

AWS D1.1/D1.1M:2020
An American National Standard



Structural Welding Code — Steel



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An American National Standard

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Structural Welding Code — Steel

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American Welding Society (AWS) D1 Committee on Structural Welding

Under the Direction of the
AWS Technical Activities Committee

Approved by the
AWS Board of Directors

Abstract

This code covers the welding requirements for any type of welded structure made from the commonly used carbon and low-alloy constructional steels. Clauses 1 through 11 constitute a body of rules for the regulation of welding in steel construction. There are eight normative and eleven informative annexes in this code. A Commentary of the code is included with the document.



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This standard is subject to revision at any time by the AWS D1 Committee on Structural Welding. It must be reviewed every five years, and if not revised, it must be either reaffirmed or withdrawn. Comments (recommendations, additions, or deletions) and any pertinent data that may be of use in improving this standard are requested and should be addressed to AWS Headquarters. Such comments will receive careful consideration by the AWS D1 Committee on Structural Welding and the author of the comments will be informed of the Committee's response to the comments. Guests are invited to attend all meetings of the AWS D1 Committee on Structural Welding to express their comments verbally. Procedures for appeal of an adverse decision concerning all such comments are provided in the Rules of Operation of the Technical Activities Committee. A copy of these Rules can be obtained from the American Welding Society, 8669 NW 36 St, # 130, Miami, FL 33166.

Foreword

This foreword is not part of AWS D1.1/D1.1M:2020, *Structural Welding Code—Steel*, but is included for informational purposes only.

The first edition of the *Code for Fusion Welding and Gas Cutting in Building Construction* was published by the American Welding Society in 1928 and called Code 1 Part A. It was revised in 1930 and 1937 under the same title. It was revised again in 1941 and given the designation D1.0. D1.0 was revised again in 1946, 1963, 1966, and 1969. The 1963 edition published an amended version in 1965, and the 1966 edition published an amended version in 1967. The code was combined with D2.0, *Specifications for Welding Highway and Railway Bridges*, in 1972, given the designation D1.1, and retitled *AWS Structural Welding Code*. D1.1 was revised again in 1975, 1979, 1980, 1981, 1982, 1983, 1984, 1985, 1986, 1988, 1990, 1992, 1994, 1996, 1998, 2000, 2002, 2004, 2006, 2008 and 2010. A second printing of D1.1:2010 was published in 2011. From 1972 to 1988, the D1.1 code covered the welding of both buildings and bridges.

In 1988, AWS published its first edition of AASHTO/AWS D1.5, *Bridge Welding Code*; coincident with this, the D1.1 code changed references of buildings and bridges to statically loaded and dynamically loaded structures, respectively, in order to make the document applicable to a broader range of structural applications. After the publishing of the 2010 edition, it was decided that the *AWS Structural Welding Code—Steel* would be published on a five year revision cycle instead of a two year revision cycle. This was done in order to sync the publication cycle of AWS Structural Welding Code-Steel with the publication cycles of the AISC Steel Building Specification and the International Building Code. This 2020 edition is the 24th edition of D1.1.

Changes in Code Requirements, underlined text in the clauses, subclauses, tables, figures, or forms indicates a change from the 2015 edition. A vertical line in the margin of a table or figure also indicates a change from the 2015 edition.

The following is a summary of the most significant technical changes contained in D1.1/D1.1M:2020:

Summary of Changes	
Clause/Table/Figure/Annex	Modification
Clause 1	
Clause 2	This is a new clause listing normative references. It replaces subclause 1.9 and Annex S from the previous edition.
Clause 3	This is a new clause that provides terms and definitions specific to this standard. It replaces subclause 1.3 and Annex J from the previous edition.
Clause 4	Clause 4 was presented as Clause 2 in the previous edition. Annex A Figures in the previous edition were incorporated into Clause 4.
Clause 5	Clause 5 was presented as Clause 3 in the previous edition. The Clause has also been restructured to follow the normal progression of writing a prequalified WPS. Table 5.2 has been editorially renamed and reorganized to list WPS essential variables. Additional requirements have been added when using shielding gases and a new Table 5.7 was added on shielding gases. New materials have been added to Tables 5.3 and 5.8.
Clause 6	Clause 6 was presented as Clause 4 in the previous edition. Revisions include the requirements for the qualification of WPSs using waveform technology. All the CVN testing requirements have been added to Table 6.7, so they now are all contained in a single place. The WPS retest requirements have been clarified. The PJP Groove weld clause has been reorganized to clarify the qualification of PJP Groove welds using the Joint Details in Figure 5.2. Part D of the Clause has been reorganized to better align the testing procedures and qualification of CVNs with the order that they would be accomplished.

(Continued)

Summary of Changes (Continued)

Clause/Table/Figure/Annex	Modification
Clause 7	Clause 7 was presented as Clause 5 in the previous edition. Revisions were made to the weld restoration of base metal with mislocated holes.
Clause 8	Clause 8 was presented as Clause 6 in the previous edition. Revisions were made to the qualification requirements for inspection personnel to ensure that all welding inspectors are qualified. The Engineer's responsibilities as it relates to Inspection were also clarified. Digital radiography has been added to Radiographic Testing. The limitations for geometric unsharpness have been added to the Code and the equation has been revised to match the equation in ASME <i>Boiler and Pressure Vessel Code</i> , Section V, Article 2. The methodology to determine the attenuation factor has been updated to reflect that UT instruments are now capable of reporting a fractional value for dB.
Clause 9	Clause 9 was presented as Clause 7 in the previous edition. The code was updated to require the manufacturer's permanent identification on headed studs and deformed anchor bars. Revisions were made to provide weld procedure requirements for fillet welding of studs.
Clause 10	Clause 10 was presented as Clause 9 in the previous edition. The calculations for static strength of welded tubular connections were removed in deference to AISC design provisions.
Clause 11	Clause 11 was presented as Clause 8 in the previous edition.
Annex A	Annex A was presented as Annex B in the previous edition.
Annex B	Annex B was presented as Annex H in the previous edition.
Annex D	Annex D was presented as Annex F in the previous edition.
Annex E	Annex E was presented as Annex D in the previous edition.
Annex F	Annex F was presented as Annex E in the previous edition.
Annex H	New Annex that addresses phased array ultrasonic testing (PAUT)
Annex J	Annex J was presented as Annex M in the previous edition.
Annex K	Annex K was presented as Annex P in the previous edition.
Annex L	Annex L was presented as Annex T in the previous edition.
Annex M	Annex M was presented as Annex U in the previous edition.
Annex N	Annex N was presented as Annex K in the previous edition.
Annex O	Annex O was presented as Annex Q in the previous edition.
Annex P	Annex P was presented as Annex L in the previous edition.
Annex Q	Annex Q was presented as Annex O in the previous edition.
Annex R	Annex R has been modified to contain preliminary design of circular tube connections previously contained in the Tubular Structures clause as well as ovalizing parameter alpha.
Annex T	Annex T was presented as Annex N in the previous edition.
C-Annex H	Commentary was added for Annex H

Commentary. The Commentary is nonmandatory and is intended only to provide insightful information into provision rationale.

Normative Annexes. These annexes address specific subjects in the code and their requirements are mandatory requirements that supplement the code provisions.

Informative Annexes. These annexes are not code requirements but are provided to clarify code provisions by showing examples, providing information, or suggesting alternative good practices.

Index. As in previous codes, the entries in the Index are referred to by subclause number rather than by page number. This should enable the user of the Index to locate a particular item of interest in minimum time.

(Continued)

Errata. It is the Structural Welding Committee's Policy that all errata should be made available to users of the code. Therefore, any significant errata will be published in the Society News Section of the *Welding Journal* and posted on the AWS web site at: <http://www.aws.org/standards/page/errata>.

Suggestions. Your comments for improving AWS D1.1/D1.1M:2015, *Structural Welding Code—Steel* are welcome. Submit comments to the Secretary of the D1Q Subcommittee, American Welding Society, 8669 NW 36 St, # 130, Miami, FL 33166.

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Structural Welding Code—Steel

1. General Requirements

1.1 Scope

This code contains the requirements for fabricating and erecting welded steel structures. When this code is stipulated in contract documents, conformance with all provisions of the code shall be required, except for those provisions that the Engineer (see 1.5.1) or contract documents specifically modifies or exempts.

The following is a summary of the code clauses:

1. General Requirements. This clause contains basic information on the scope and limitations of the code, key definitions, and the major responsibilities of the parties involved with steel fabrication.

2. Normative References. This clause contains a list of reference documents that assist the user in implementation of this code or are required for implementation.

3. Terms and Definitions. This clause contains terms and definitions as they relate to this code.

4. Design of Welded Connections. This clause contains requirements for the design of welded connections composed of tubular, or nontubular, product form members.

5. Prequalification of WPSs. This clause contains the requirements for exempting a Welding Procedure Specification (WPS) from the WPS qualification requirements of this code.

6. Qualification. This clause contains the requirements for WPS qualification and the performance qualification tests required to be passed by all welding personnel (welders, welding operators, and tack welders) to perform welding in accordance with this code.

7. Fabrication. This clause contains general fabrication and erection requirements applicable to welded steel structures governed by this code, including the requirements for base metals, welding consumables, welding technique, welded details, material preparation and assembly, workmanship, weld repair, and other requirements.

8. Inspection. This clause contains criteria for the qualifications and responsibilities of inspectors, acceptance criteria for production welds, and standard procedures for performing visual inspection and nondestructive testing (NDT).

9. Stud Welding. This clause contains the requirements for the welding of studs to structural steel.

10. Tubular Structures. This clause contains exclusive tubular requirements. Additionally, the requirements of all other clauses apply to tubulars, unless specifically noted otherwise.

11. Strengthening and Repair of Existing Structures. This clause contains basic information pertinent to the welded modification or repair of existing steel structures.

1.2 Standard Units of Measurement

This standard makes use of both U.S. Customary Units and the International System of Units (SI). The latter are shown within brackets ([]) or in appropriate columns in tables and figures. The measurements may not be exact equivalents; therefore, each system must be used independently.

1.3 Safety Precautions

Safety and health issues and concerns are beyond the scope of this standard and therefore are not fully addressed herein. It is the responsibility of the user to establish appropriate safety and health practices. Safety and health information is available from the following sources:

American Welding Society:

- (1) ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*
- (2) AWS Safety and Health Fact Sheets
- (3) Other safety and health information on the AWS website

Material or Equipment Manufacturers:

- (1) Safety Data Sheets supplied by materials manufacturers
- (2) Operating Manuals supplied by equipment manufacturers

Applicable Regulatory Agencies

Work performed in accordance with this standard may involve the use of materials that have been deemed hazardous, and may involve operations or equipment that may cause injury or death. This standard does not purport to address all safety and health risks that may be encountered. The user of this standard should establish an appropriate safety program to address such risks as well as to meet applicable regulatory requirements. ANSI Z49.1 should be considered when developing the safety program.

1.4 Limitations

The code was specifically developed for welded steel structures that utilize carbon or low alloy steels that are 1/8 in [3 mm] or thicker with a minimum specified yield strength of 100 ksi [690 MPa] or less. The code may be suitable to govern structural fabrications outside the scope of the intended purpose. However, the Engineer should evaluate such suitability, and based upon such evaluations, incorporate into contract documents any necessary changes to code requirements to address the specific requirements of the application that is outside the scope of the code. The Structural Welding Committee encourages the Engineer to consider the applicability of other AWS D1 codes for applications involving aluminum (AWS D1.2), sheet steel equal to or less than 3/16 in [5 mm] thick (AWS D1.3), reinforcing steel (AWS D1.4), stainless steel (AWS D1.6), strengthening and repair of existing structures (AWS D1.7), seismic supplement (AWS D1.8), and titanium (AWS D1.9). The AASHTO/AWS D1.5 *Bridge Welding Code* was specifically developed for welding highway bridge components and is recommended for those applications.

1.5 Responsibilities

1.5.1 Engineer's Responsibilities. The Engineer shall be responsible for the development of the contract documents that govern products or structural assemblies produced under this code. The Engineer may add to, delete from, or otherwise modify, the requirements of this code to meet the particular requirements of a specific structure. All requirements that modify this code shall be incorporated into contract documents. The Engineer shall determine the suitability of all joint details to be used in a welded assembly.

The Engineer shall specify in contract documents, as necessary, and as applicable, the following:

- (1) Code requirements that are applicable only when specified by the Engineer.
- (2) All additional NDT that is not specifically addressed in the code.
- (3) Extent of verification inspection, when required.
- (4) Weld acceptance criteria other than that specified in Clause 8.
- (5) CVN toughness criteria for weld metal, base metal, and/or HAZ when required.
- (6) For nontubular applications, whether the structure is statically or cyclically loaded.

- (7) Which welded joints are loaded in tension.
- (8) All additional requirements that are not specifically addressed in the code.
- (9) For OEM applications, the responsibilities of the parties involved.

1.5.2 Contractor’s Responsibilities. The Contractor shall be responsible for WPSs, qualification of welding personnel, the Contractor’s inspection, and performing work in conformance with the requirements of this code and contract documents.

1.5.3 Inspector’s Responsibilities

1.5.3.1 Contractor Inspection. Contractor inspection shall be supplied by the Contractor and shall be performed as necessary to ensure that materials and workmanship meet the requirements of the contract documents.

1.5.3.2 Verification Inspection. The Engineer shall determine if Verification Inspection shall be performed. Responsibilities for Verification Inspection shall be established between the Engineer and the Verification Inspector.

1.6 Approval

All references to the need for approval shall be interpreted to mean approval by the Authority Having Jurisdiction or the Engineer.

1.7 Mandatory and Nonmandatory Provisions

1.7.1 Code Terms “Shall,” “Should,” and “May.” “Shall,” “should,” and “may” have the following significance:

1.7.1.1 Shall. Code provisions that use “shall” are mandatory unless specifically modified in contract documents by the Engineer.

1.7.1.2 Should. The word “should” is used to recommend practices that are considered beneficial, but are not requirements.

1.7.1.3 May. The word “may” in a provision allows the use of optional procedures or practices that can be used as an alternative or supplement to code requirements. Those optional procedures that require the Engineer’s approval shall either be specified in the contract documents, or require the Engineer’s approval. The Contractor may use any option without the Engineer’s approval when the code does not specify that the Engineer’s approval shall be required.

1.8 Welding Symbols

Welding symbols shall be those shown in AWS A2.4, *Standard Symbols for Welding, Brazing, and Nondestructive Examination*. Special conditions shall be fully explained by added notes or details.