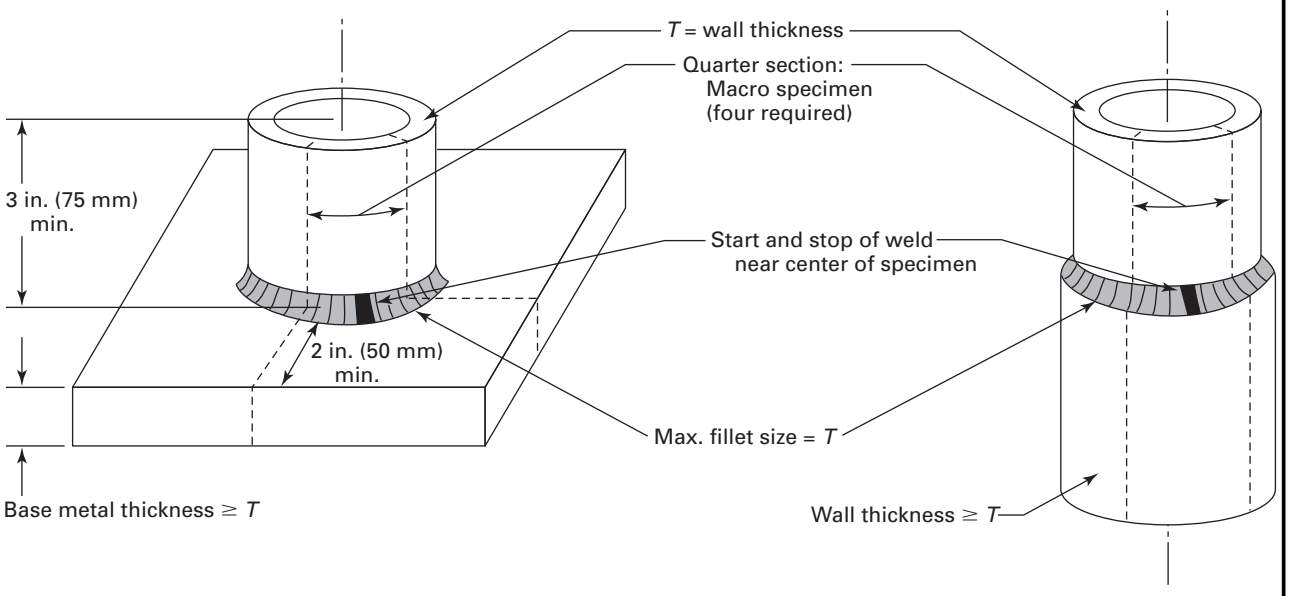
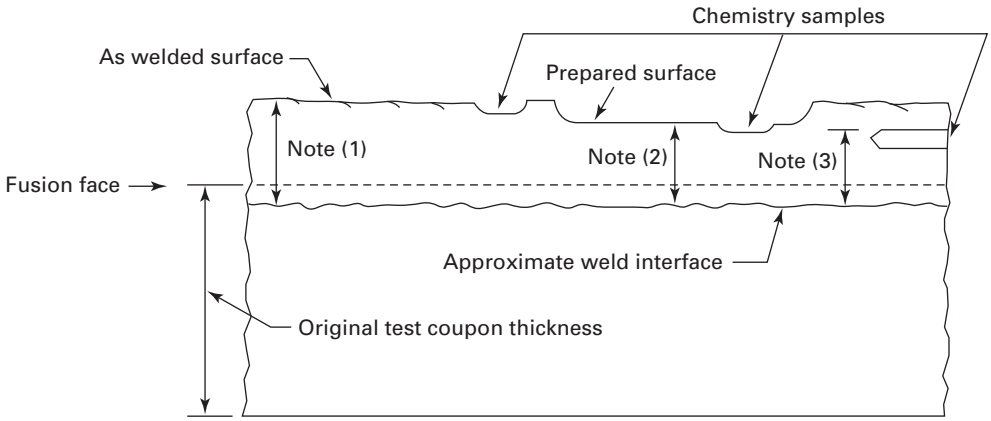
Figure QW-462.4(d)
Fillet Welds in Pipe — Procedure



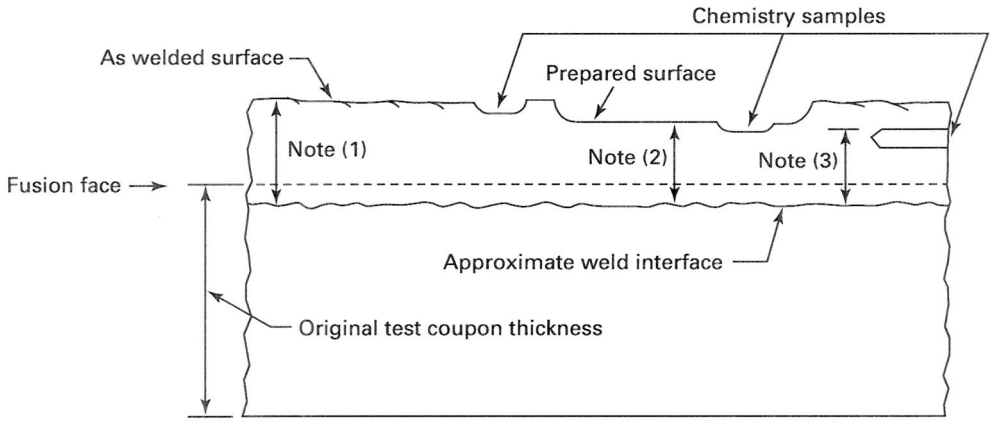
GENERAL NOTES:
(a) Either pipe-to-plate or pipe-to-pipe may be used as shown.
(b) Macro test:
(1) The fillet shall show fusion at the root of the weld but not necessarily beyond the root.
(2) The weld metal and the heat-affected zone shall be free of cracks.

Figure QW-462.5(a)
Chemical Analysis and Hardness Specimen Corrosion-Resistant and Hard-Facing Weld Metal Overlay



Add "Notes:" as shown on next page

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.