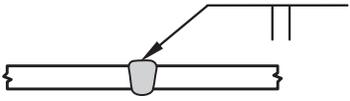
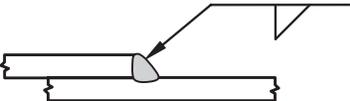
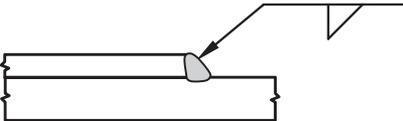
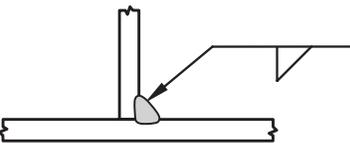
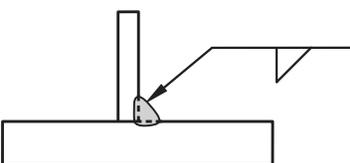
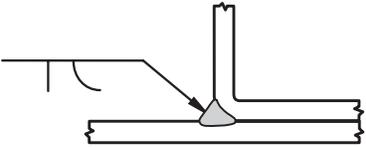
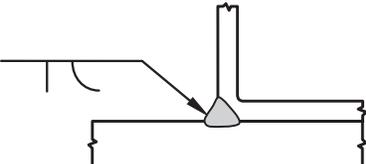
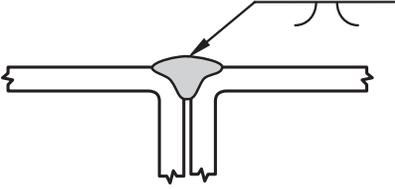
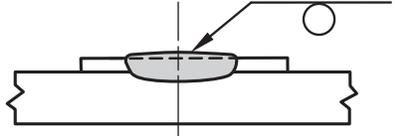
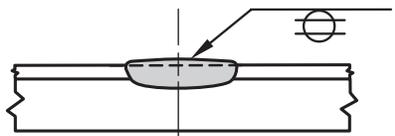
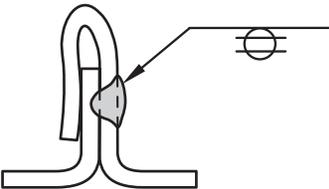
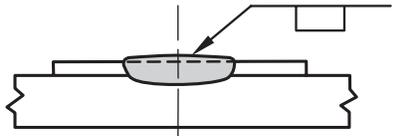


Table 4.4
Welder Performance Qualification Tests^a (see 4.8)

Test Assemblies Shown in Figure:	Type of Welded Joint Tested	Type of Test	Position		Qualified	
			Tested	Qualified	Welded Joint	Thickness
4.1 	Square-groove weld in butt joint—sheet to sheet	Bend	F H V OH	F F, H F, H, V F, H, OH	Square-groove weld in butt joint—sheet to sheet	Thickness tested [except as modified by 4.7.2(3)]
4.2A 	Fillet weld in lap joint—sheet to sheet	Bend	F H V OH	F F, H F, H, V F, H, OH	Fillet weld in lap or corner joint—sheet to sheet, and sheet to supporting structural member	Thickness tested and thicker
4.2B 	Fillet weld in lap joint—sheet to supporting structural member	Bend	F H V OH	F F, H F, H, V F, H, OH	Fillet weld in lap or corner joint—sheet to supporting structural member	Thickness tested and thicker
4.2C 	Fillet weld in T-joint—sheet to sheet	Bend	F H V OH	F F, H F, H, V F, H, OH	Fillet weld in T-, lap, or corner joint—sheet to sheet, and sheet to supporting structural member	Thickness tested and thicker
4.2D 	Fillet welded T-joint, sheet to supporting member	Bend	F H V OH	F F, H F, H, V F, H, OH	Fillet welded T-, lap, or corner joint, sheet to supporting member	Thickness tested and thicker
4.3A 	Flare-bevel-groove weld—sheet to sheet	Bend	F H V OH	F F, H F, H, V F, H, OH	Flare-bevel-groove weld—sheet to sheet and sheet to supporting structural member, and flare-V-groove weld—sheet to sheet	Thickness tested and thicker
4.3B 	Flare-bevel-groove weld—sheet to supporting structural member	Bend	F H V OH	F F, H F, H, V F, H, OH	Flare-bevel-groove weld—sheet to supporting structural member	Thickness tested and thicker

(Continued)

Table 4.4 (Continued)
Welder Performance Qualification Tests^a (see 4.8)

Test Assemblies Shown in Figure:	Type of Welded Joint Tested	Type of Test	Position		Qualified	
			Tested	Qualified	Welded Joint	Thickness
4.3C 	Flare-V-groove weld—sheet to sheet	Bend	F H V OH	F F, H F, H, V F, H, OH	Flare-V-groove weld—sheet to sheet and flare-bevel-groove weld—sheet to sheet, and sheet to supporting structural member	Thickness tested and thicker
4.4 	Arc spot weld—sheet to supporting structural member	Torsion	F	F	Arc spot and arc seam weld—sheet to supporting structural member	Thickness tested
4.5A 	Arc seam weld—sheet to supporting structural member	Bend	F	F	Arc seam weld—sheet to supporting structural member	Thickness tested
4.5B 	Arc seam weld—sheet to sheet	Bend	H	H	Arc seam weld—sheet to sheet	Thickness tested
4.6 	Arc plug weld—sheet to supporting structural member	Torsion	F H V OH	F F, H F, H, V F, H, OH	Arc plug weld—sheet to sheet, and sheet to supporting structural member	Thickness tested

^a Two tests shall be required for each assembly.

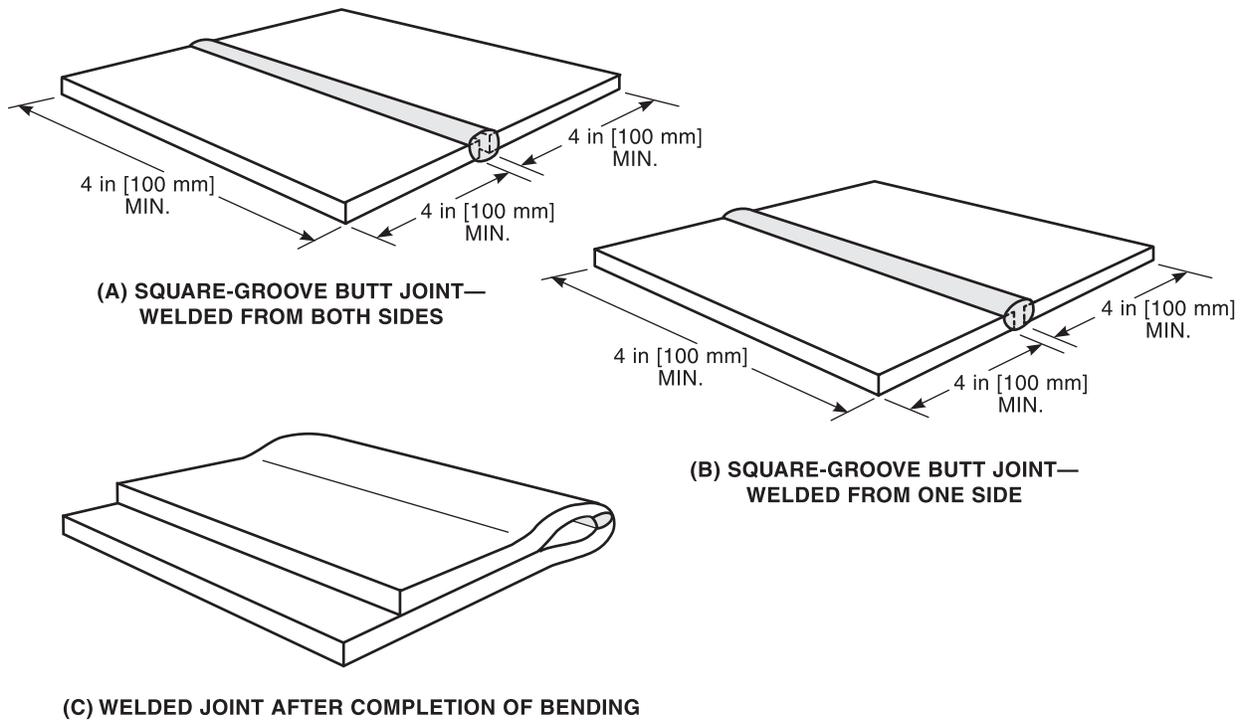


Figure 4.1—Test for Square-Groove Welds in Butt Joints [see 4.6.1.2(1)]

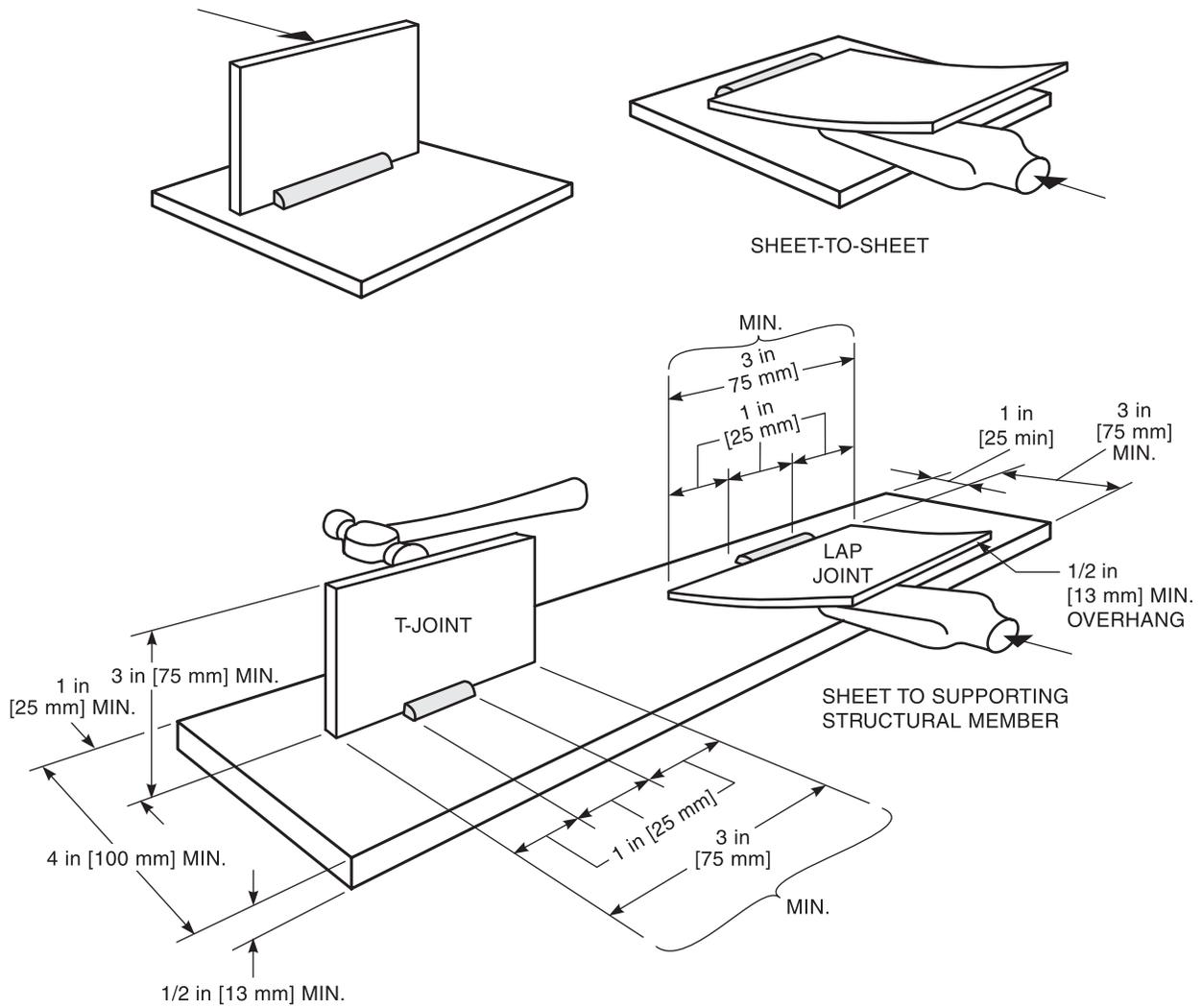


Figure 4.2A—Test for Fillet Welds [see 4.6.2.2(1)]

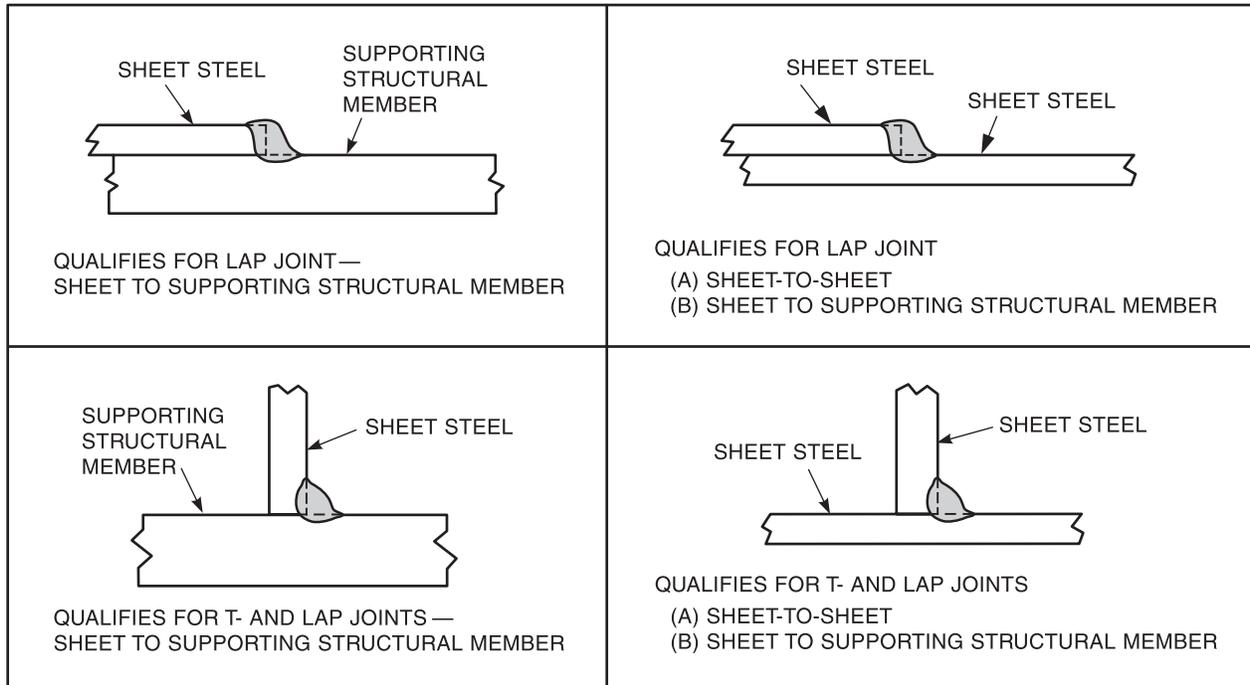


Figure 4.2B—Extent of Validity of Fillet Weld Qualifications (see 4.2.2.3)

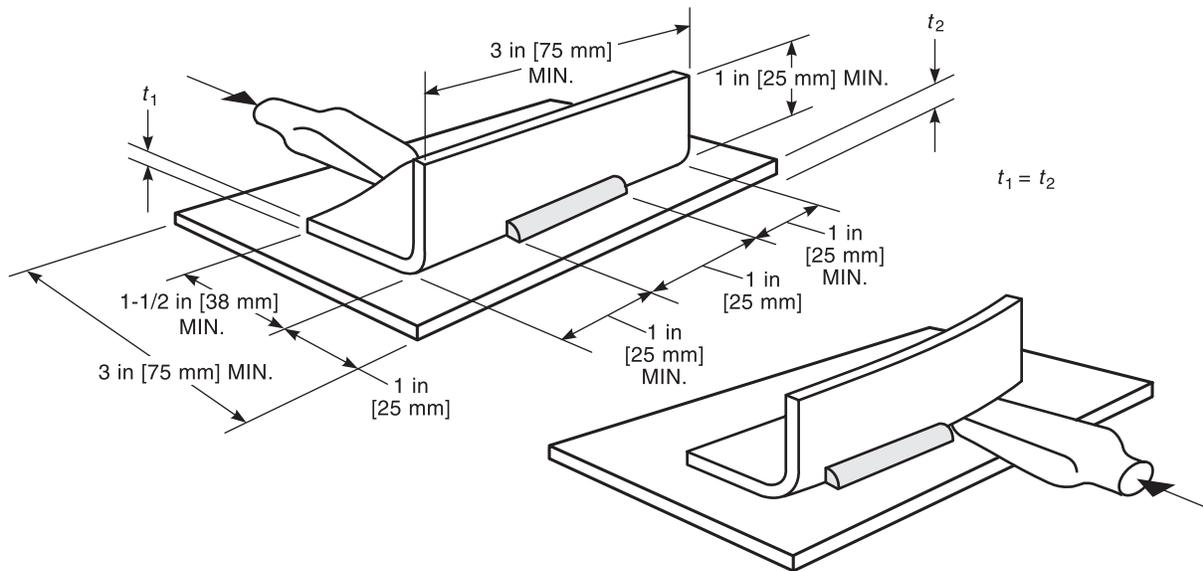


Figure 4.3A—Test for Sheet to Sheet Flare-Bevel-Groove Welds [see 4.6.3.2(1)(a)]

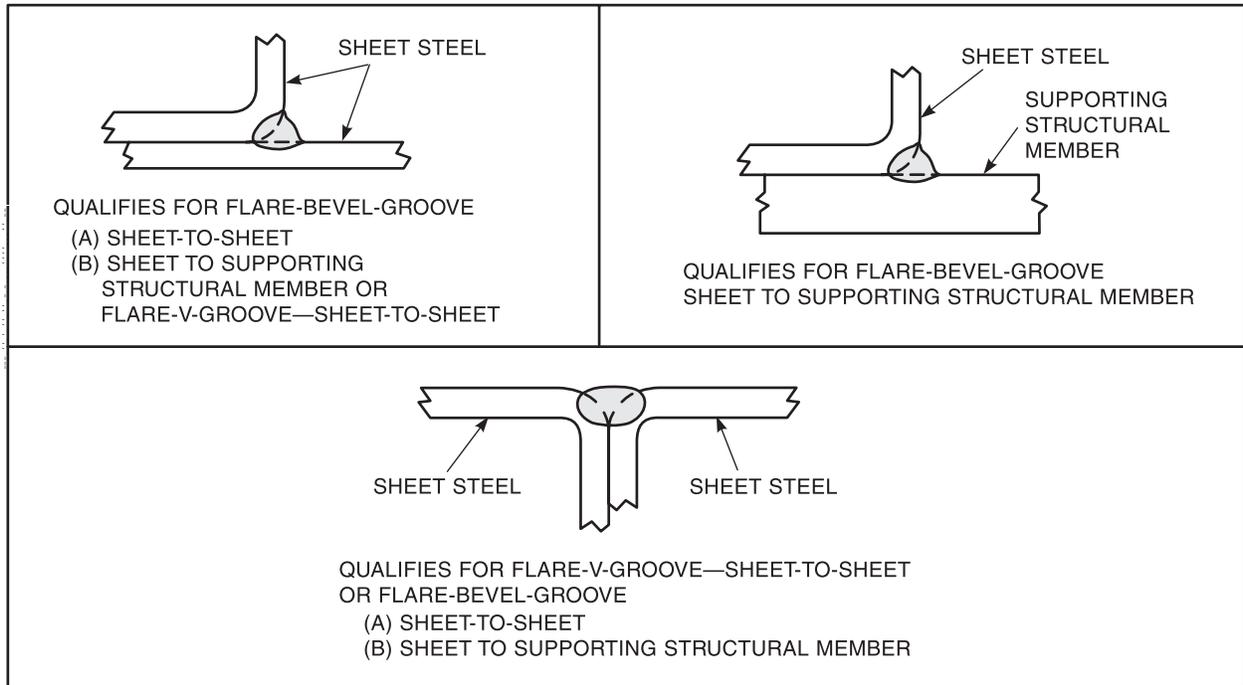


Figure 4.3D—Extent of Validity of Flare-Groove Weld Qualifications (see 4.6.3.3)

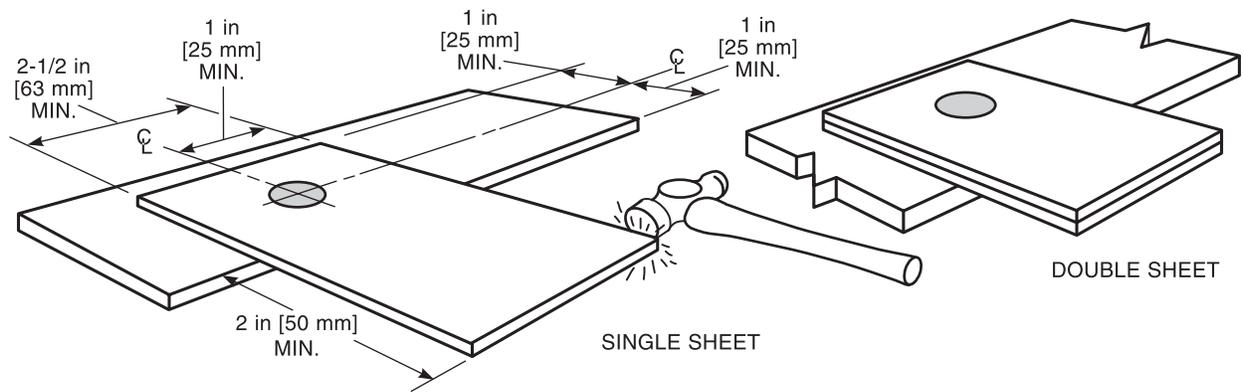


Figure 4.4—Test for Arc Spot Welds [see 4.6.4.2(1)]

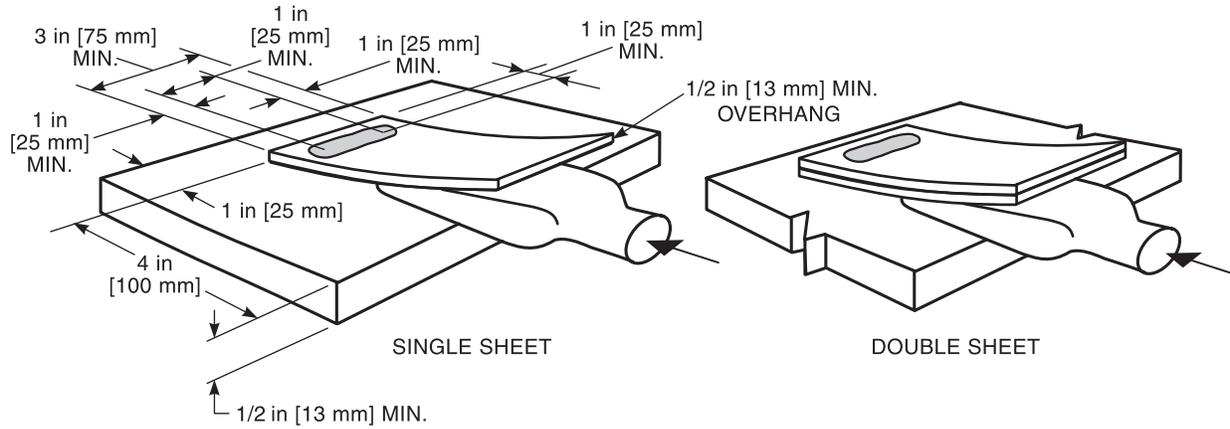


Figure 4.5A—Test for Sheet to Supporting Structural Member Arc Seam Welds [see 4.6.5.2(1)]

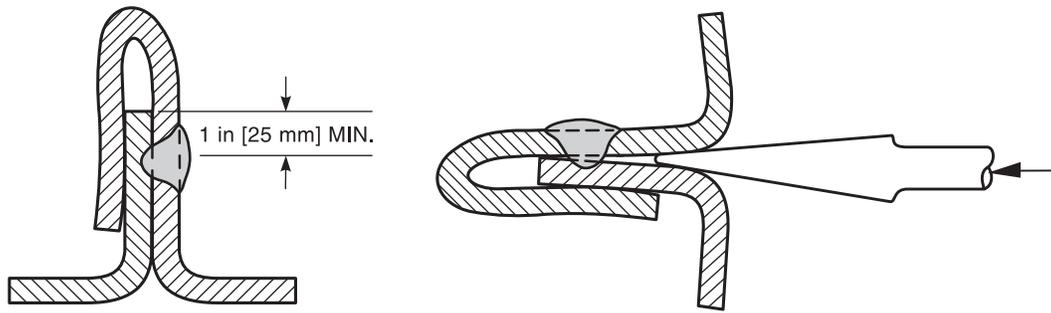
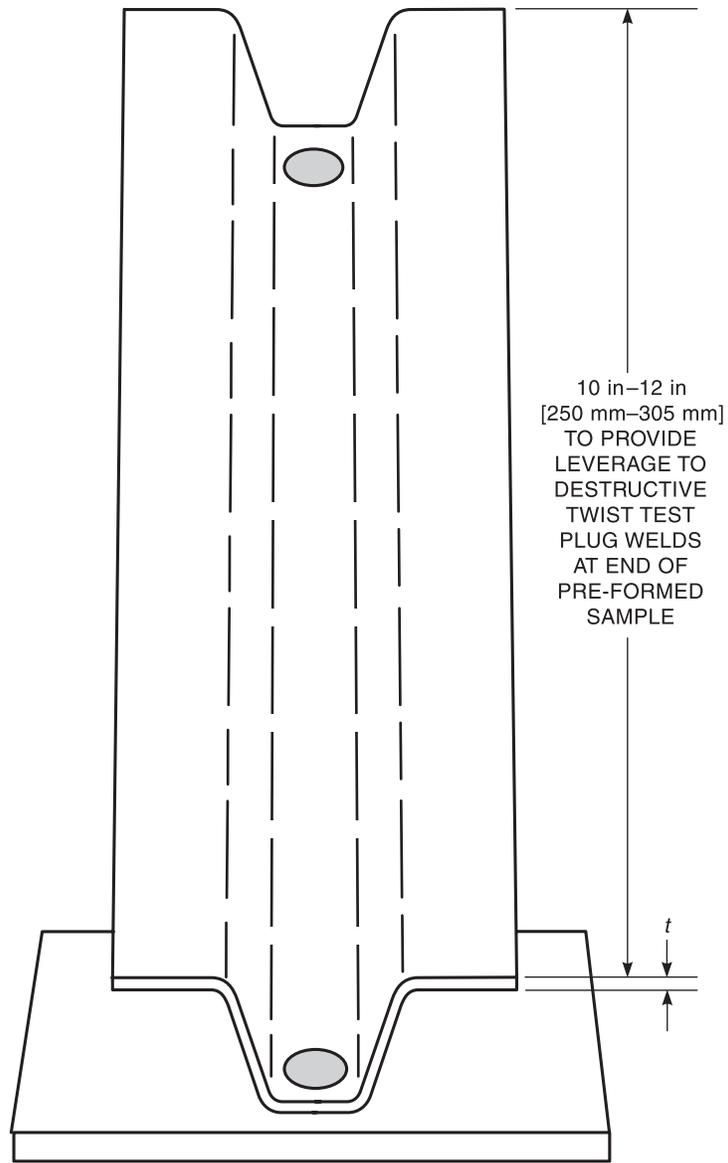


Figure 4.5B—Test for Sheet to Sheet Arc Seam Welds [see 4.6.5.2(2)]



ARC PLUG WELD
(SHEET TO SUPPORTING MEMBER)
FLAT POSITION

DETAIL (A)

Typical for multi-ply sheet to supporting structural member or sheet-to-sheet—
also used for horizontal, vertical, and overhead positions.

Figure 4.6—Test for Arc Plug Welds [see 4.6.6.2(1)]

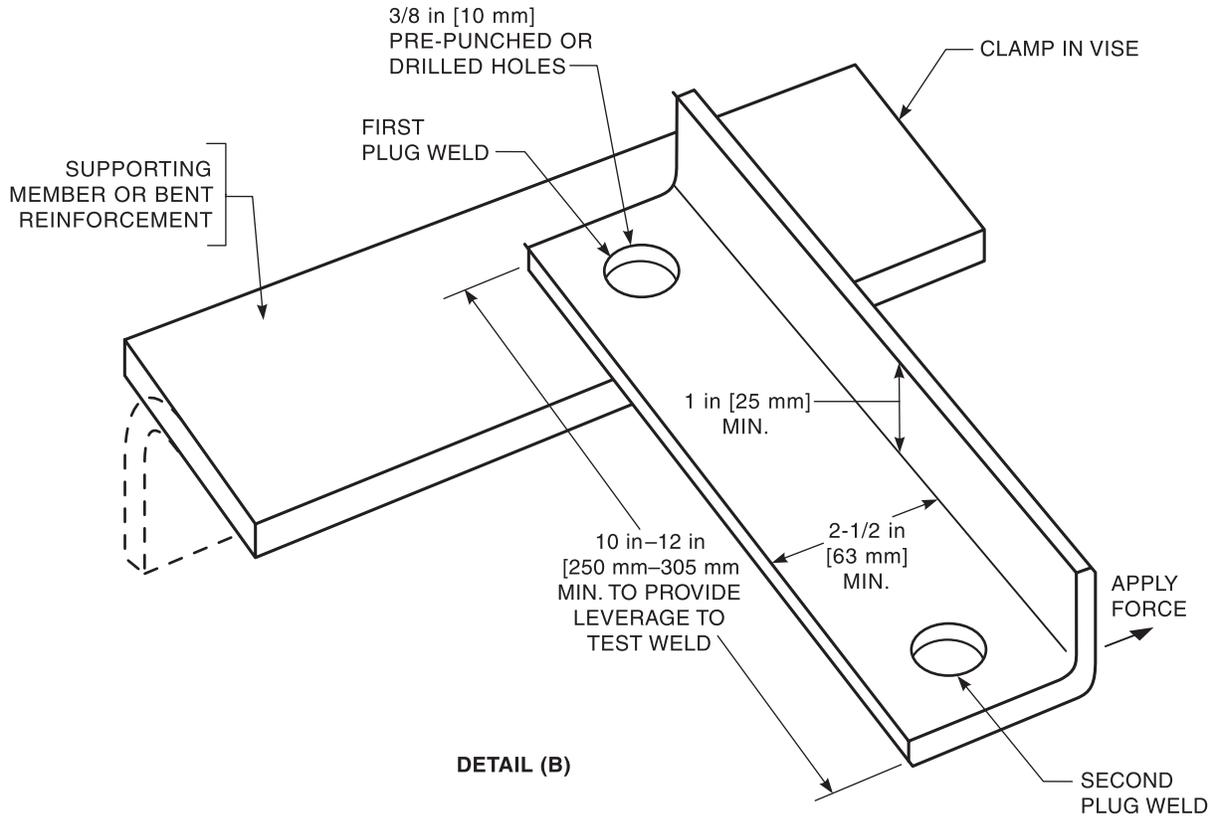


Figure 4.6 (Continued)—Test for Arc Plug Welds [see 4.6.2.2(1)]

This page is intentionally blank.