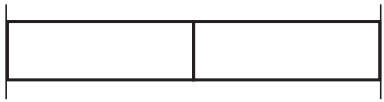
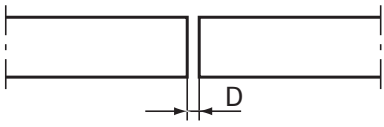
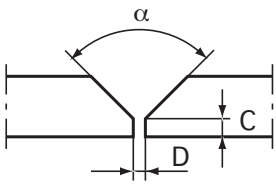
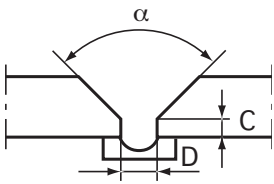
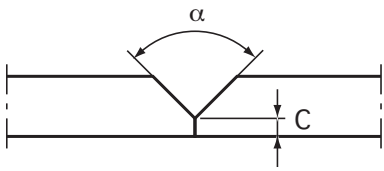
Joint preparations Table 7.1

No. and joint type		Sides	Method	Thickness
1. I-joint No root gap[1)]		One side	TIG	< 2.5 mm
2. I-joint No root gap[2)]		Two sides	SAW	6 – 9 mm
3. I-joint		One side	PAW	1 – 8 mm
4. I-joint D = 1.0 – 2.0 mm		One side	MMA MIG TIG	< 2.5 mm
5. I-joint D = 2.0 – 2.5 mm		Two sides	MMA MIG TIG FCW	< 4 mm
6. V-joint α = 60°[3)] C = 0.5 – 1.5 mm D = 2.0 – 4.0 mm		One side	MMA MIG TIG FCW	4 – 16 mm
7. V-joint α = 60°[3)] C = 2.0 – 2.5 mm D = 2.5 – 3.5 mm		Two sides	MMA MIG TIG FCW	4 – 16 mm
8. V-joint α = 60°[3)] C = 1.5 – 2.5 mm D = 4.0 – 6.0 mm		One side against backing	FCW	4 – 20 mm
9. V-joint α = 80 – 90° C = 1.5 mm No root gap[1)]		Two sides	TIG+ SAW	3 – 16 mm
10. V-joint α = 80 – 90° C = 3.0 – 6.0 mm[4)] No root gap		Two sides	SAW	8 – 16 mm
11. V-joint α = 80 – 90° C = 3.0 – 4.0 mm No root gap		Two sides	PAW+ SAW	6 – 16 mm

[1)] There must be a root gap when welding special grades.
[2)] A ground groove, 1 – 2 mm deep and wide.
[3)] The joint angle for special grades is 60 – 70°.
[4)] A root land of 5 mm and above may require the torch to be angled towards the direction of travel, see "Width and depth" in chapter 4.