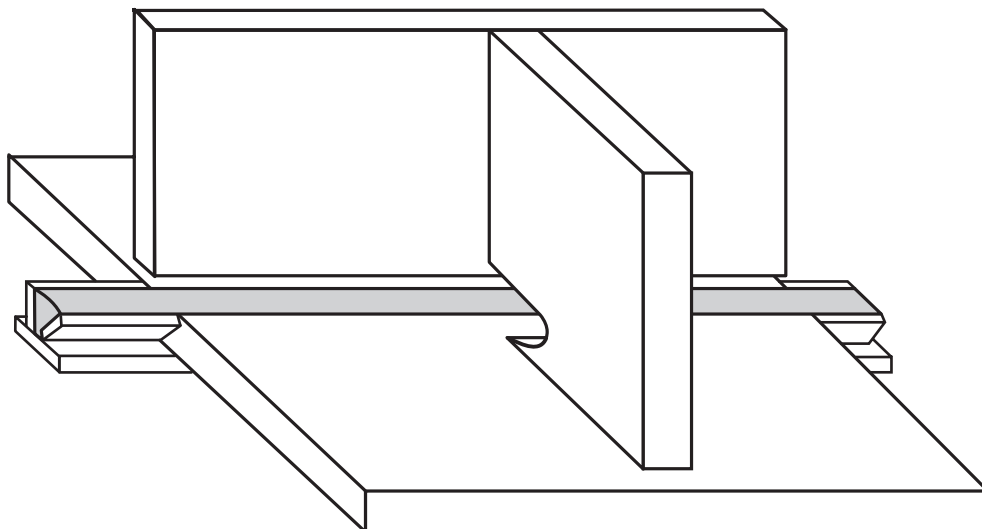


Notes:

1. The weld access hole dimensions are applicable for this test only.
2. Nonsteel backing type shall be as specified in WPS or shall be open root.
3. All groove dimensions shall be as specified in the WPS.
4. The test plates and column plate shall be same length, 12 in [300 mm] min.
5. The attachment plate may be of any size and dimension.
6. The column plate may be any thickness.

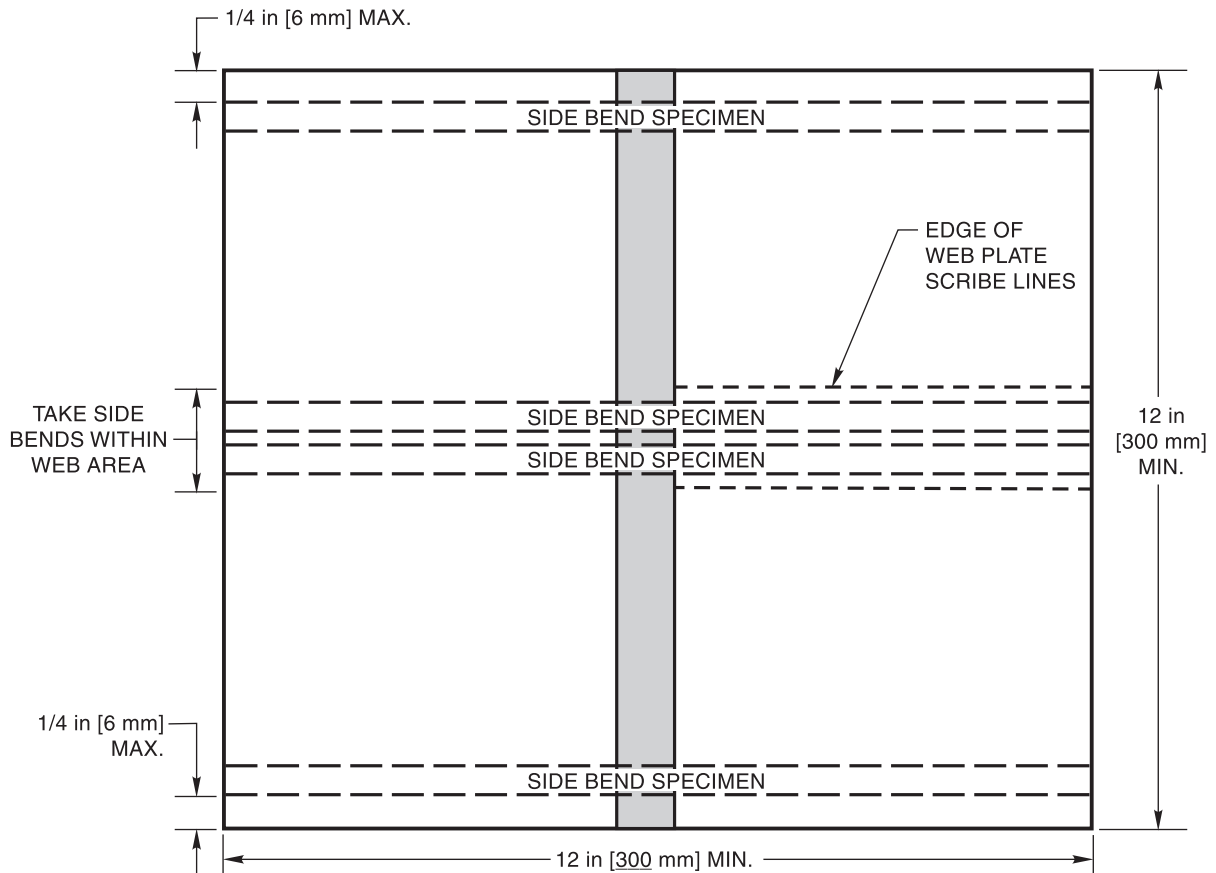
Figure D.2—Test Plate Configuration for Option B (see D2)



Notes:

1. The web location shall be marked on the test plates prior to disassembling the test configuration (see D3.1.4).
2. The web plate shall be centered on the test plate.

Figure D.3—Test Plate Configuration Illustration (see D2)



Notes:

1. See Annex D1, Figure D.1, and Figure D.2 for test assembly, groove detail, and test procedure requirements.
2. Test plates shall be a minimum of 1 in [25 mm] thick.
3. The web plate thickness area shall be 1 in [25 mm] thick. The web area shall be clearly marked on the plates before removal. Two side bend specimens shall be taken from within the web area; the entire width of each specimen shall be within the web area.
4. Side bends shall be 3/8 in [10 mm] thick. Testing shall be done in accordance with AWS D1.1/D1.1M subclause 4.8.3.1.
5. The two bend specimens taken near the ends of the welds shall be bent so that the side of the bend specimen that was nearest to the end of the weld becomes the convex side (sees the greatest tension).

**Figure D.4—Location of Side Bend Specimens on Test Plates—
Supplemental Welder Qualification (see D4.2.1.1)**