



American Welding Society

2015 AWS D1.1/D1.1M Summary of Changes in the 2015 Edition



In addition to editorial changes to the text and commentary to improve clarity and understanding of the provisions of the code, the following have been undertaken in the D1.1:2015 edition...

General:

- All tubular provisions, tables, and figures moved to a new "Tubular Structures" Clause and corresponding new section of commentary
- Incorporation of AWS A5.36, *Specification for Carbon and Low-Alloy Steel Flux Cored Electrodes for Flux Cored Arc Welding and Metal Cored Electrodes for Gas Metal Arc Welding*
- Steels not recommended for PWHT: added ASTM A709 Grade HPS 100W [HPS 690W] and deleted ASTM A709 100 (690) and 100W (690W)

Design:

- Clarification regarding calculation of effective throat of a combination PJP flare bevel groove weld and fillet weld
- Additional provisions for wrapping welds on opposite sides of a common plane to permit seal welding
- Fatigue curve cases and figures revised to align with AISC 360

Qualification and prequalification:

- Clarification of conditions for backing other than steel in prequalified WPSs
- Reorganization and update of tables for prequalified base metals and filler metals and alignment with table for prequalified preheat and interpass temperature
- New figure for prequalified fillet weld joint details
- New figure for prequalified CJP groove, T-, and corner joints
- Clarification of CVN Test requirements for sub-sized specimens

Fabrication:

- Clarification of baking requirements for low-hydrogen electrodes for ASTM A514 and A517 steels
- Clarification of preheat and interpass temperature requirements for combinations of base metals
- Updated requirements for backing and for substrate cleanliness
- Clarification of provisions for oxygen gouging
- Clarification when locations of the depth of the web from tension flanges of beams or girders are considered outside the tension zone for tack welds and construction aid welds
- Revisions to the location and sequence of member and element splices
- Clarification of weld profile requirements

Inspection:

- Clarification regarding retesting based on quality of work
- New table for qualification and calibrations requirements of U/T equipment
- Clarification regarding calibration for sensitivity and horizontal sweep of U/T equipment

Annexes:

- New figures to clarify effective throat for various joint types and combinations
- Terms and definitions are now normative
- Sample welding forms extensively revised
- Safe practices has been deleted Clause 1 includes references for safety

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Americas: +1 800 854 7179 | EMEA: +44 1344 328040 | APAC: +852 2368 5733

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