

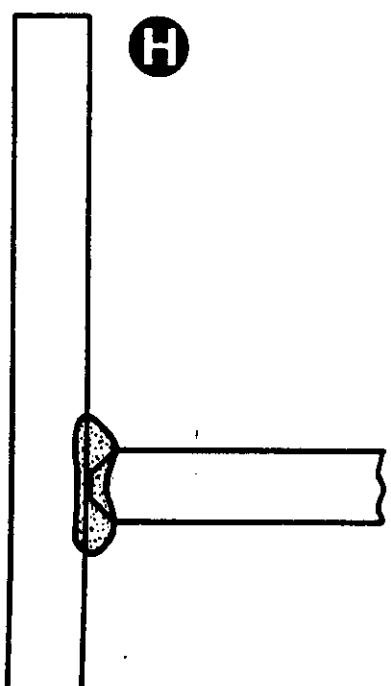
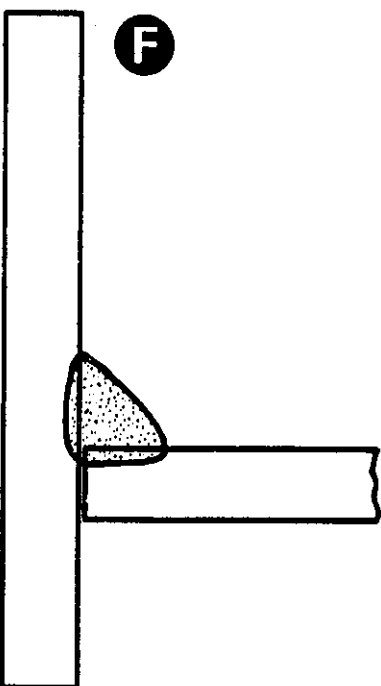
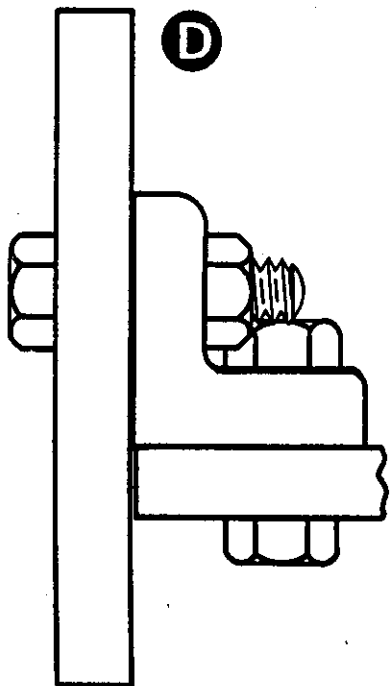
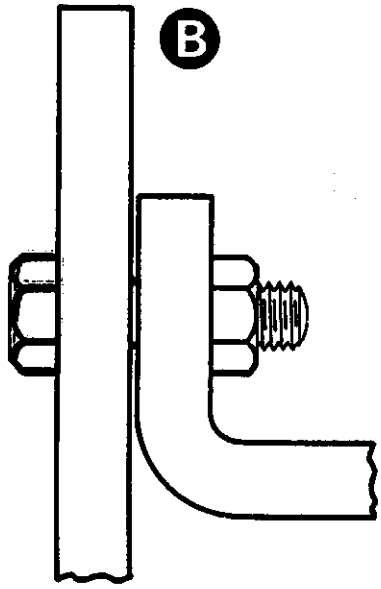
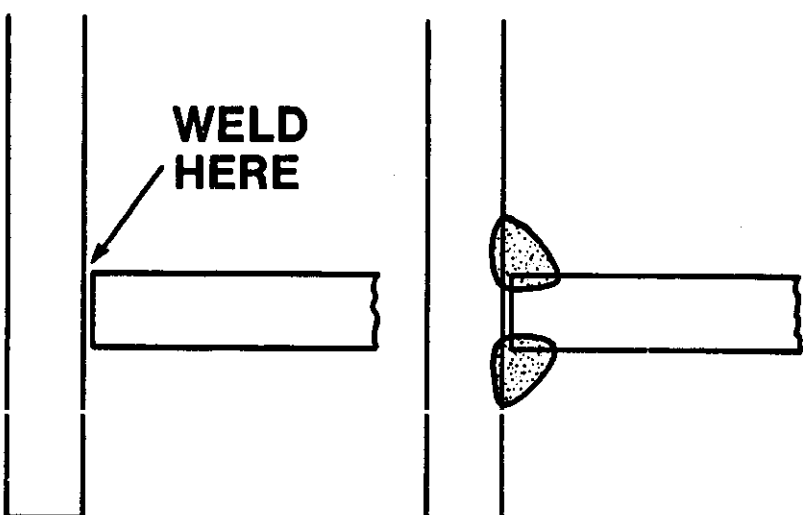
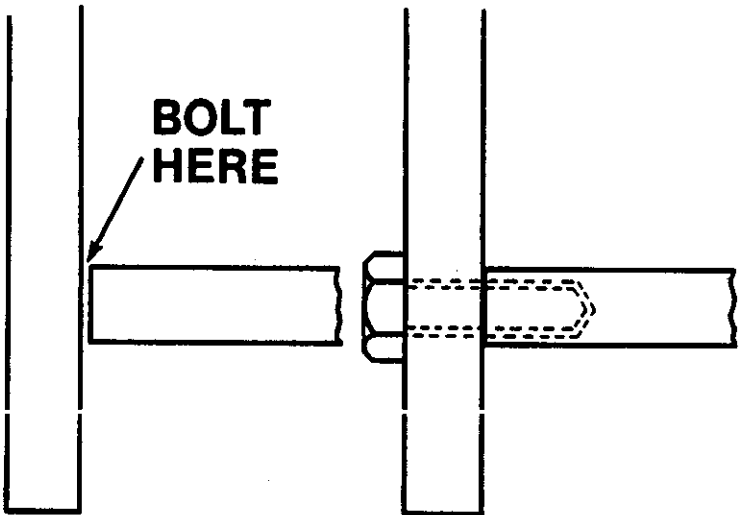
WELD SYMBOLS ON DRAWINGS

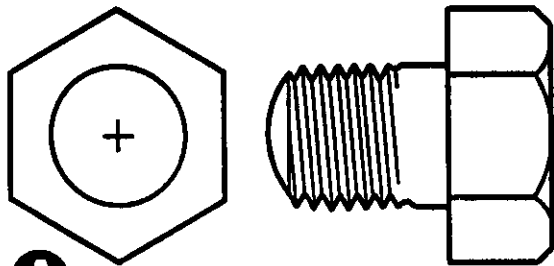
Lecture 16

Section

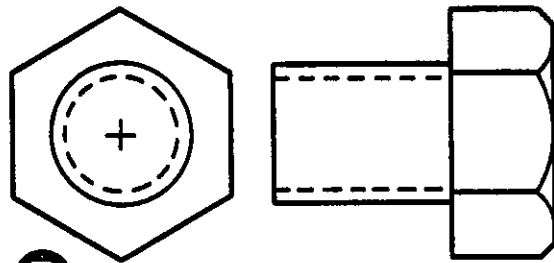
SET D

1. THE NEED TO SPECIFY WELDS
2. THE ADVANTAGES OF SYMBOLS
3. WELD SYMBOLS 1, BUTT/GROOVE WELDS
4. WELD SYMBOLS 2, BACKING/SEALING RUN, FILLET, PLUG, SPOT AND SEAM WELDS
5. WELD SYMBOLS 3, ANSI/AWS SPECIALS
6. LOCATION OF SYMBOLS 1, BUTT WELDS
7. LOCATION OF SYMBOLS 2, BUTT WELDS
8. LOCATION OF SYMBOLS 3, FILLET WELDS
9. SUPPLEMENTARY SYMBOLS 1, WELD SURFACE SYMBOLS
10. SUPPLEMENTARY SYMBOLS 2
11. SUPPLEMENTARY SYMBOLS 3, ANSI/AWS
12. DIMENSIONS 1, BUTT WELD METAL
13. DIMENSIONS 2, BUTT WELD PREPARATION, ANSI/AWS
14. DIMENSIONS 3, FILLET WELD, TRANSVERSE
15. DIMENSIONS 4, FILLET WELD, TRANSVERSE
16. DIMENSIONS 5, FILLET WELD, LONGITUDINAL, ISO/BS
17. DIMENSIONS 6, FILLET WELD, LONGITUDINAL, ANSI/AWS
18. PROCESS IDENTIFICATION
19. STUD WELDS
20. SPOT AND SEAM WELDS
21. NONDESTRUCTIVE TESTING SYMBOLS, ANSI/AWS
22. EXERCISE 1, FLANGE ENDED PIPE
23. EXERCISE 2, VESSEL
24. EXERCISE 3, TANK
25. EXERCISE 4, BEAM



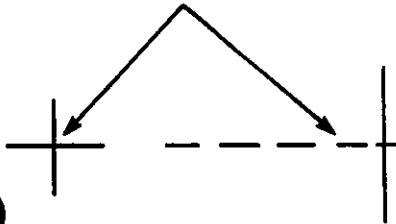


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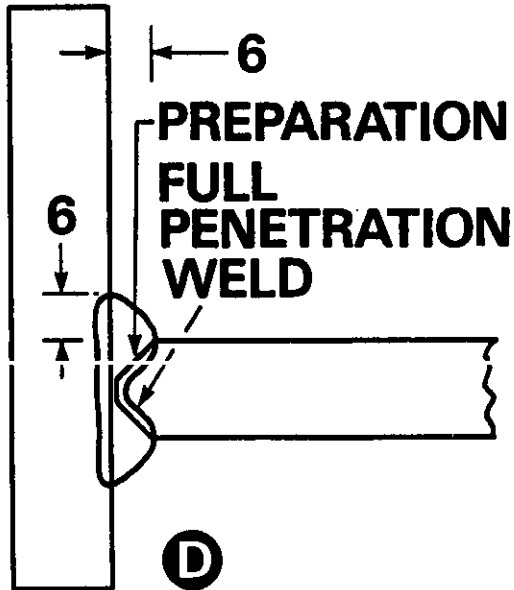


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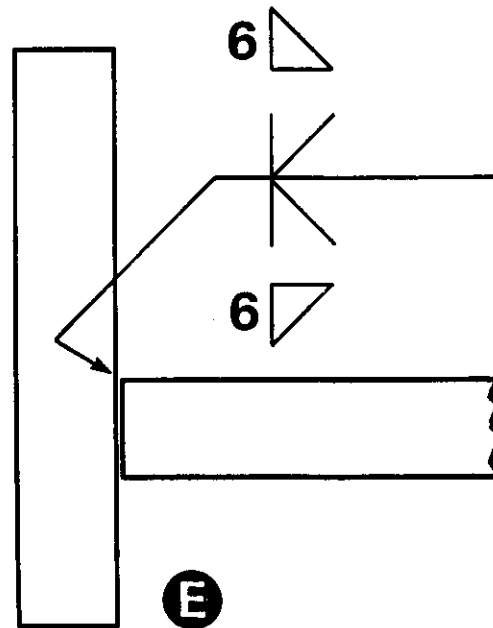
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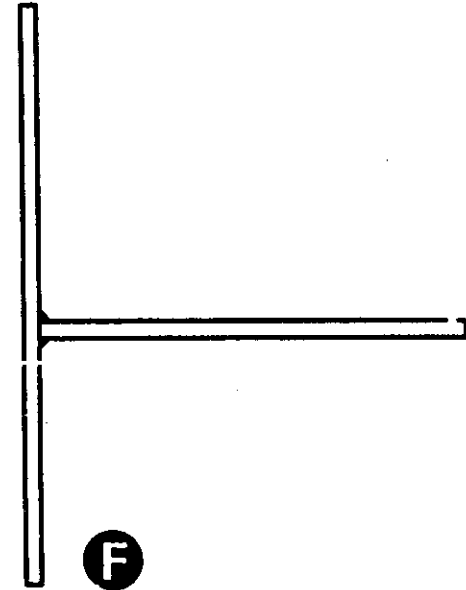
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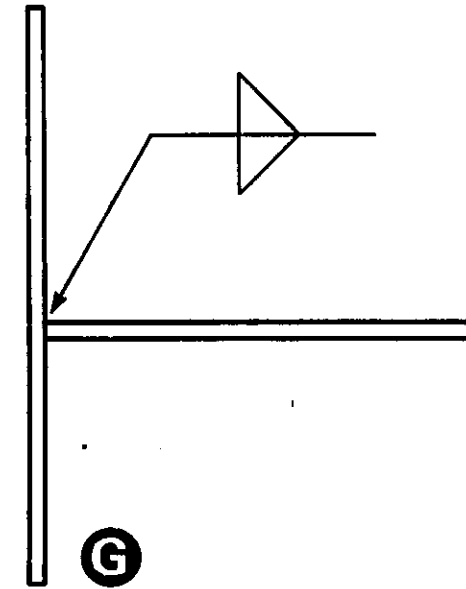
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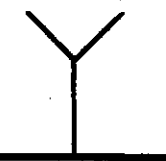
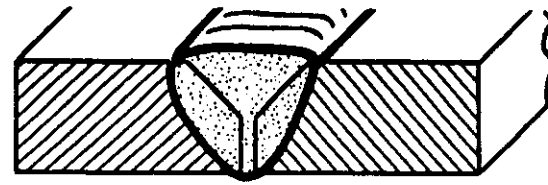
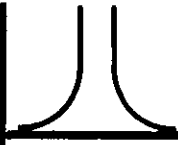
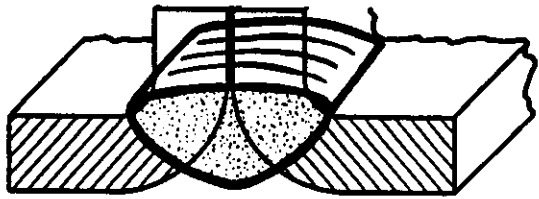
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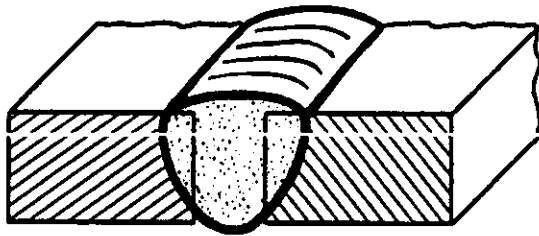
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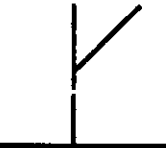
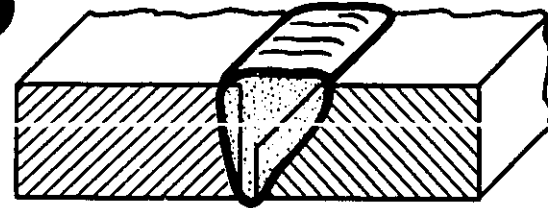
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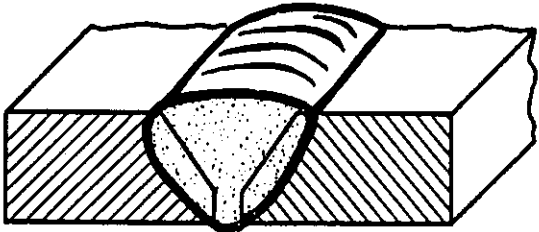
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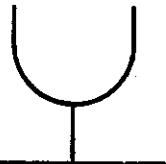
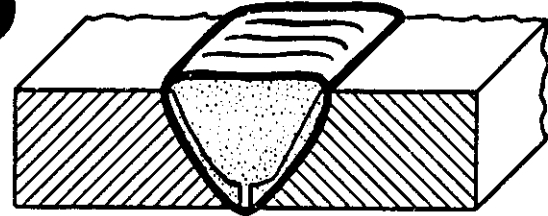
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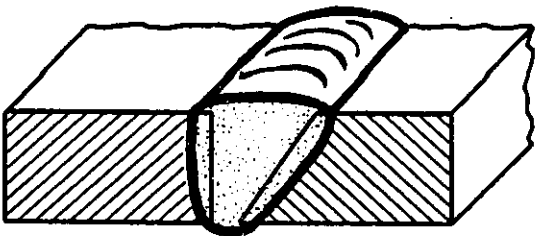
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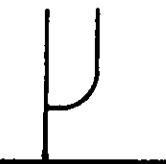
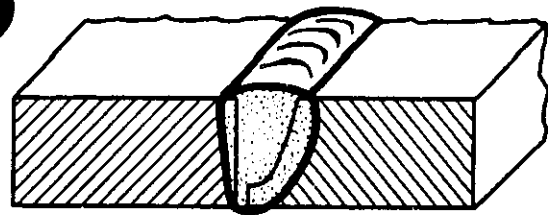
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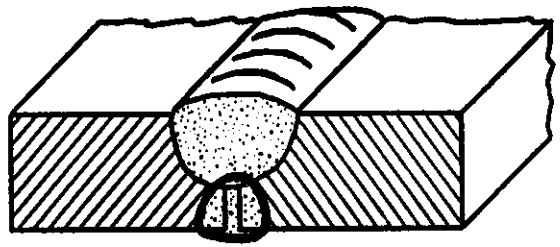


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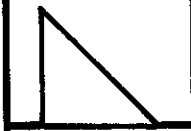
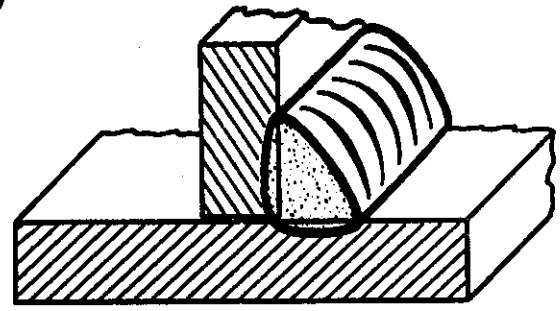
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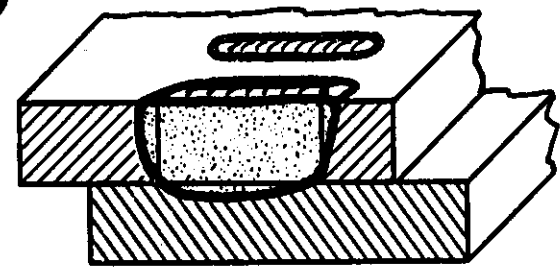
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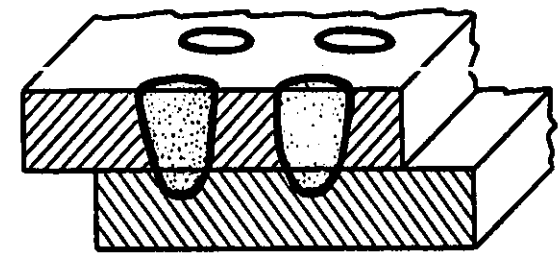
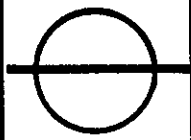
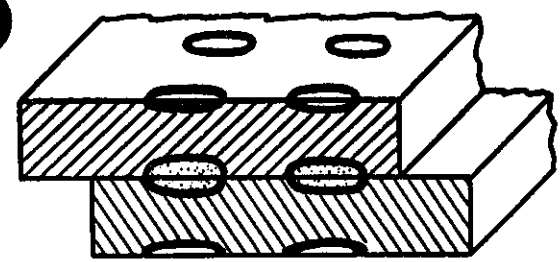
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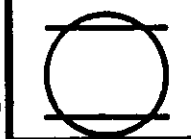
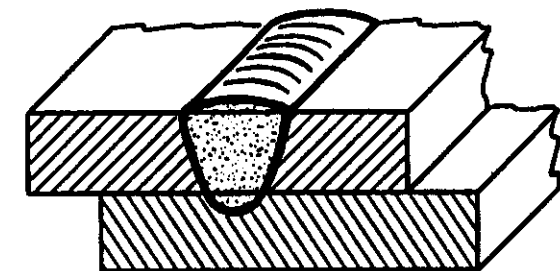
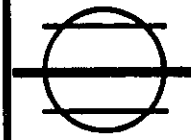
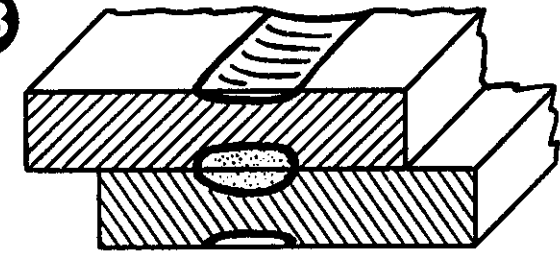
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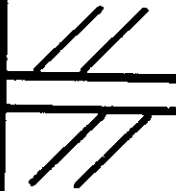
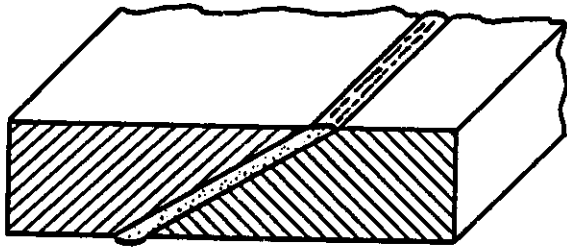
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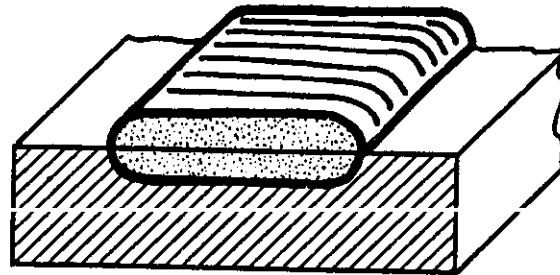
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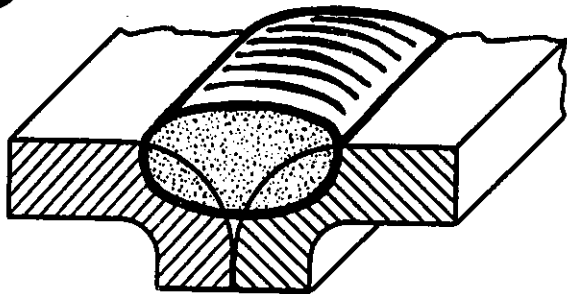
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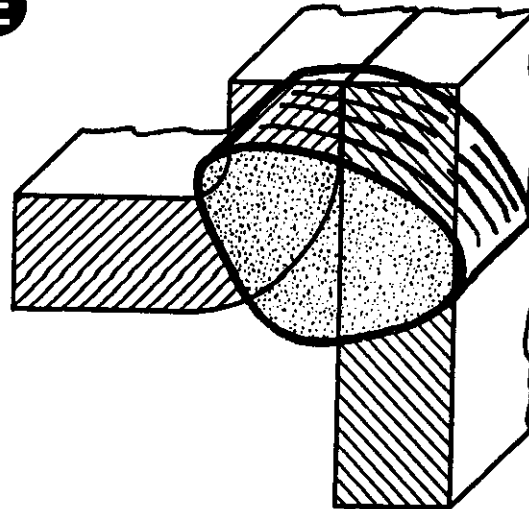
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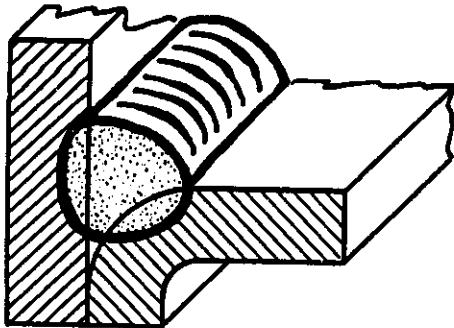
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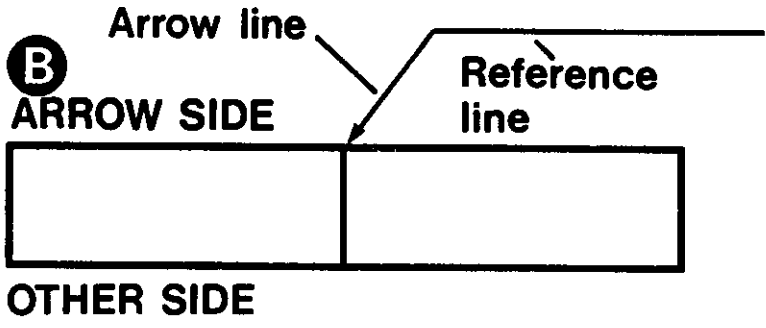
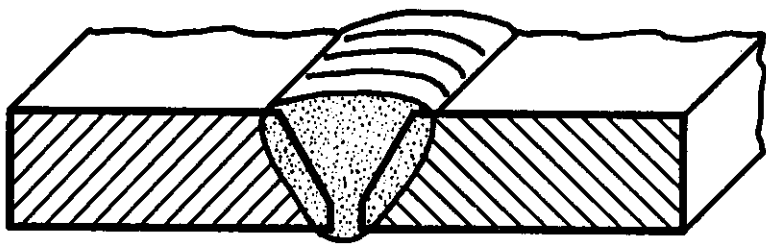
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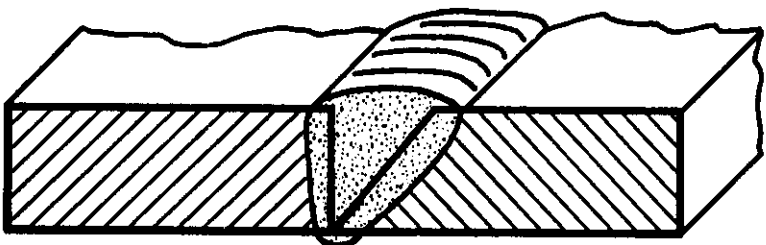
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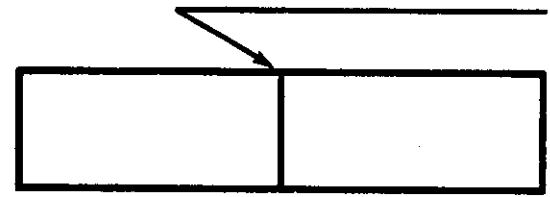
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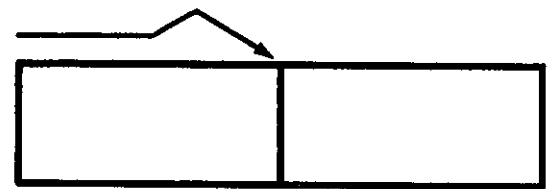
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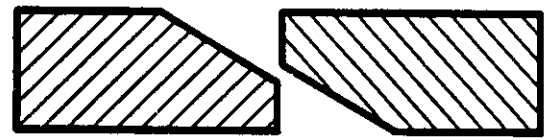
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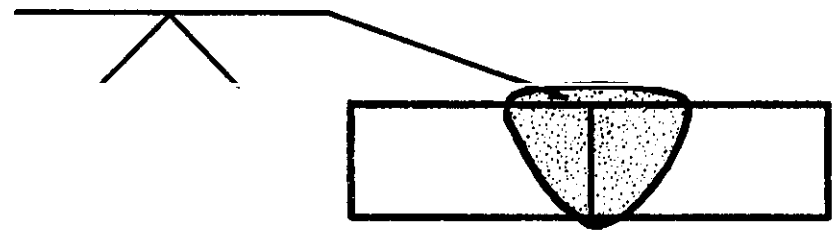
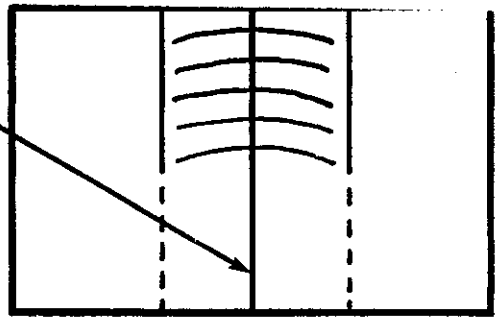


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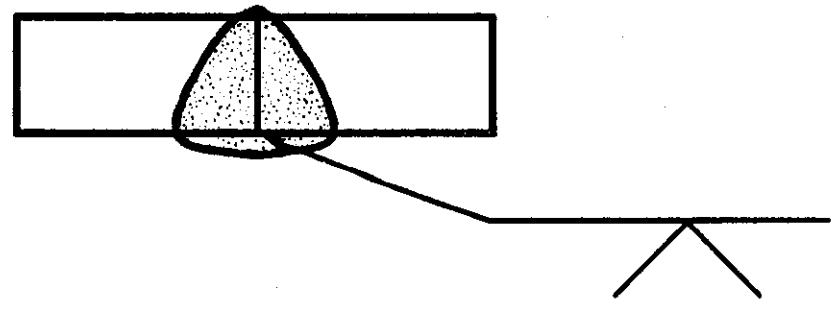


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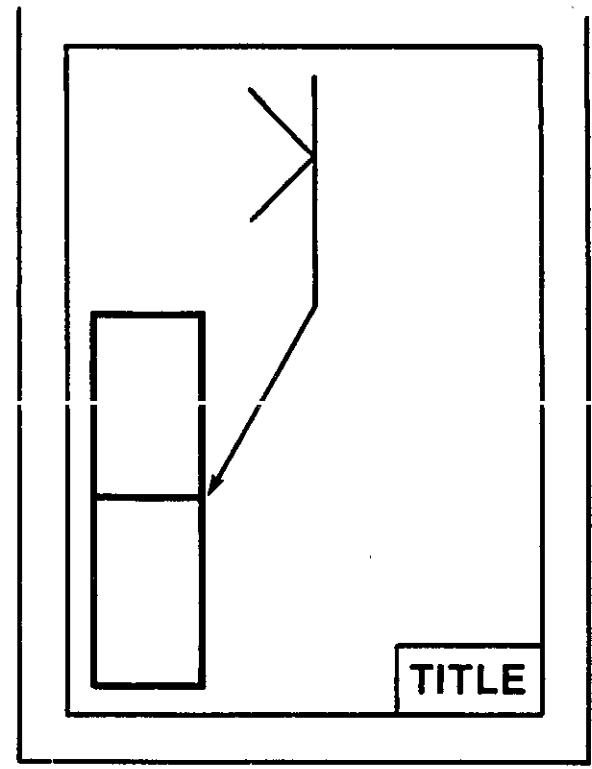
ARROW SIDE SYMBOL



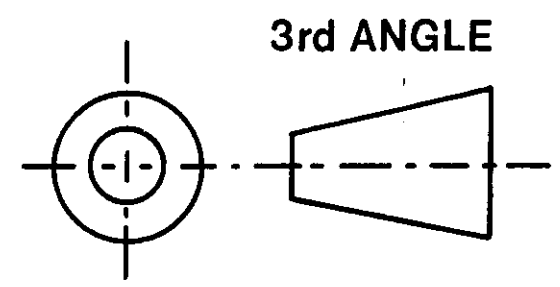
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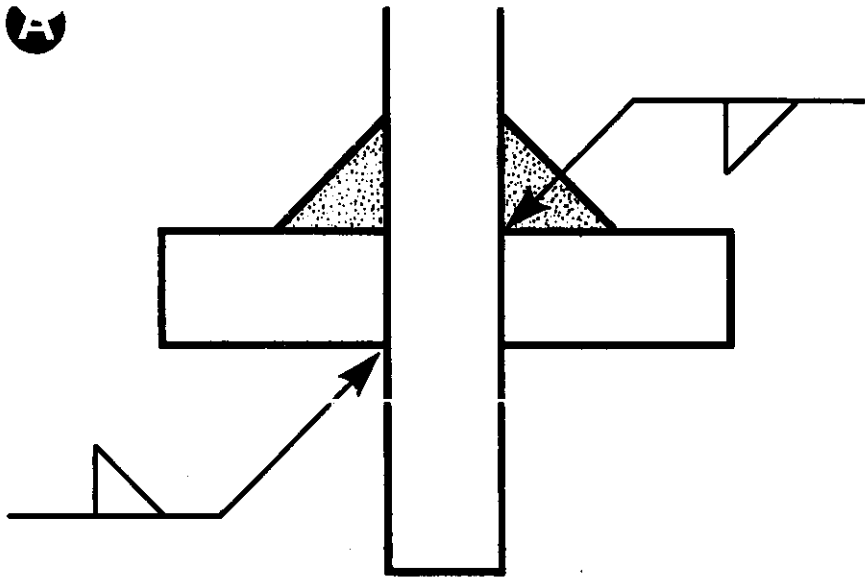
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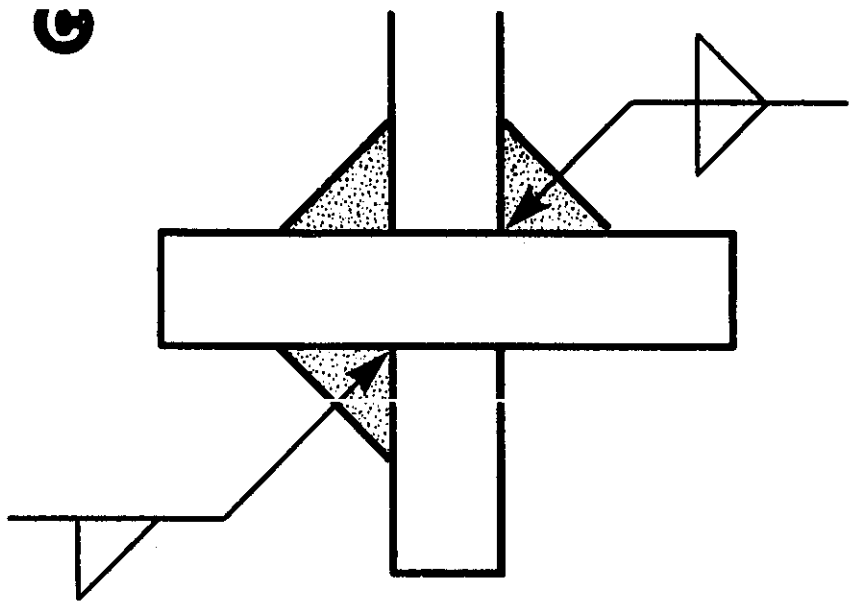
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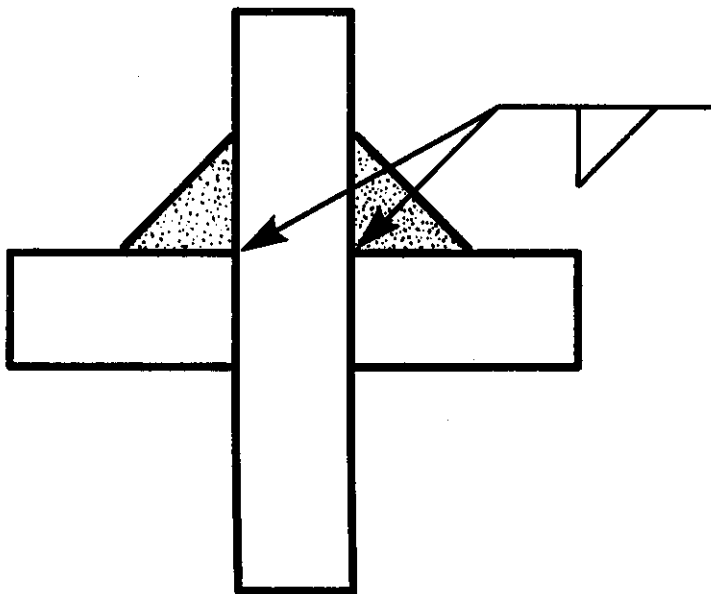
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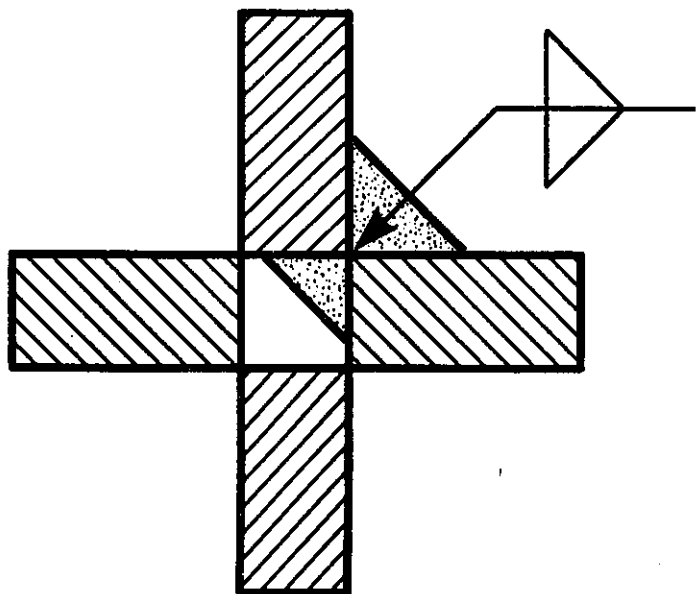
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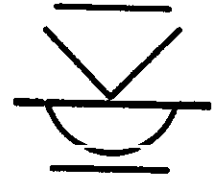
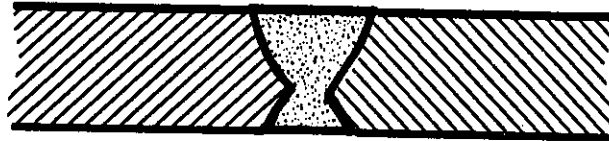
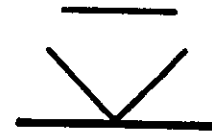
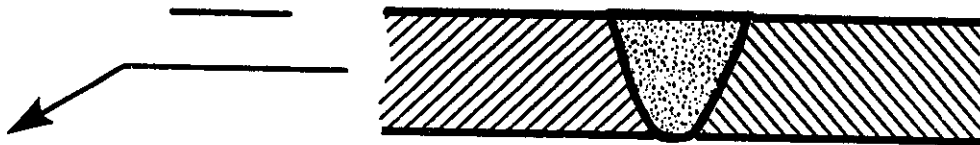
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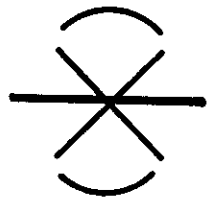
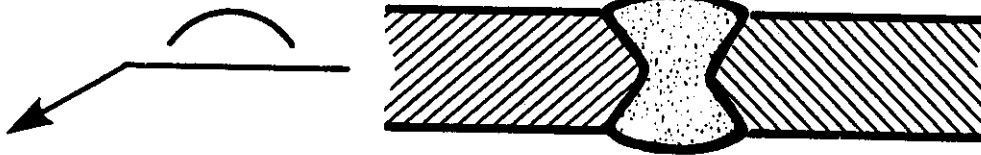
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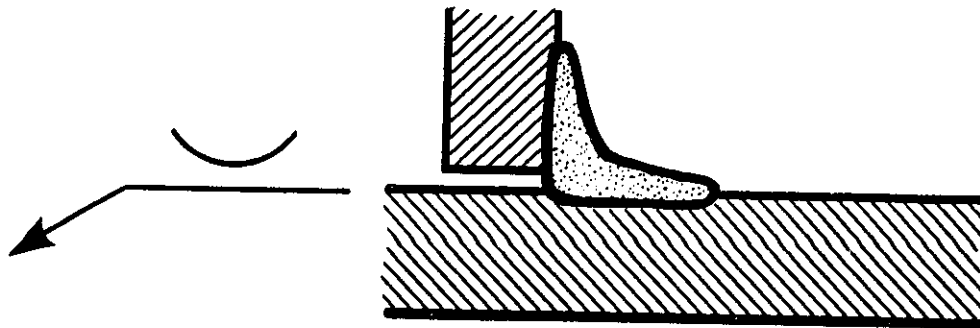
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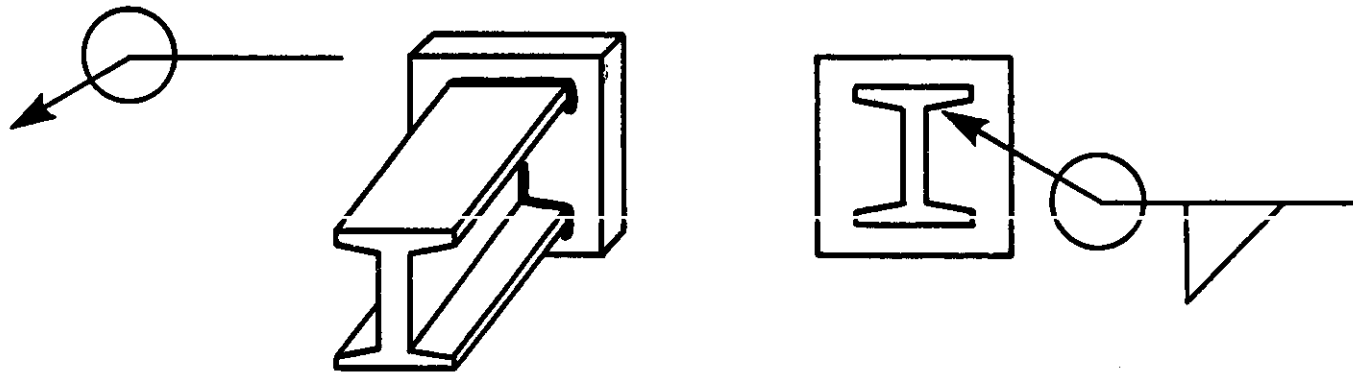


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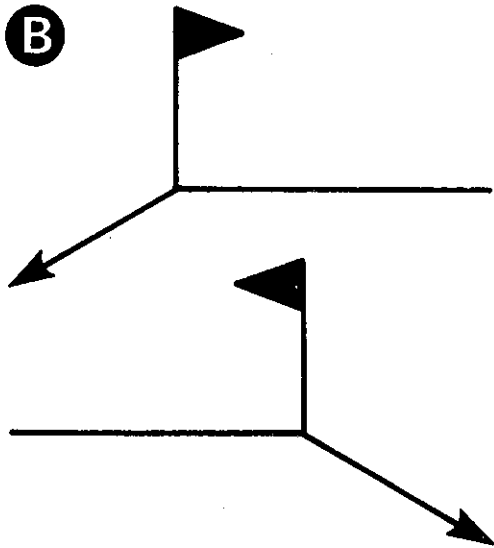
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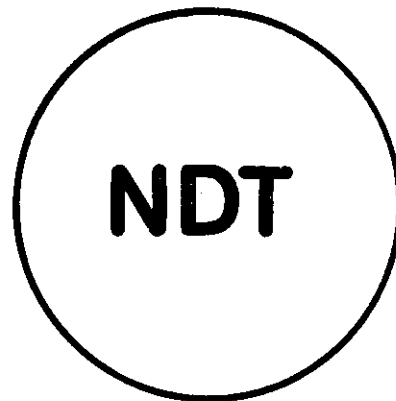
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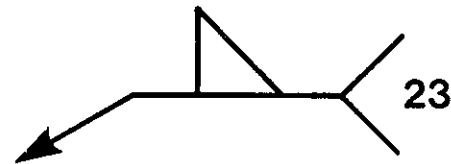
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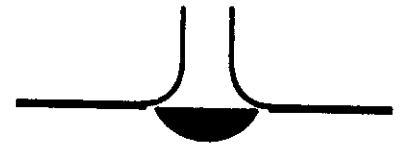
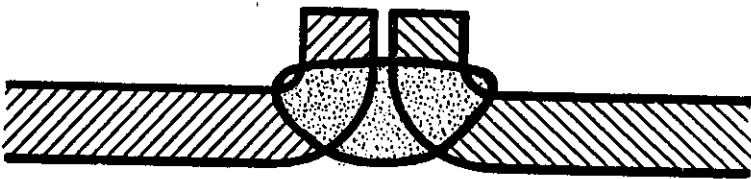


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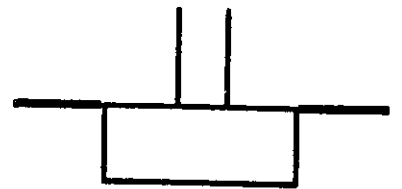
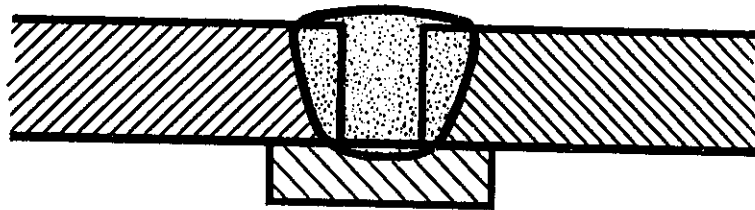


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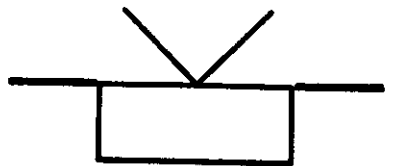
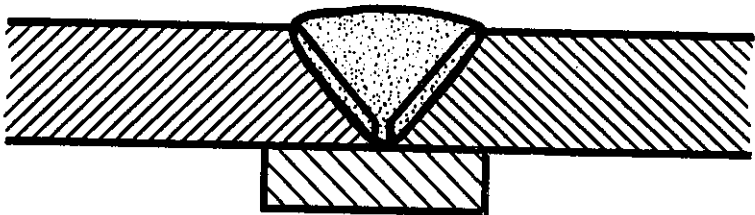




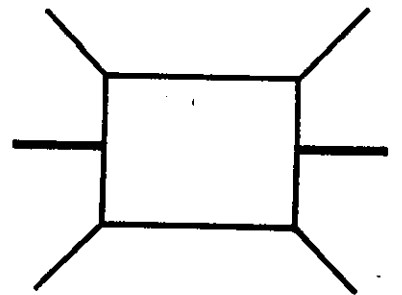
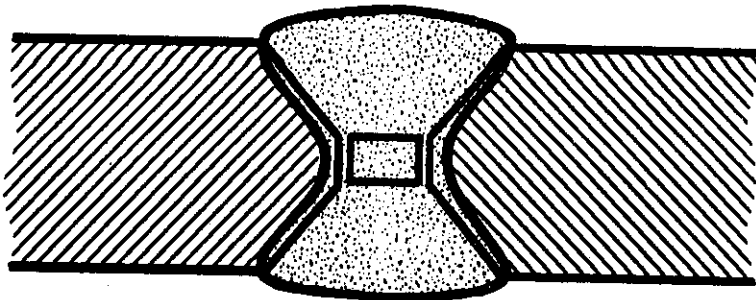
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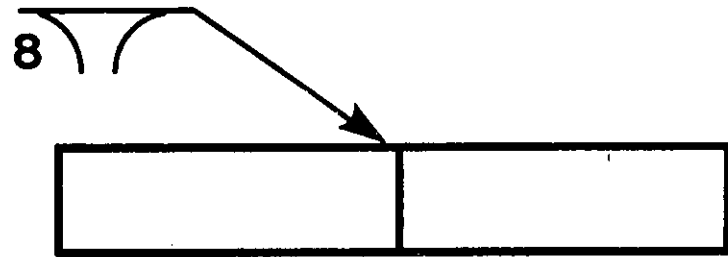
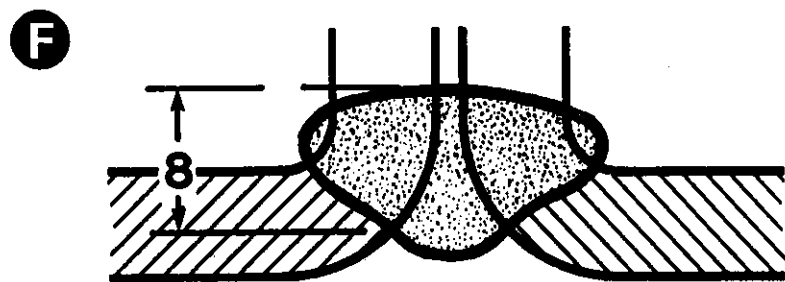
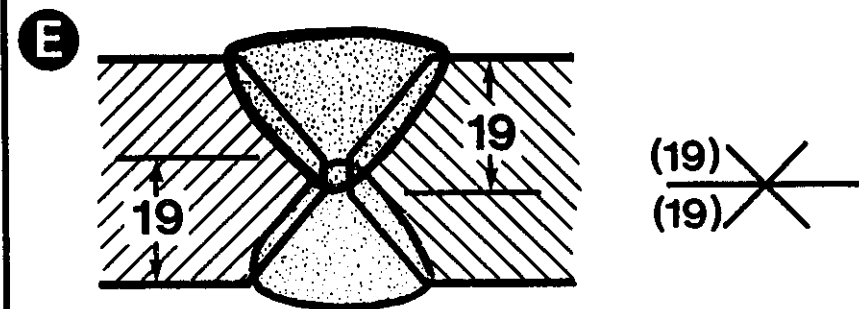
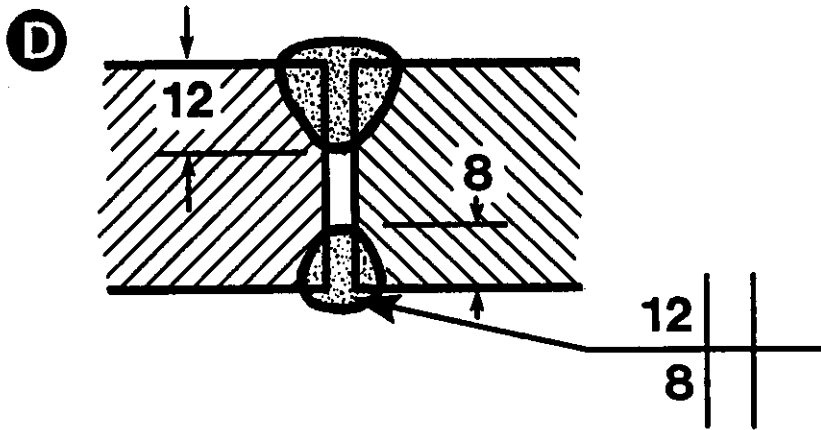
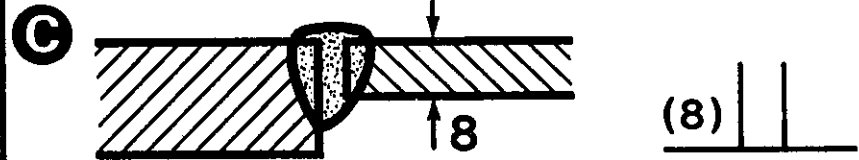
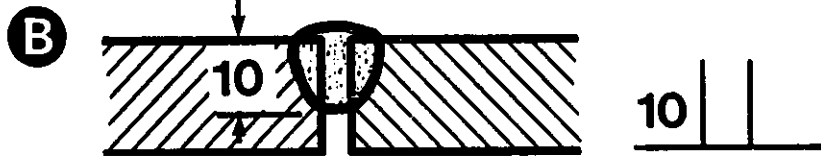
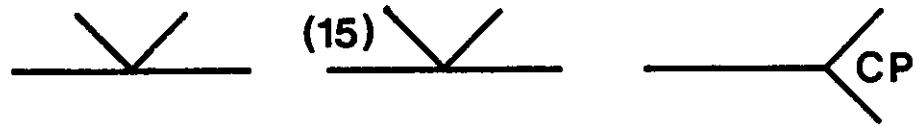
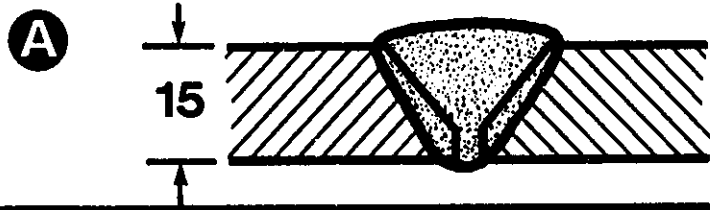
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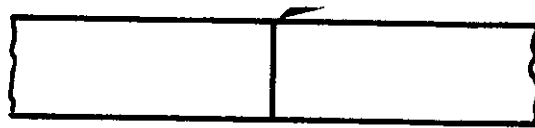
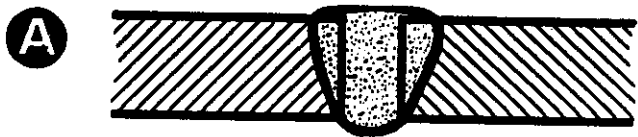


WI 11

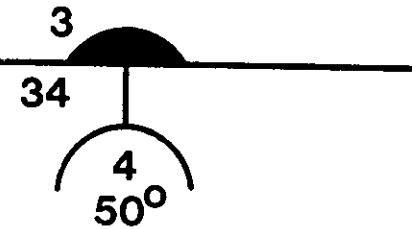
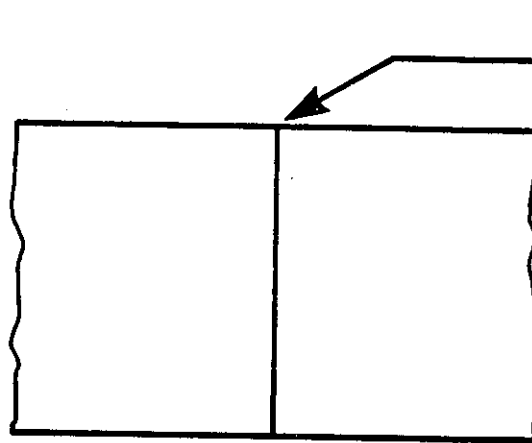
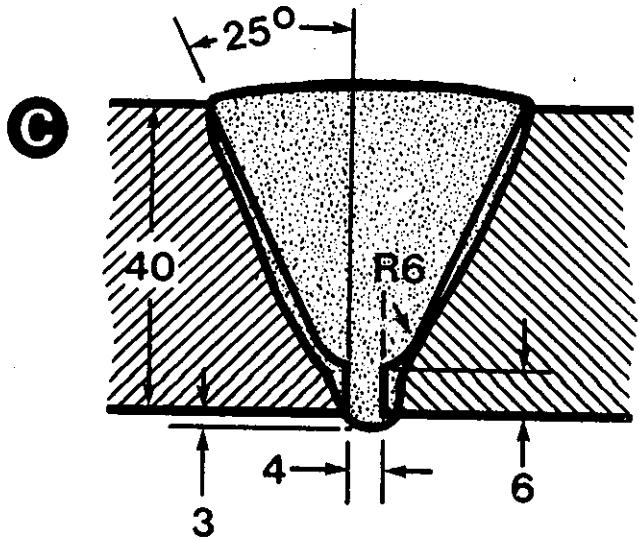
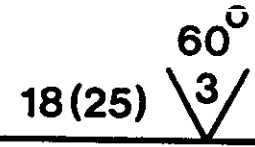
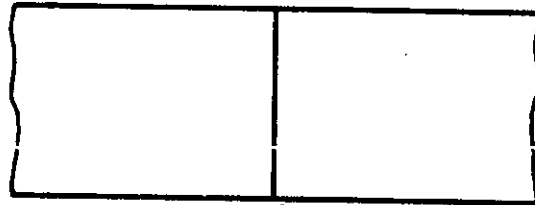
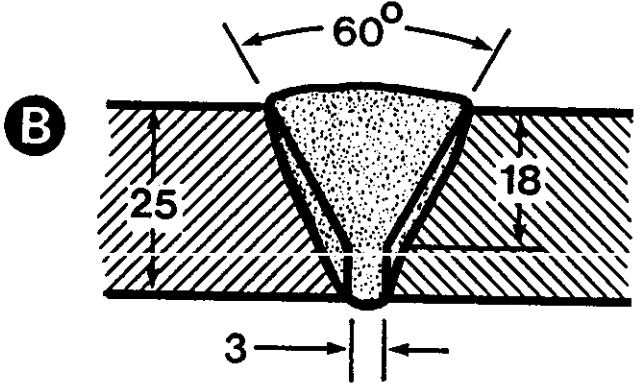
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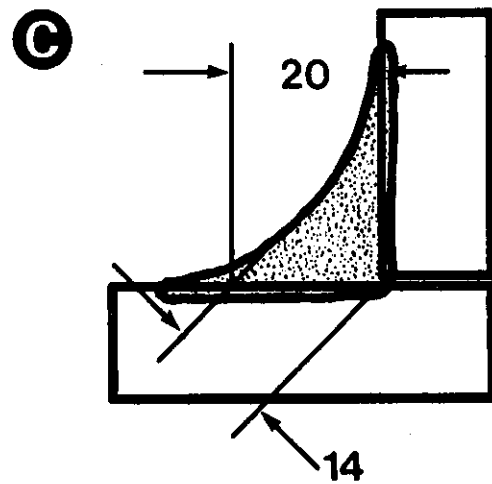
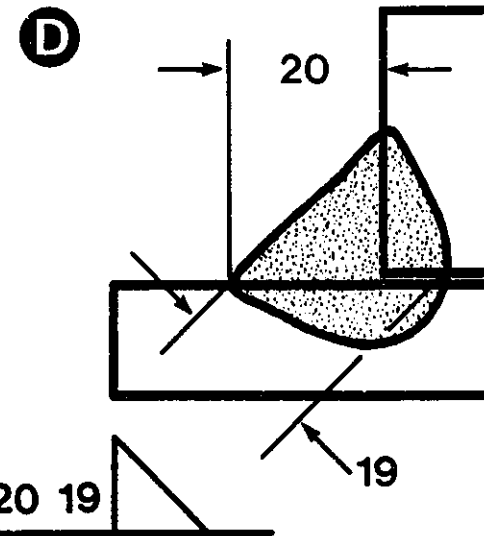
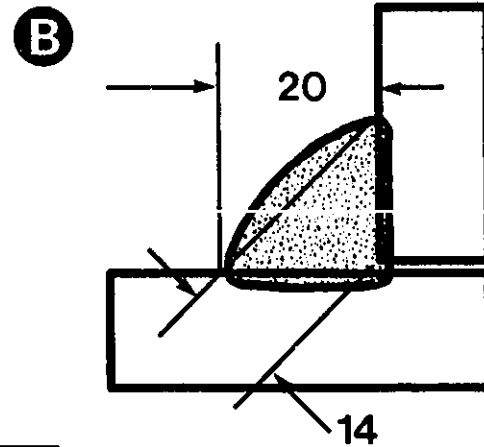
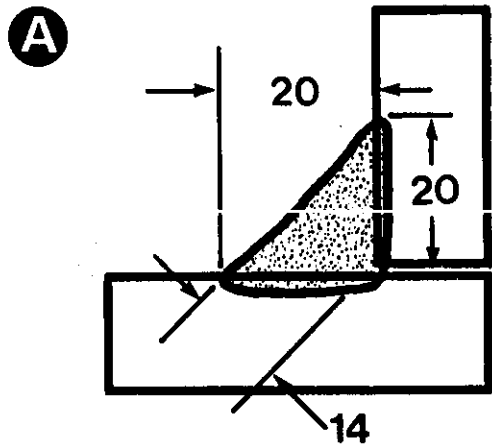


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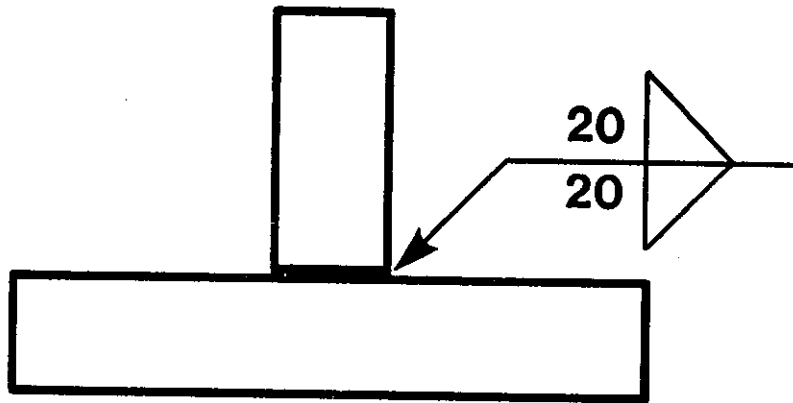


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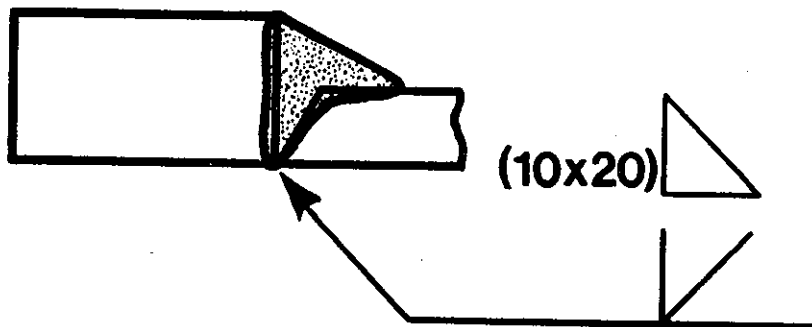
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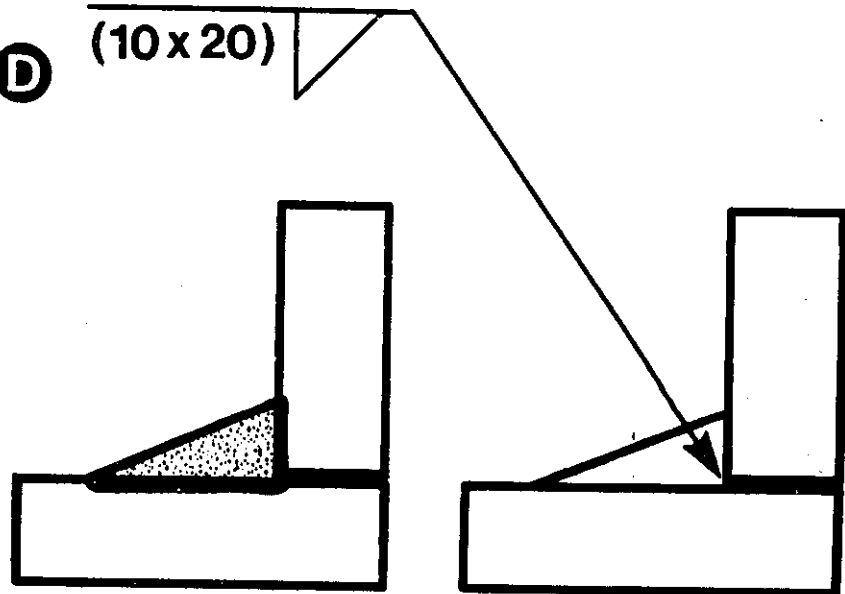
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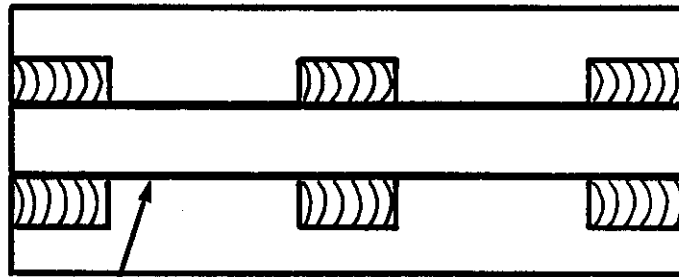
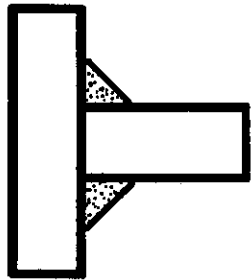
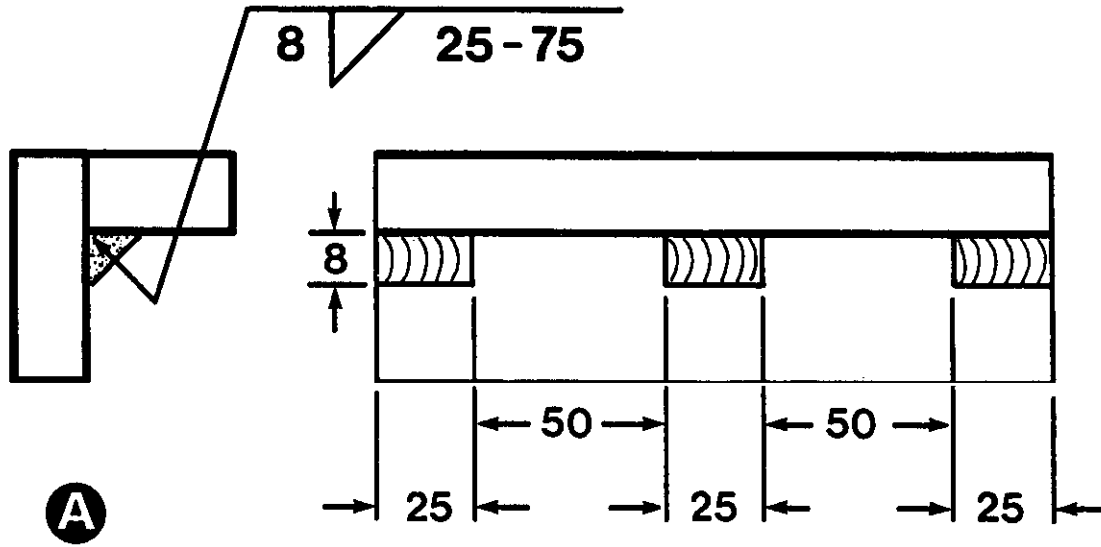
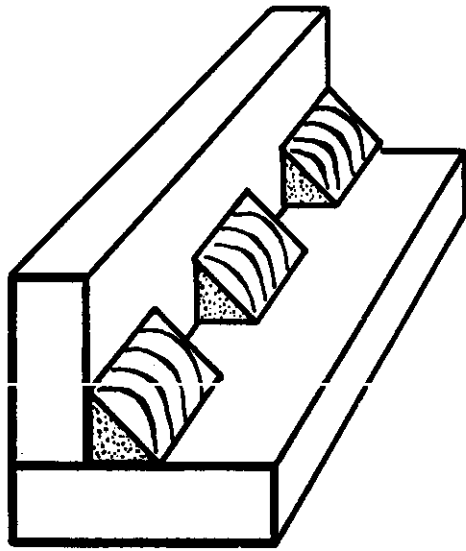
3,4,5,6,8,10,12,16,18,20,22,25

C

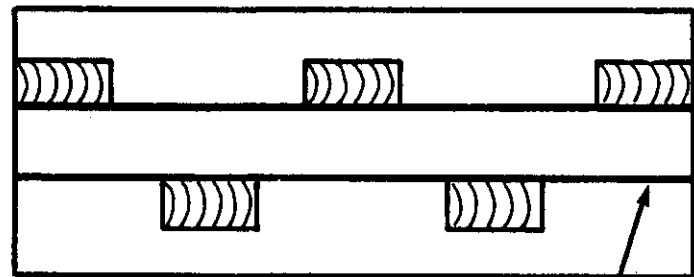
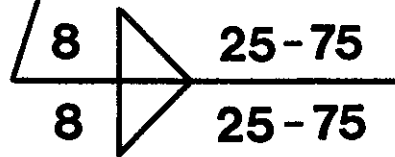


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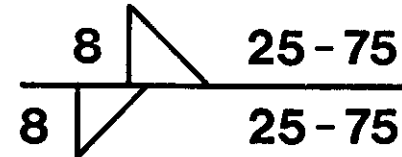




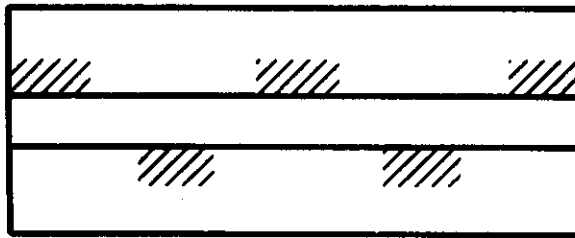
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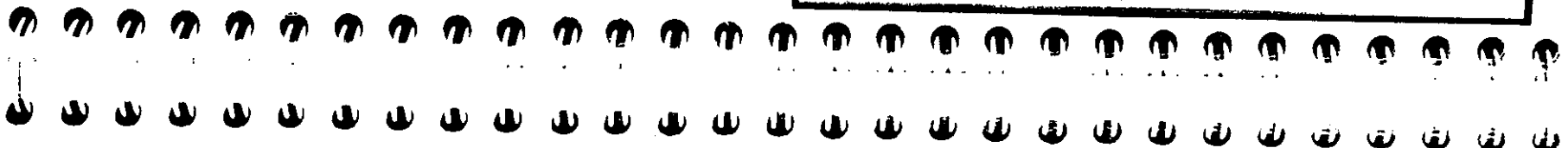


D



ARC WELDING**AW****SHIELDED METAL ARC WELDING****SMAW****FLUX CORED ARC WELDING****FCAW****SUBMERGED ARC WELDING****SAW****GAS METAL ARC WELDING****GMAW****GAS TUNGSTEN ARC WELDING****GTAW****PLASMA ARC WELDING****PAW****RESISTANCE WELDING****RW****RESISTANCE SPOT WELDING****RSW****RESISTANCE SEAM WELDING****RSEW****PROJECTION WELDING****RPW****FLASH WELDING****FW****OXYFUEL GAS WELDING****OFW****OXYACETYLENE WELDING****OAW****FRICITION WELDING****FRW****FORGE WELDING****FOW****THERMIT WELDING****TW****ELECTROSLAG WELDING****ESW****STUD ARC WELDING****SW****BRAZING****B****SOLDERING****S****SUFFIXES****AUTOMATIC
MACHINE****AU
ME****MANUAL
SEMI-AUTOMATIC****MA
SA****18**

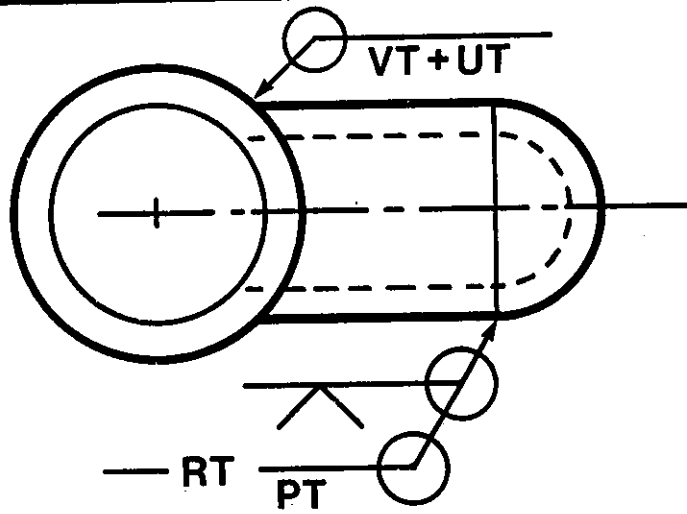
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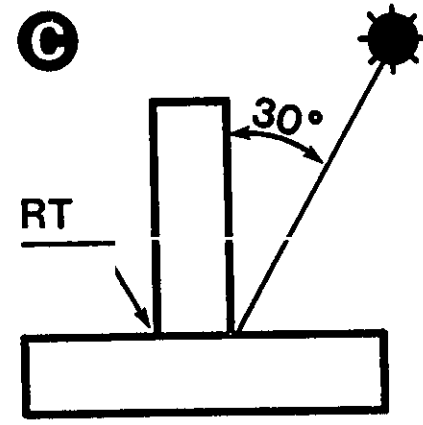
A

Type of test	Symbol
ACOUSTIC EMISSION	AET
EDDY CURRENT	ET
LEAK	LT
MAGNETIC PARTICLE	MT
NEUTRON RADIOGRAPHIC	NRT
PENETRANT	PT
PROOF	PRT
RADIOGRAPHIC	RT
ULTRASONIC	UT
VISUAL	VT

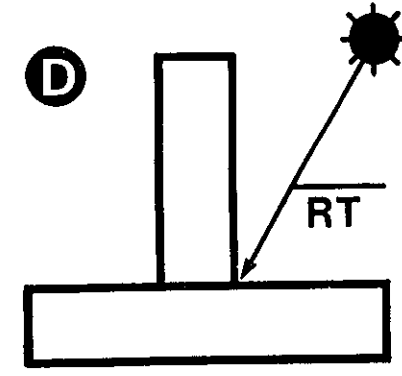
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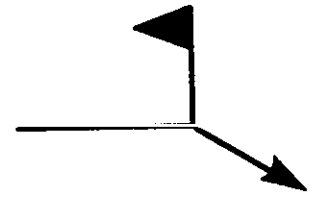
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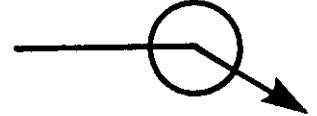
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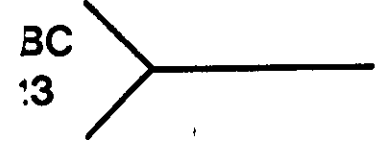
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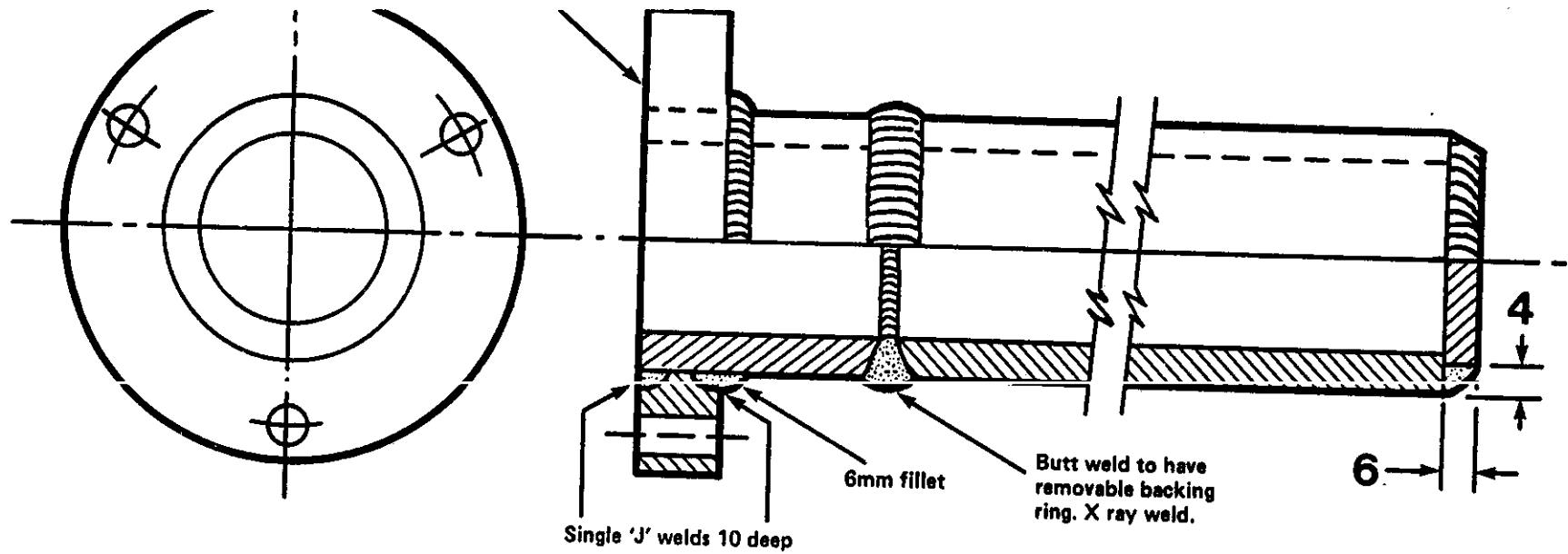


F



G





All dimensions in millimetres

FLANGE ENDED PIPE

WI 22

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SECTION 23: EXERCISE 2, VESSEL

23 (Base transparency
+ 2 overlays)

BASE TRANSPARENCY

Symbols representing welds to be made: letters in circles are for ease of reference below only.

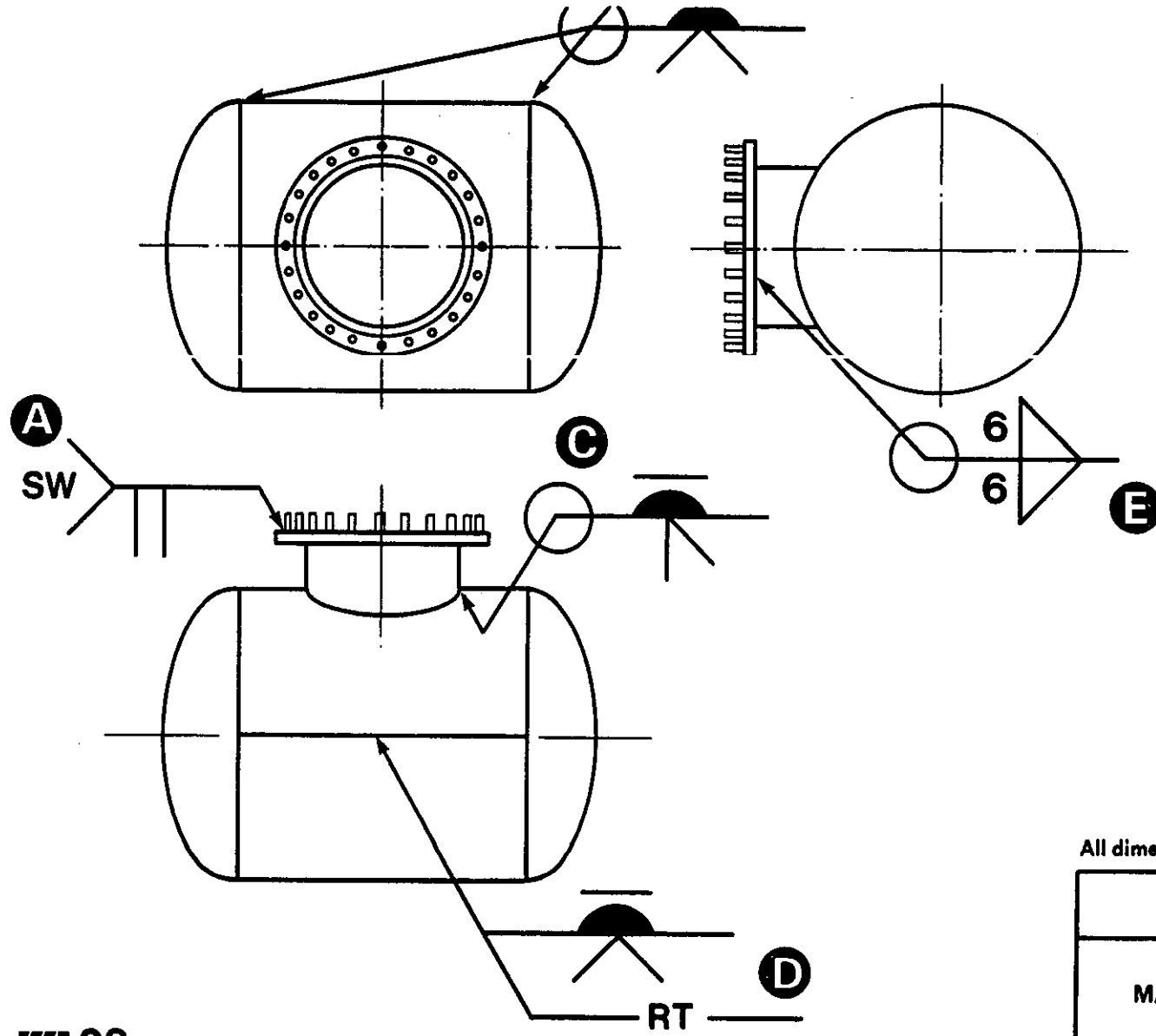
Problem 1. Describe welds to be made, with sketches where necessary.

Comments

- 1 The standard used for welding symbols has not been identified: there are six clear indications that it is to ANSI/AWS.
A: process abbreviation in fork is alphabetical.
B, C, D: 3 x 'melt-thru' symbols.
B and D: 2 x 'radiographic test' symbol.
- 2 A: stud arc welding, confirmed by studs on drawing.
- 3 B and D: single-V butt weld with melt-thru, ground flush inside and radiographed.
- 4 C: single-bevel butt weld, stub pipe only bevelled, (set-on branch), with melt-thru, ground flush inside.
- 5 E: fillet weld, of 6mm leg length, both sides of joint. See sketches on overlay (a) for interpretation.
- a **OVERLAY:** possible interpretations of flange to tube joint E.
F: this is consistent with the weld symbol, but the view does not show the expected projection of the tube through the flange: also a form unlikely to be used, because of clearance problems.
G, H: consistent with weld symbol and drawing. To decide between these two, it would be necessary to have details of the flange.

Problem 2. Modify symbols to conform to BS 499: Part 2: 1980, with joint as at H.

- b **OVERLAY:** symbols to BS, solution to problem 2.
I: symbol replacing A.
J: symbol replacing B: note that BS can only specify NDT, not specifically radiography. As there is no 'melt-thru' symbol, only full penetration and a flat rear face can be specified: the symbol requirements would be met by welding to produce a substantially flat surface, without further treatment.
K: symbol replacing C
L: symbol replacing D
M: Symbol replacing E } see comments on J above



All dimensions in millimetres

VESSEL

MATERIAL:
STAINLESS STEEL
BODY 6mm
FLANGE 20mm

SECTION 25: EXERCISE 4, BEAM

25 (Base transparency and overlay)

BASE TRANSPARENCY

Sketch of beam, not to scale, to be assembled by manual metal arc welding in the shop and on site.

Problem. Sketch in welding details and symbols to BS 499: Part 2: 1980 (or other standard as instructed).

a **OVERLAY: SOLUTION.** (Letters in circles are for reference below only).

Comments

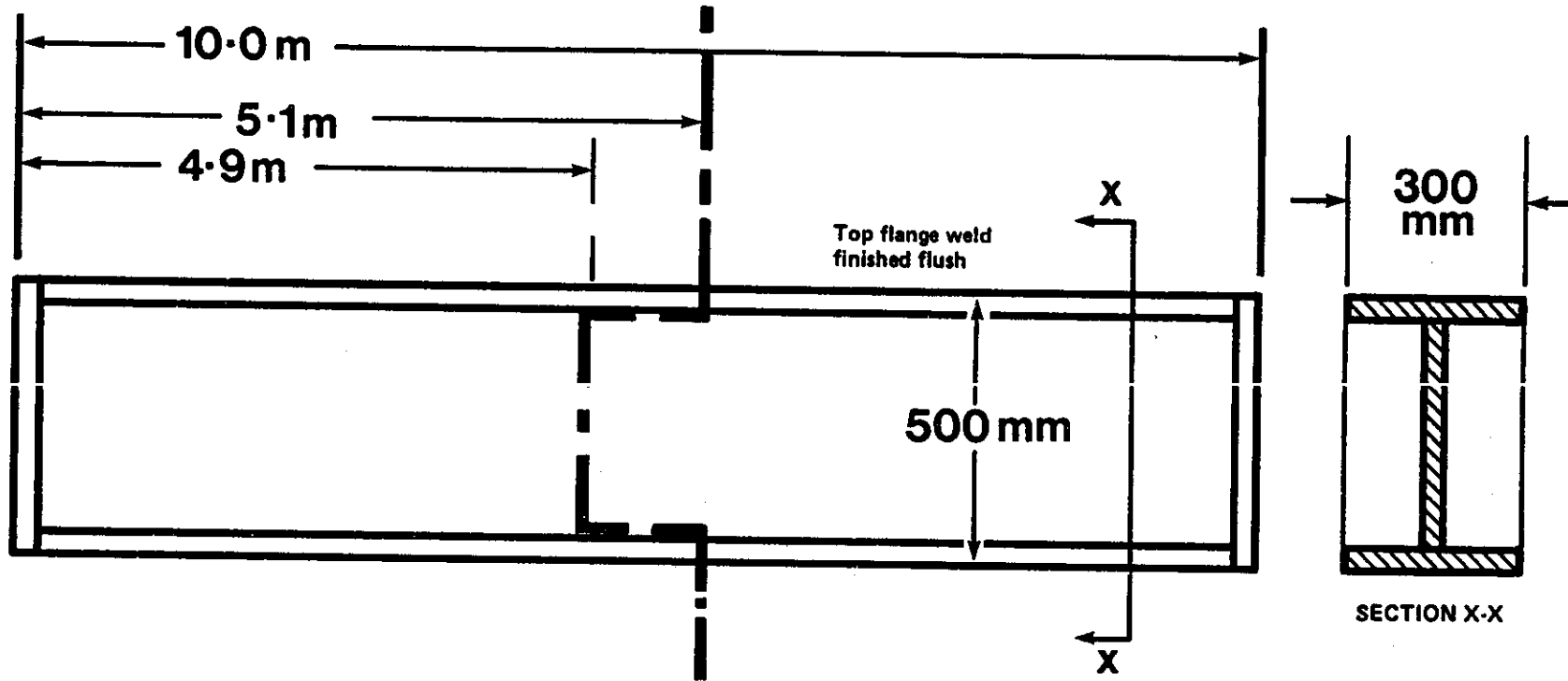
A Cope-holes have been introduced to avoid the need to dress welds where they meet other welds, and to avoid welding up into corners, often a site for defects.

B We cannot use a 'weld all round' symbol for the end flange joints, as it cannot go over top and bottom of the flanges, and it is interrupted by the cope-holes.

C Similarly to B, the web-to-flange joints are in four sections, needing four arrows if they are to be shown individually.

The spacing in BS is not the pitch (here 300mm) but the distance between the ends of weld elements, here $(300-100) = 200\text{mm}$.

D A suggestion to be taken seriously! Apart from simplifying the drawing, complete shop fabrication can considerably reduce the costs of welding and of quality assurance.



FLANGES	15mm
WEB	10mm
END PLATES	20mm

End flanges: 12mm fillet weld
all round (inside)
Flange-to-web: 12mm fillet welds
100mm long, 300mm pitch each
side, alternately each side.

Not to scale

SKETCH FOR BEAM

