

Errata Sheet

AWS D14.6/D14.6M:2005, *Specification for Welding Rotating Elements of Equipment*

The following Erratum has been identified and incorporated into the current reprint of this document.

Page 38, Table 8: A note shall be added to “pipe” with the accompanying text and number printed below the table with the other notes. The text for the note shall be “Welding operators qualified to weld pipe or tubing over 24 in. (600 mm) in diameter or the test positions indicated.”

Table 8
Welder Qualification—Production Welding Positions Qualified by Plate and Pipe Test Welds

Qualification Test Weld	Plate or Pipe Position ⁽²⁾	Type of Weld and Position of Welding Qualified ⁽¹⁾			
		Plate		Pipe ⁽⁵⁾	
		Groove	Fillet ⁽³⁾	Groove	Fillet ⁽³⁾
Plate—groove	1G	F	F, H	F, H	F, H
	2G	F, H	F, H	F, H	F, H
	3G	F, H, V	F, H, V	F, H, V	F, H, V
	4G	F, OH	F, H, OH	F, H, OH	F, H, OH
	3G + 4G	All	All	All	All
Plate—fillet ⁽³⁾	1F		F		F
	2F		F, H		F, H
	3F		F, H, V		F, H, V
	4F		F, H, OH		F, H, OH
	3F + 4F		All		All
Pipe—groove	1G Rotated	F	F, H	F	F, H
	2G	F, H	F, H	F, H	F, H
	5G	F, V, OH	F, V, OH	F, V, OH	F, V, OH
	6G	Note (4)	Note (4)	Note (4)	Note (4)
	2G + 5G	Note (4)	Note (4)	Note (4)	Note (4)
	6GR	All	All	All	All
Pipe—fillet ⁽³⁾	1F Rotated		F		F
	2F		F, H		F, H
	2F Rotated		F, H		F, H
	4F		F, H, OH		F, H, OH
	5F		All		All

Notes:

- (1) Positions for welding: F = flat, H = horizontal, V = vertical, OH = overhead.
- (2) See Figures 2, 3A, 3B, 4, and 5.
- (3) Not applicable for fillet welds between parts having a dihedral angle of 75° or less.
- (4) Qualifies for all but groove welds for T-, Y-, and K- connections.
- (5) Welding operators qualified to weld pipe or tubing over 24 in. (600 mm) in diameter or the test positions indicated.