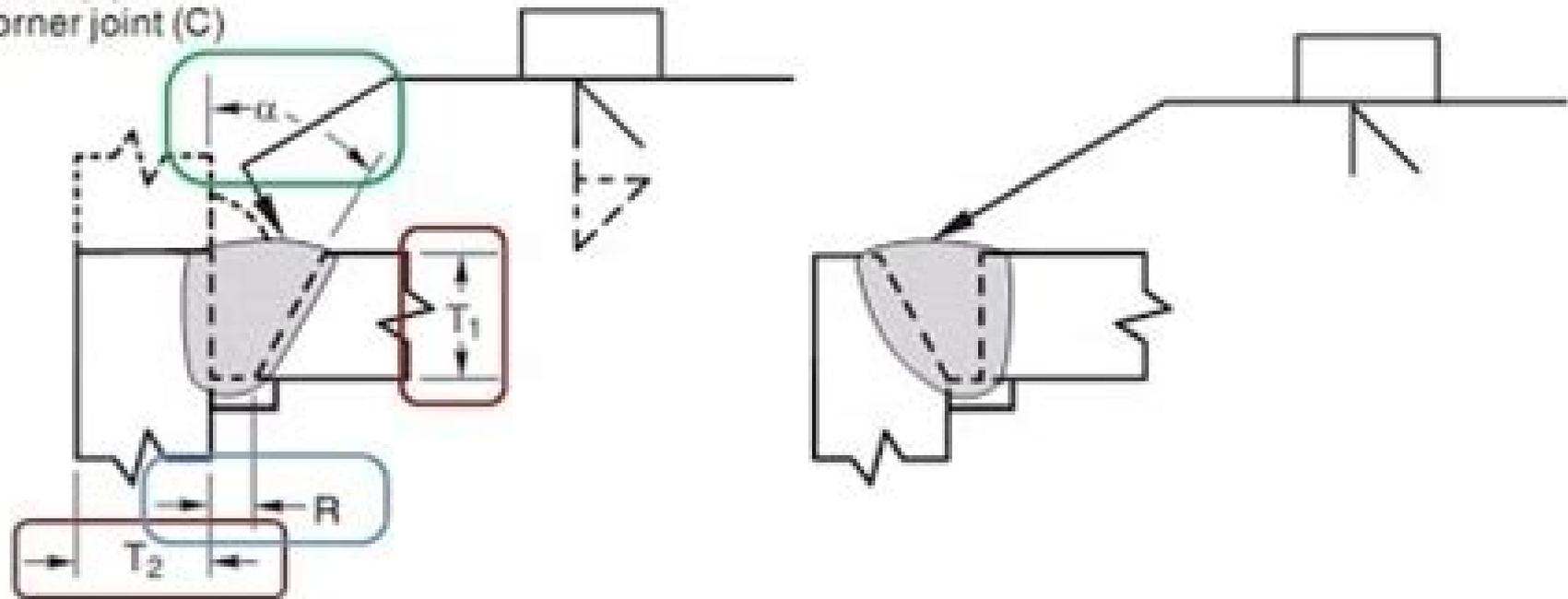


AWS D1.1:2010 Structural Welding Code--Steel

Single-bevel-groove weld (4)

T-joint (T)

Corner joint (C)



| Welding Process | Joint Designation | Base Metal Thickness (U = unlimited) | | Groove Preparation | |
|-----------------|-------------------|--------------------------------------|-------|--------------------|---------------------|
| | | T_1 | T_2 | Root Opening | Groove Angle |
| SMAW | TC-U4a | U | U | $R = 1/4$ | $\alpha = 45^\circ$ |
| | | | | $R = 3/8$ | $\alpha = 30^\circ$ |
| GMAW FCAW | TC-U4a-GF | U | U | $R = 3/16$ | $\alpha = 30^\circ$ |
| | | | | $R = 3/8$ | $\alpha = 30^\circ$ |
| | | | | $R = 1/4$ | $\alpha = 45^\circ$ |

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Jicheng Xie



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