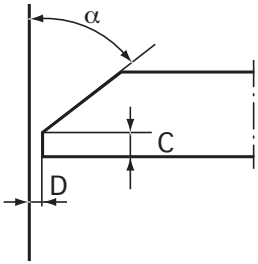
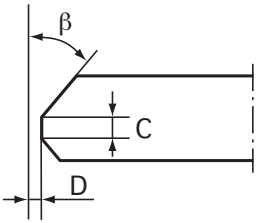
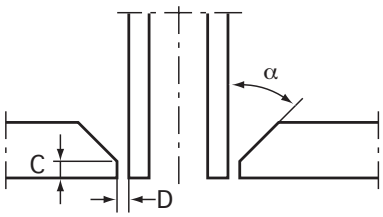
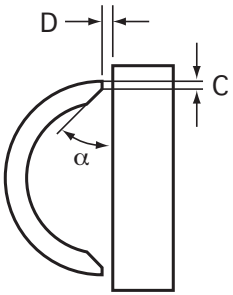
Joint preparations Table 7.1

No. and joint type		Sides	Method	Thickness
28. Half V-joint α = 50° C = 1.5 – 2.5 mm D = 2.0 – 4.0 mm		One side	MMA MIG TIG[6] FCW[5]	4 – 12 mm
29. Half V-joint α = 50° C = 1.5 – 2.5 mm D = 1.5 – 2.5 mm		Two sides	MMA MIG TIG[6] FCW	4 – 16 mm
30. K-joint β = 50° C = 2.0 – 2.5 mm D = 2.0 – 4.0 mm		Two sides	MMA MIG TIG[6] FCW	14 – 30 mm[8]
31. Half V-joint [7] α = 50° C = 1.0 – 2.0 mm D = 2.0 – 3.0 mm		Two sides	MMA MIG TIG[6] FCW	4 – 16 mm
32. Half pipe α = 45° C = 1.5 – 2.0 mm D = 1.0 – 2.0 mm		One side	MMA MIG TIG FCW	4 – 16 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.
[7] For openings such as manways, viewports and nozzles.
[8] A thickness above 20 mm can be prepared as an asymmetrical X-joint.