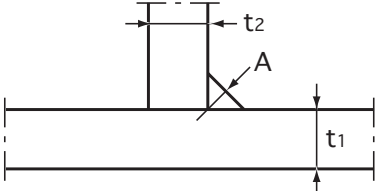
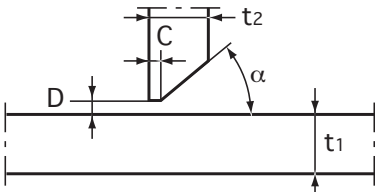
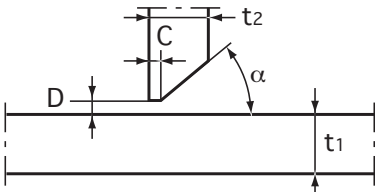
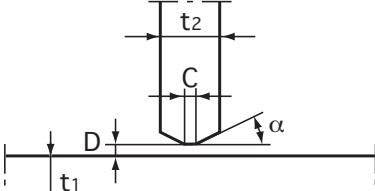
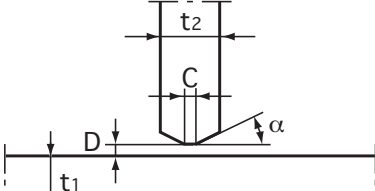
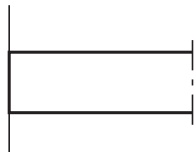
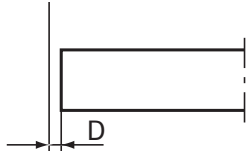


Joint preparations

Table 7.1

No. and joint type		Sides	Method	Thickness
21. Fillet weld No root gap $A \approx 0.7 \times t$		One or two sides	MMA MIG TIG FCW	> 2 mm
22. Half V-joint $\alpha = 50^\circ$ $C = 1.0 - 2.0 \text{ mm}$ $D = 2.0 - 4.0 \text{ mm}$		One side	MMA MIG TIG ⁶⁾ FCW	4 - 16 mm
23. Half V-joint $\alpha = 50^\circ$ $C = 1.5 - 2.5 \text{ mm}$ $D = 2.0 - 3.0 \text{ mm}$		Two sides	MMA MIG TIG ⁶⁾ FCW	4 - 16 mm
24. Half X-joint $\alpha = 50^\circ$ $C = 1.0 - 1.5 \text{ mm}$ $D = 2.0 - 4.0 \text{ mm}$		One side	MMA MIG TIG ⁶⁾ FCW ⁵⁾	14 - 30 mm
25. Half X-joint $\alpha = 50^\circ$ $C = 1.5 - 2.5 \text{ mm}$ $D = 2.0 - 3.0 \text{ mm}$		Two sides	MMA MIG TIG ⁶⁾ FCW	14 - 30 mm
26. Fillet weld No root gap		Two sides	MMA MIG TIG FCW	< 2 mm
27. Fillet weld $D = 2.0 - 2.5 \text{ mm}$		Two sides	MMA MIG TIG FCW	2 - 4 mm

⁵⁾ Welding performed against ceramic backing (round type).

⁶⁾ Normally only for the first 1 - 3 runs. Followed by MIG, FCW, MMA or SAW.