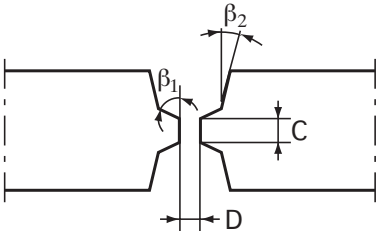
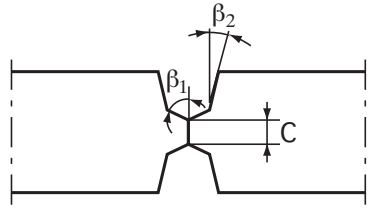
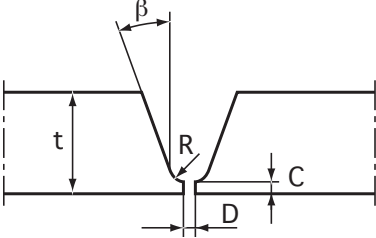
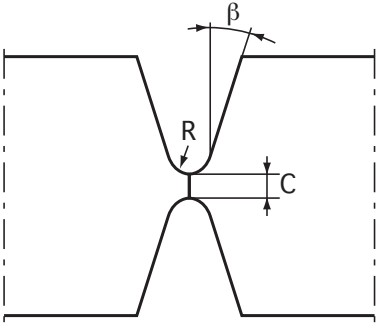


Joint preparations

Table 7.1

No. and joint type		Sides	Method	Thickness
17. X-joint $\beta_1 = 45^\circ$ $\beta_2 = 15^\circ$ $C = 1.5 - 2.5 \text{ mm}$ $D = 2.5 - 3.0 \text{ mm}$		Two sides	MMA MIG TIG <sup>6)</sup> FCW	14 – 30 mm <sup>8)</sup>
18. X-joint $\beta_1 = 45^\circ$ $\beta_2 = 15^\circ$ $C = 3.0 - 8.0 \text{ mm}^{4)}$ No root gap		Two sides	SAW <sup>9)</sup>	14 – 30 mm
19. U-joint $\beta = 10^\circ$ $R = 8.0 \text{ mm}$ $C = 2.0 - 2.5 \text{ mm}$ $D = 2.0 - 2.5 \text{ mm}$		Two sides	MMA MIG TIG <sup>6)</sup> FCW SAW <sup>10)</sup>	< 50 mm
20. Double U-joint $\beta = 15^\circ$ $R = 8.0 \text{ mm}$ $C = 4.0 - 8.0 \text{ mm}^{4)}$		Two sides	SAW <sup>9)</sup>	> 20 mm

<sup>4)</sup> 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.

<sup>6)</sup> Normally only for the first 1 – 3 runs. Followed by MIG, FCW, MMA or SAW.

<sup>8)</sup> A thickness above 20 mm can be prepared as an asymmetrical X-joint.

<sup>9)</sup> TIG or MMA can be used for root runs. Grinding from the back.  $C = 3.0 \text{ mm}$ .

<sup>10)</sup> SAW can be used for fill and cap passes.