should be applied by vigorously rubbing the surface to be etched with a piece of cotton saturated with the solution. The etching process should be continued until there is a clear definition of the structure in the weld.

QW-472.3 Iodine and Potassium Iodide. One part of powdered iodine (solid form), two parts of powdered potassium iodide, and ten parts of water, all by weight. The solution should be used at room temperature, and brushed on the surface to be etched until there is a clear definition or outline of the weld.

QW-472.4 Nitric Acid. One part of nitric acid and three parts of water, by volume.

CAUTION: Always pour the acid into the water. Nitric acid causes bad stains and severe burns.

The solution may be used at room temperature and applied to the surface to be etched with a glass stirring rod. The specimens may also be placed in a boiling solution of the acid, but the work should be done in a well-ventilated room. The etching process should be continued for a sufficient period of time to reveal all lack of soundness that might exist at the cross-sectional surfaces of the weld.

QW-473 FOR NONFERROUS METALS

The following etching reagents and directions for their use are suggested for revealing the macrostructure.

QW-473.1 Aluminum and Aluminum-Base Alloys.

Solution	Volume
Hydrochloric acid (concentrated)	15 ml
Hydrofluoric acid (48%)	10 ml
Water	85 ml

This solution is to be used at room temperature, and etching is accomplished by either swabbing or immersing the specimen.

QW-473.2 For Copper and Copper-Base Alloys: Cold Concentrated Nitric Acid. Etching is accomplished by either flooding or immersing the specimen for several seconds under a hood. After rinsing with a flood of water, the process is repeated with a 50-50 solution of concentrated nitric acid and water.

In the case of the silicon bronze alloys, it may be necessary to swab the surface to remove a white (SiO_2) deposit.

QW-473.3 For Nickel and Nickel-Base Alloys.

Material	Formula
Nickel	Nitric Acid or Lepito's Etch
Low Carbon Nickel	Nitric Acid or Lepito's Etch
Nickel-Copper (400)	Nitric Acid or Lepito's Etch
Nickel-Chromium-Iron (600 and 800)	Aqua Regia or Lepito's Etch

**Table QW-473.3-1
Makeup of Equations for Aqua Regia and Lepito's Etch**

Solution	Aqua Regia [Note (1)], [Note (2)]	Lepito's Etch [Note (2)], [Note (3)]
Nitric Acid, Concentrated — HNO_3	1 part	3 ml
Hydrochloric Acid, Concentrated — HCl	2 parts	10 ml
Ammonium Sulfate — $(\text{NH}_4)_2(\text{SO}_4)$...	1.5 g
Ferric Chloride — FeCl_3	...	2.5 g
Water	...	7.5 ml

NOTES:

- (1) Warm the parts for faster action.
- (2) Etching is accomplished by either swabbing or immersing the specimen.
- (3) Mix solution as follows:
 - (a) Dissolve $(\text{NH}_4)_2(\text{SO}_4)$ in H_2O .
 - (b) Dissolve powdered FeCl_3 in warm HCl.
 - (c) Mix (a) and (b) above and add HNO_3 .

QW-473.4 For Titanium.

Solution	Kroll's Etch	Keller's Etch
Hydrofluoric acid (48%)	1 to 3 ml	$\frac{1}{2}$ ml
Nitric acid (concentrated)	2 to 6 ml	$2\frac{1}{2}$ ml
Hydrochloric Acid (concentrated)	...	$1\frac{1}{2}$ ml
Water	To make 100 ml	To make 100 ml

Apply by swab and rinse in cold water.

These are general purpose etchants which are applied at room temperature by swabbing or immersion of the specimen.

QW-473.5 For Zirconium.

Solution	Volume
Hydrofluoric acid	3 ml
Nitric acid (concentrated)	22 ml
Water	22 ml

ARTICLE V

STANDARD WELDING PROCEDURE SPECIFICATIONS (SWPSS)

(21) QW-500 GENERAL

The SWPSSs listed in [Mandatory Appendix E](#) may be used when the requirements of the ASME Boiler and Pressure Vessel Code, Section IX are specified.

Organizations adopting new SWPSSs shall adopt the SWPS edition listed in the current edition of Section IX [see [QG-100\(d\)](#)].

Earlier editions of SWPSSs, listed in the 1998 Edition of Section IX or later, that have been adopted and properly demonstrated as required herein remain valid.

Listed SWPSSs that have been reaffirmed as indicated by "(Rxx)" or "(Rxxx)" or amended as indicated by "AMDy" remain valid.

SWPSSs are not permitted for construction where toughness testing of the WPS is required by the Construction Code.

QW-510 ADOPTION OF SWPSS

Prior to use, the organization that will be responsible for and provide operational control over production welding shall comply with the following for each SWPS that it intends to use, except as noted in [QW-520](#).

(a) Enter the name of the organization on the SWPS.

(b) An employee of that organization shall sign and date the SWPS.

(c) The applicable Code Section(s) (Section VIII, B31.1, etc.) and/or any other fabrication document (contract, specification, etc.) that must be followed during welding shall be listed on the SWPS.

(d) The organization shall weld and test one groove weld test coupon following that SWPS. The following information shall be recorded:

(1) the specification, type, and grade of the base metal welded

(2) groove design

(3) initial cleaning method

(4) presence or absence of backing

(5) The ASME or AWS specification and AWS classification of electrode or filler metal used and manufacturer's trade name

(6) size and classification of tungsten electrode for GTAW

(7) size of consumable electrode or filler metal

(8) shielding gas and flow rate for GTAW and GMAW

(9) preheat temperature

(10) position of the groove weld and, if applicable, the progression

(11) if more than one process or electrode type is used, the approximate weld metal deposit thickness for each process or electrode type

(12) maximum interpass temperature

(13) post weld heat treatment used, including holding time and temperature range

(14) visual inspection and mechanical testing results

(15) the results of volumetric examination when permitted as an alternative to mechanical testing by [QW-304](#)

(e) The coupon shall be visually examined in accordance with [QW-302.4](#) and mechanically tested in accordance with [QW-302.1](#) or volumetrically examined in accordance with [QW-302.2](#). If visual examination, volumetric examination, or any test specimen fails to meet the required acceptance criteria, the test coupon shall be considered as failed and a new test coupon shall be welded before the organization may use the SWPS.

QW-511 USE OF DEMONSTRATED SWPSS

Code Sections or fabrication documents that are required to be referenced by [QW-510\(c\)](#) may be added or deleted from a demonstrated SWPS without further demonstrations.

QW-520 USE OF SWPSS WITHOUT DISCRETE DEMONSTRATION

Once an SWPS has been demonstrated, additional SWPSSs that are similar to the SWPS that was demonstrated may be used without further demonstration. Such additional SWPSSs shall be compared to the SWPS that was used for the demonstration, and the following limitations shall not be exceeded:

(a) a change in the welding process.

(b) a change in the P-Number.

(c) a change from the as-welded condition to the heat-treated condition. This limitation also applies for SWPSSs that allow use in both conditions (e.g., SWPS B2.1-021 allows production welding with or without heat treatment; if the demonstration was performed without heat treatment, production welding with heat treatment is not permitted). Once heat treatment has been demonstrated for any SWPS, this limitation no longer applies.

(d) a change from a gas-shielded flux-cored wire or solid wire to a self-shielded flux-cored wire or vice versa.

(e) a change from globular, spray or pulsed spray transfer welding to short-circuiting transfer welding or vice versa.

(f) a change in the F-Number of the welding electrode.

(g) the addition of preheat above ambient temperature.

(h) a change from an SWPS that is identified as for sheet metal to one that is not and vice versa.

QW-530 FORMS

A suggested [Form QW-485](#) for documenting the welding variables and test results of the demonstration is provided in [Nonmandatory Appendix B](#).

QW-540 PRODUCTION USE OF SWPSs

As with any WPS, welding that is done following an SWPS shall be done in strict accordance with the SWPS. In addition, the following requirements apply to the use of SWPSs:

(a) The organization may not deviate from the welding conditions specified on the SWPS.

(b) SWPSs may not be supplemented with PQRs or revised in any manner except for reference to the applicable Code Section or other fabrication documents as provided by [QW-511](#).

(c) Only the welding processes shown on an SWPS shall be used in given production joint. When a multi-process SWPS is selected, the processes shown on the SWPS shall be used in the order and manner specified on the SWPS.

(d) SWPSs shall not be used in the same production joint together with WPSs qualified by the organization.

(e) The organization may supplement an SWPS by attaching additional instructions to provide the welder with further direction for making production welds to Code or other requirements. When SWPSs are supplemented with instructions that address any condition shown on the SWPS, such instructions shall be within the limits of the SWPS. For example, when an SWPS permits use of several electrode sizes, supplemental instructions may direct the welder to use only one electrode size out of those permitted by the SWPS; however, the supplemental instructions may not permit the welder to use a size other than one or more of those permitted by the SWPS.

(f) SWPSs may not be used until the demonstration of [QW-510](#) has been satisfactorily welded, tested, and certified.

(g) The identification number of the Supporting Demonstration shall be noted on each SWPS that it supports prior to using the SWPS.

(h) The certified Supporting Demonstration Record shall be available for review.