

## ERRATA SHEET

**AWS B2.1-1/8-229:2002, Standard Welding Procedure Specification (SWPS)  
for Gas Tungsten Arc Welding followed by Shielded Metal Arc Welding of  
Carbon Steel (M-1/P-1/S-1, Groups 1 or 2) to Austenitic Stainless Steel (M-8/P-  
8/S-8, Group 1), 1/8 through 1-1/2 inch thick, ER309(L) and E309(L) -15, -16,  
or -17, As-Welded Condition, Primarily Pipe Applications**

The following Errata have been identified and incorporated into the current reprint of this document.

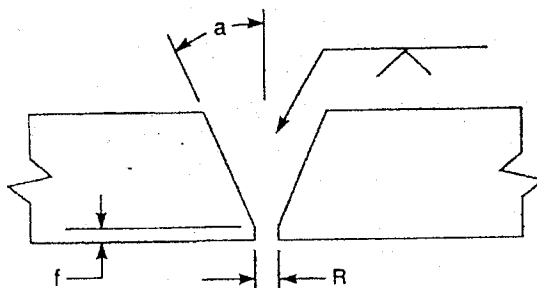
Cover Page – Title, change “ER309(L)-15, -16” to “E309(L)-15, -16”.

Page V -- Foreword, second paragraph, remove the following text from the last line “, which are available from the Welding Research Council.”.

Page 4 -- Electrical Characteristics Table, under GROOVE WELDS, delete the “R” from the last four entries under Filler Metal, Classification<sup>1</sup>, and change it from “ER309(L)-XX<sup>4</sup>, ER309(L)-XX, ER309(L)-XX, and ER309(L)-XX)” to read “E309(L)-XX<sup>4</sup>, E309(L)-XX, E309(L)-XX, and E309(L)-XX”.

Page 4 -- Electrical Characteristics Table, under FILLET WELDS and GROOVE WELDS on BACKING RINGS<sup>6</sup>, under Filler Metal, Classification<sup>1</sup>, delete the “R” from the last four entries under Filler Metal, Classification, and change it from “ER309(L)-XX<sup>4</sup>, ER309(L)-XX, ER309(L)-XX, and ER309(L)-XX)” to read “E309(L)-XX<sup>4</sup>, E309(L)-XX, E309(L)-XX, and E309(L)-XX”.

Page 6 -- Figure 1, JOINT 1, replace sketch with the one shown below:



$a = 30^\circ, +10^\circ, -0^\circ$   
 $f = 1/16 \text{ in.} \pm 1/32 \text{ in.}$   
 $R = 1/8 \text{ in.} \pm 1/16 \text{ in.}$   
I.D. MISMATCH = 1/16 in. MAX.