1 / 12 · Qualification

A WPS meets Clause 5 in full. What does that exempt the contractor from?

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2 / 12 · Qualification

Name the things a prequalified WPS still needs.

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3 / 12 · Qualification

Which items must all conform to Clause 5 for a WPS to be prequalified?

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4 / 12 · Qualification

One variable on a WPS falls outside Clause 5. What are the contractor's two options?

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5 / 12 · Qualification

What is the classic process mode that can't be prequalified, and why?

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6 / 12 · Qualification

In a prequalified groove joint label, what do the first letters tell you?

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1 / 12 · Qualification

Only the procedure test weld under Clause 6 Part B, so no PQR is needed. Nothing else is waived.

AWS D1.1/D1.1M:2025 Clause 5, prequalification; Clause 6 Part B

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2 / 12 · Qualification

A written WPS, welders qualified under Clause 6 Part C, and full compliance with Clauses 7 and 8. CVN testing under Clause 6 Part D too if the contract calls for it.

AWS D1.1/D1.1M:2025 Clause 5; Clause 6 Parts C and D; Clauses 7 and 8

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3 / 12 · Qualification

Process, base metal, filler metal match, joint detail with its tolerances, preheat and interpass, process variables, and position. One miss and it is not prequalified.

AWS D1.1/D1.1M:2025 Clause 5, prequalification of WPSs

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4 / 12 · Qualification

Change the WPS so it conforms to Clause 5, or qualify it by test under Clause 6 Part B.

AWS D1.1/D1.1M:2025 Clause 5; Clause 6 Part B, WPS qualification

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5 / 12 · Qualification

Short-circuit transfer GMAW. It is prone to incomplete fusion, so a WPS using it must be qualified by test.

AWS D1.1/D1.1M:2025 Clause 5, prequalified processes

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6 / 12 · Qualification

The joint type: B butt, C corner, T tee, or a combination such as BC or TC.

AWS D1.1/D1.1M:2025 Clause 5, prequalified joint designations

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7 / 12 · Qualification

In a prequalified joint label, what do L, U and P mean?

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8 / 12 · Qualification

On a prequalified joint label, what does a lowercase letter right after the detail number mean?

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9 / 12 · Qualification

The parts are tacked and you have a gauge in hand. Which tolerance column of the joint detail figure do you read?

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10 / 12 · Qualification

Why read the notes under a prequalified joint detail figure?

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11 / 12 · Qualification

How do you read the prequalified minimum preheat and interpass table?

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12 / 12 · Qualification

Two steels with different preheat requirements are joined. Which preheat applies?

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8 / 12 · Qualification

It marks a variant of that same numbered detail, such as a different groove shape or backing. Don't confuse it with the process letters at the end of the label; the detail's table shows which processes it covers.

AWS D1.1/D1.1M:2025 Clause 5, prequalified joint designations

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7 / 12 · Qualification

L is limited thickness, U is unlimited thickness and P is partial joint penetration. So the label alone tells you CJP or PJP.

AWS D1.1/D1.1M:2025 Clause 5, prequalified joint designations

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10 / 12 · Qualification

They add conditions the sketch doesn't show, such as back gouging or backing.

AWS D1.1/D1.1M:2025 Clause 5, prequalified joint detail figures and notes

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9 / 12 · Qualification

As fit-up. The as detailed column is for reviewing the drawing or WPS. The two can allow different tolerances.

AWS D1.1/D1.1M:2025 Clause 5, prequalified joint detail figures

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12 / 12 · Qualification

The more demanding one. The table gives a minimum, so a WPS may call for more but never less.

AWS D1.1/D1.1M:2025 Clause 5, prequalified minimum preheat and interpass table

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11 / 12 · Qualification

Find the steel's category, then the row for the thickest part at the point of welding, then read the minimum temperature. Check the notes.

AWS D1.1/D1.1M:2025 Clause 5, prequalified minimum preheat and interpass table

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