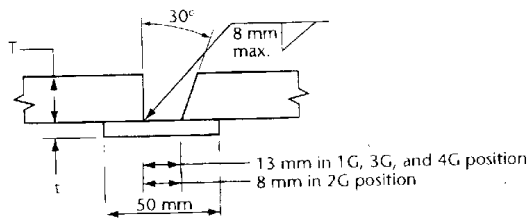
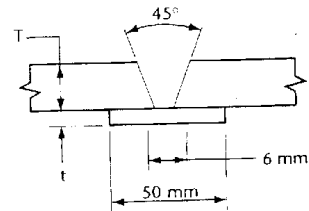


*Use techniques adopted by the company.

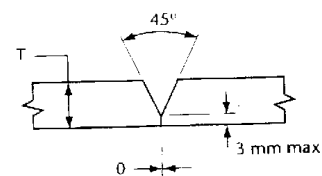
2 plates 150 mm x 75 mm min



Option 1 (GF)



Option 2 (G)



Option 3 (G)

Notes:

- (1) For Option 1 for 1G, 3G, and 4G positions, the fillet weld shall be 8 mm max and shall be visually inspected for leg size, undercut, and profile.
- (2) Options 2 and 3 also require the welder or welding operator to qualify for a fillet weld (see Figure 6 and Table 2).
- (3) T = 10 mm except T = 6 mm for GTAW process and GMAW process short circuiting.
- (4) t = 5 to 8 mm; 6 mm is recommended.

Figure 8
Plate Test Assembly for S Classification for
SMAW, GMAW, and GTAW Processes

(See Clauses 8.5.1, 9.4.1.1, 9.4.3.3, 9.4.3.4, 9.9.8, 9.11.2, 9.14.2.1.1, 9.14.2.2, and 9.14.2.3.1, Tables 2 and 7, and Figure 2 and 6.)