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Structural Welding Code— Sheet Steel



American Welding Society



Key Words — Sheet steel, allowable stresses, details of welded joints, workmanship qualification, visual acceptance criteria, stud welding

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Structural Welding Code— Sheet Steel

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Prepared by
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Approved by
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Abstract

This code covers the requirements associated with welding sheet steel having a minimum specified yield point no greater than 80 000 psi (550 MPa). The code requirements cover any welded joint made from the commonly used structural quality low-carbon hot rolled and cold rolled sheet and strip steel with or without zinc coating (galvanized). Section 1 includes general provisions, section 2 design, section 3 prequalification, section 4 qualification, section 5 fabrication, section 6 inspection, and section 7 stud welding.



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Table of Contents

	Page No.
<i>Personnel</i>	iii
<i>Foreword</i>	v
<i>Preface</i>	vi
<i>List of Tables</i>	xi
<i>List of Figures</i>	xii
1. General Provisions	1
1.1 Scope.....	1
1.1.1 Applicable Materials.....	1
1.1.2 General Stipulations.....	1
1.1.3 Approval.....	1
1.2 Sheet Steel Base Metal.....	1
1.2.1 Specified Base Metals.....	1
1.2.2 Other Base Metals.....	1
1.2.3 Minimum Yield Point.....	1
1.3 Welding Processes.....	1
1.3.1 Approved Processes.....	1
1.3.2 Stud Welding.....	2
1.3.3 Other Processes.....	2
1.4 Weld Metal Requirements.....	2
1.4.1 Matching Filler Metals.....	2
1.4.2 Other Base Metal–Filler Metal Combinations.....	2
1.4.3 Manufacturer’s Certification.....	2
1.4.4 Electrodes for Shielded Metal Arc Welding.....	2
1.4.4.1 AWS Specification.....	2
1.4.4.2 Low-Hydrogen Electrode Control.....	2
1.4.4.3 Melting Rate.....	2
1.4.5 Submerged Arc Welding.....	2
1.4.5.1 AWS Specification.....	2
1.4.5.2 Flux.....	2
1.4.6 Gas Metal Arc Welding, Flux Cored Arc Welding and Gas Tungsten Arc Welding Filler Metals.....	2
1.4.6.1 AWS Specification.....	2
1.4.6.2 Shielding Media.....	4
1.5 Weld Types.....	4
1.5.1 Square-Groove Welds in Butt Joints.....	4
1.5.2 Fillet Welds.....	4
1.5.2.1 Fillet Welds in Lap and T-joints.....	4
1.5.3 Flare-Groove Welds.....	4
1.5.4 Arc Spot Welds.....	4
1.5.5 Arc Seam Welds.....	4
1.5.6 Arc Plug Welds.....	4
1.6 Definitions.....	4
1.7 Welding Symbols.....	5
1.8 Safety Precautions.....	5
1.9 Standard Units of Measurement.....	5

2. Design of Welded Connections	6
Part A—Allowable Load Capacities	
2.1 Base-Metal Stresses	6
2.2 Allowable Load Capacities in Weld Joints	6
2.2.1 Square-Groove Welds in Butt Joints	6
2.2.2 Fillet Welds	6
2.2.3 Flare-Groove Welds	7
2.2.4 Arc Spot Welds	7
2.2.5 Arc Seam Welds	8
2.2.6 Arc Plug Welds	9
Part B—Details of Welded Connections	9
2.3.1 General	9
2.3.2 Square-Groove Welds	9
2.3.3 Fillet Welds	9
2.3.3.1 Minimum Length	9
2.3.3.2 Leg Sizes	9
2.3.4 Flare-Groove Welds	9
2.3.4.1 Single-Flare-Bevel-Groove Welds	9
2.3.4.2 Single-Flare-V-Groove Welds	9
2.3.5 Arc Spot Welds	9
2.3.5.1 Single or Double Thickness	9
2.3.5.2 Minimum Edge Distance	9
2.3.5.3 Weld Washers	9
2.3.6 Arc Seam Welds	9
2.3.6.1 Positions	9
2.3.6.2 Minimum Width	9
2.3.6.3 Minimum Edge Distance	9
2.3.7 Arc Plug Welds	12
2.3.7.1 Position and WPS Diameter	12
2.3.7.2 Minimum Hole Diameter	12
2.3.7.3 Minimum Edge Distance	12
3. Prequalification of WPSs	14
3.0 Scope	14
3.1 Joint Details	14
3.1.1 Requirements	14
3.1.1.1 Joints Meeting These Requirements	14
3.1.1.2 Joints Not Conforming To These Requirements	14
3.2 Details of Complete Joint Penetration Groove Welds	14
3.3 Details of Fillet Welds	14
3.4 Details of Flare-Groove Welds	14
3.5 Details of Flare-Bevel Lap Joints	14
4. Qualification	18
Part A—General Requirements	18
4.1 Preparation of a WPS and PQR	18
4.2 Engineer’s Approval	18
4.3 Responsibility	18
4.4 WPS Requirements	18
Part B—Welding Procedure Specification (WPS)	18
4.5 Essential Variable Limitations	18
4.6 Number of Tests, Testing Methods and Acceptance Standards for WPS Qualification	18
4.6.1 Square Groove Welds in Butt Joints	18

4.6.2	Fillet Welds	24
4.6.2.1	Qualification Test Requirements	24
4.6.2.2	Test Assemblies	24
4.6.2.3	Validity of Qualification	24
4.6.3	Flare-Groove Welds	24
4.6.3.1	Qualification Test Requirements	24
4.6.3.2	Qualification Ranges	26
4.6.4	Arc Spot Welds	26
4.6.4.1	Single or Double Thicknesses	26
4.6.4.2	SMAW Melting Rate	29
4.6.4.3	Qualification Ranges	29
4.6.4.4	Arc Seam Option	29
4.6.5	Arc Seam Welds	29
4.6.5.1	Single or Double Thicknesses for Sheet Steel to Supporting Member	29
4.6.5.2	Single Thicknesses for Sheet Steel to Sheet Steel	29
4.6.5.3	Testing and Examination	29
4.6.5.4	SMAW Melting Rate	29
4.6.5.5	Qualification Ranges	30
4.6.5.6	Arc Spot Option	30
4.6.6	Arc Plug Welds	30
4.6.6.1	Single or Multiple Thicknesses for Sheet Steel to Supporting Member	30
4.6.6.2	Multiple Thicknesses for Sheet Steel to Sheet Steel	30
4.6.6.3	Testing and Examination	32
4.6.6.4	Qualification Ranges	32
Part C	—Welder Performance Qualification	32
4.7	Essential Variables	32
4.7.1	General	32
4.7.1.1	Base Metals	32
4.7.1.2	Processes	32
4.7.1.3	SMAW Electrodes	32
4.7.1.4	Electrodes and Shielding Media	33
4.7.1.5	Position	33
4.7.1.6	Vertical Welding	33
4.7.2	Specific Conditions	33
4.8	Number of Tests and Methods for Welder Performance Qualification	33
4.8.1	General	33
4.8.1.1	WPS Status	33
4.8.1.2	Welder Qualification through WPS Qualification	33
4.8.1.3	Records	33
4.8.2	Specific Conditions	33
4.9	Duration of Qualification	33
5.	<i>Fabrication</i>	34
5.1	General	34
5.2	Preparation of Material	34
5.3	Assembly	34
5.3.1	Joint Detail Positions	34
5.3.2	Close Contact	34
5.4	Allowable Deviation from WPS for Lower Temperatures	34
5.4.1	Arc Spot Welds	34
5.4.2	Arc Seam Welds	34
5.4.3	Arc Plug Welds	34

6. Inspection	35
Part A—Acceptance Criteria	35
6.1 Production Weld Acceptance Criteria	35
6.1.1 Visual Inspection	35
6.1.1.1 No Cracks	35
6.1.1.2 Minimum Reinforcement	35
6.1.1.3 Undercut	35
6.1.1.4 Fillet Weld Face	35
6.1.1.5 Contract Document Conformance	35
Part B—Contractor’s Responsibility	35
6.2 Inspection of WPS and Welder Qualification	35
6.3 Inspection of Work	35
6.3.1 Requests	35
6.3.2 Work Quality	35
7. Stud Welding	36
Annex A—Sample Welding Forms	37
Annex B—Guidelines for Preparation of Technical Inquiries for the Structural Welding Committee	41
Annex C—Terms and Definitions	43
Annex D—Gage Numbers and Equivalent Thicknesses	47
Annex E—Safe Practices	49
<i>Commentary on Structural Welding Code—Sheet Steel</i>	53
C1. General Provisions	55
C1.1 Scope	55
C1.4.4.1 AWS Specification	55
C1.4.4.3 Melting Rate	55
C2. Design of Welded Connections	57
C2.2.2 Fillet Welds	57
C2.2.4 Arc Spot Welds	57
C4. Workmanship	60
C4.5 Essential Variable Limitations	60
C4.6.4 Arc Spot Welds	60
C5. Technique	61
C5.3.1 Joint Detail Positions	61
C5.4.1 and C5.4.2 Arc Spot and Arc Seam Welds	61

List of Tables

Table		Page No.
1.1	(5.1) Matching Filler Metal Requirements.....	3
1.2	(1.1) Welding Positions and Restrictions for WPS	4
4.1	(6.1) WPS Qualification Tests.....	19
4.2	(6.2) Welder Performance Qualification Tests	21
4.3	(New) PQR Essential Variable Changes Requiring WPS Requalification for SMAW, GMAW, FCAW, GTAW, and SAW	23
D1	(D1) Gage Numbers and Equivalent Thicknesses—Hot-Rolled and Cold-Rolled Sheet	47
D2	(D2) Gage Numbers and Equivalent Thicknesses—Galvanized Sheet	47

List of Figures

Figure	Page No.
2.1 (3.1) Square-Groove Welds in Butt Joints.....	7
2.2 (2.3) Fillet Welds.....	7
2.3A (2.4A) Single-Flare-Bevel-Groove Weld.....	7
2.3B (2.4B) Single-Shear in Flare-Groove Welds.....	8
2.3C (2.4C) Double-Shear in Flare-Groove Welds.....	8
2.4 (3.2A) Arc Spot Welds.....	10
2.5 (2.2) Arc Seam Welds.....	10
2.6 (New) Arc Plug Welds.....	11
2.7 (3.4A) Fillet Welds in Lap Joints.....	11
2.8 (3.4B) Fillet Welds in T-Joints.....	11
2.9 (3.5) Single-Flare-Bevel-Groove Weld.....	12
2.10 (3.6) Single-Flare-V-Groove Weld.....	12
2.11A (3.2C) Edge Distances for Arc Spot Welds.....	12
2.11B (3.2B) Arc Spot Weld Using Washer.....	12
2.11C (2.1) Typical Weld Washer.....	12
2.12 (3.3C) Arc Seam Welds Along Standing Rib.....	13
2.13A (3.3A) Edge Distances for Arc Seam Welds.....	13
2.13B (2.11A) Edge Distances for Arc Plug Welds.....	13
3.1A (New) Square Groove Weld in Butt Joint with Steel Backing.....	15
3.1B (New) Square Groove Weld in Butt or Corner Joint without Backing.....	15
3.2A (New) Fillet Weld in Corner Joint.....	15
3.2B (New) Fillet Weld in Lap Joint.....	16
3.2C (New) Fillet Weld in T-Joint.....	16
3.3A (New) Flare-Bevel-Groove Weld in Butt Joint.....	16
3.3B (New) Flare-Bevel-Groove Weld in Corner Joint.....	17
3.3C (New) Flare-V-Groove Weld in Butt Joint.....	17
3.3D (New) Flare-Bevel-Groove Weld in Lap Joint.....	17
4.1 (6.1) Test for Square-Groove Welds in Butt Joints.....	24
4.2A (6.4) Test for Fillet Welds.....	25
4.2B (6.5) Extent of Validity of Fillet Weld Qualifications.....	26
4.3A (6.6A) Test for Sheet to Sheet Flare-Bevel-Groove Welds.....	27
4.3B (6.6B) Test for Sheet to Supporting Structural Member Flare-Bevel-Groove Welds.....	27
4.3C (6.6C) Test for Flare-V-Groove Welds.....	28
4.3D (6.7) Extent of Validity of Flare-Groove Weld Qualifications.....	28
4.4 (6.2) Test for Arc Spot Welds.....	39
4.5A (6.3A) Test for Sheet to Supporting Structural Member Arc Seam Welds.....	30
4.5B (6.3B) Test for Sheet to Sheet Arc Seam Welds.....	30
4.6 (New) Test for Arc Plug Welds.....	31
 <i>Commentary:</i>	
C1 (C9) Melting Rate Measurement Illustrated.....	56
C2 (C6) Allowable Stress for Fillet Welds.....	57
C3 (C7) Load Capacity of Fillet Welds.....	58
C4 (C1) Arc Spot Welds.....	58
C5 (C5) Arc Seam Weld in a Supporting Plate.....	59
C6 (C8) Positions of Welding.....	62

Structural Welding Code—Sheet Steel

1. General Provisions

1.1 Scope

This welding code covers arc welding of structural sheet/strip steels, including cold formed members (hereafter collectively referred to as *sheet steel*) which are equal to or less than 3/16 in. (0.188 in./4.8 mm) in nominal thickness. See Annex D, Tables D1 and D2 for gage numbers and equivalent thicknesses.

Three weld types unique to sheet steel, arc spot, arc seam, and arc plug welds, are included in this code.

1.1.1 Applicable Materials. This code is applicable to the welding of structural sheet steels to other structural sheet steels or to supporting structural steel members.

1.1.2 General Stipulations. The fundamental premise of the code is to provide general stipulations applicable to any situation. Acceptance criteria for production welds different from those specified in the code shall be permitted for a particular application, provided they are suitably documented by the proposer and approved by the Engineer. These alternate acceptance criteria shall be based upon evaluation of suitability for service using past experience, experimental evidence, or engineering analysis considering material type, service load effects, and environmental factors.

1.1.3 Approval. All references to the need for approval shall be interpreted to mean approval by the Engineer, defined as the duly designated person who acts for and in behalf of the owner on all matters within the scope of this code. Deviations from code requirements shall require the Engineer's approval.

1.2 Sheet Steel Base Metal

1.2.1 Specified Base Metals. Sheet steel base metals to be welded under this code shall conform to the requirements of the latest edition of one of the specifications

listed below, or any sheet steel qualified in conformance with 1.2.2. Any combination of these steels may be welded together. These steels may also be welded to any of the steels listed in the latest edition of ANSI/AWS D1.1, *Structural Welding Code—Steel*.

(1) Specification for Sheet Steel, Zinc-Coated (Galvanized) by the Hot-Dip Process. Structural Physical Quality (A653 SQ Grades 33, 37, 40, and 80).

(2) Specification for Hot-Rolled Steel Sheet and Strip. Structural Quality (ASTM A570).

(3) Specification for Steel Sheet and Strip, Hot-Rolled and Cold-Rolled, High Strength, Low Alloy, with Improved Corrosion Resistance (ASTM A606).

(4) Specification for Steel Sheet and Strip, Hot-Rolled or Cold-Rolled, High Strength, Low Alloy Columbium or Vanadium, or both (ASTM A607 Grades 45, 50, 55, 60, 65, and 70).

(5) Specification for Steel, Cold-Rolled Sheet, Carbon Structural (ASTM A611).

1.2.2 Other Base Metals. When a steel other than those covered in 1.2.1 is approved under the provisions of the project or product specification, and such a steel is proposed for welded construction, the weldability of the steel and the WPS for welding it shall be established by qualification in conformance with the requirements of section 4 and such other requirements as prescribed by the Engineer.

1.2.3 Minimum Yield Point. The provisions of this code are intended for use with sheet steel having a minimum specified yield point equal to or less than 80 000 psi (550 MPa).

1.3 Welding Processes

1.3.1 Approved Processes. This code provides for welding with the shielded metal arc welding (SMAW), gas