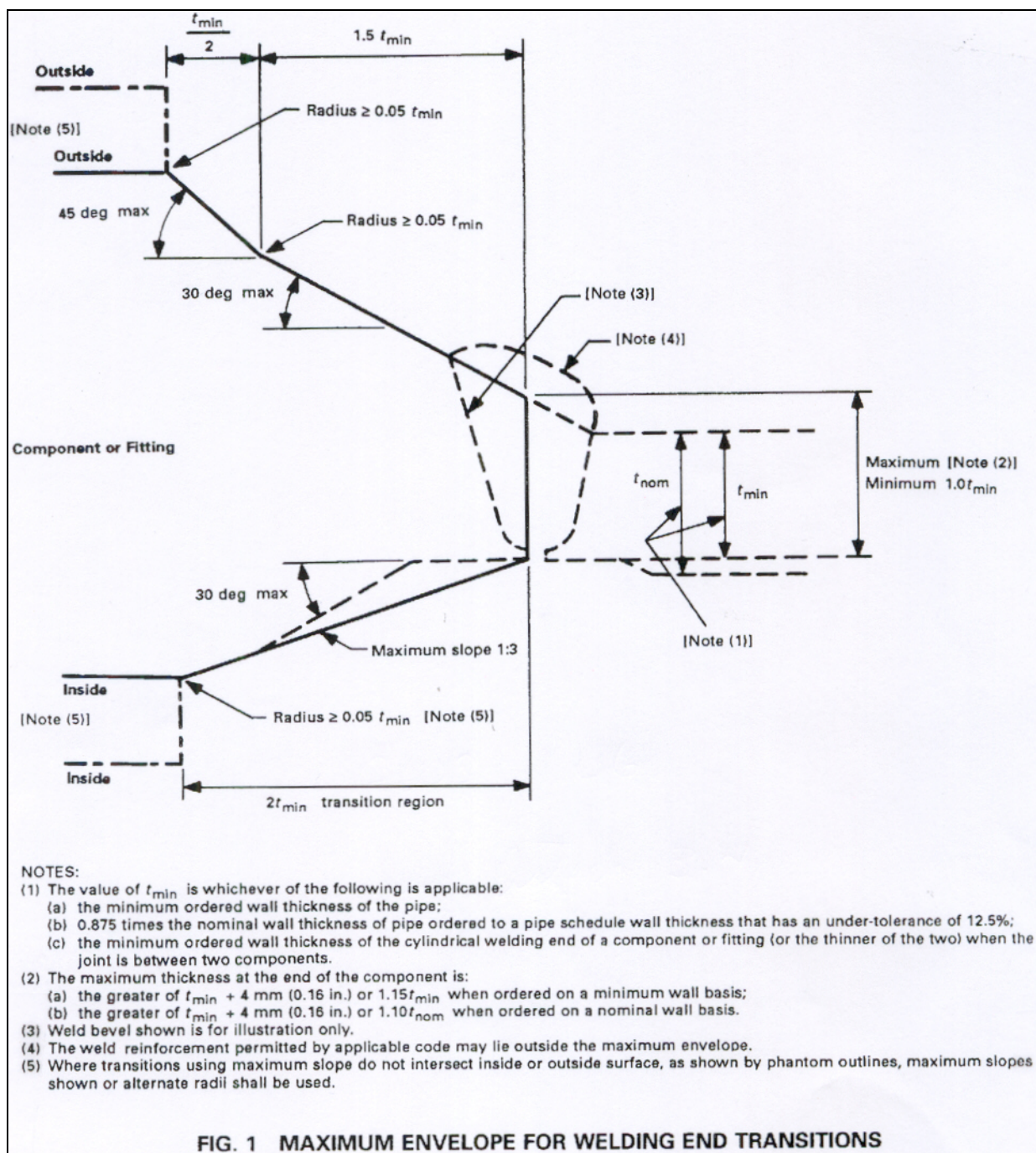
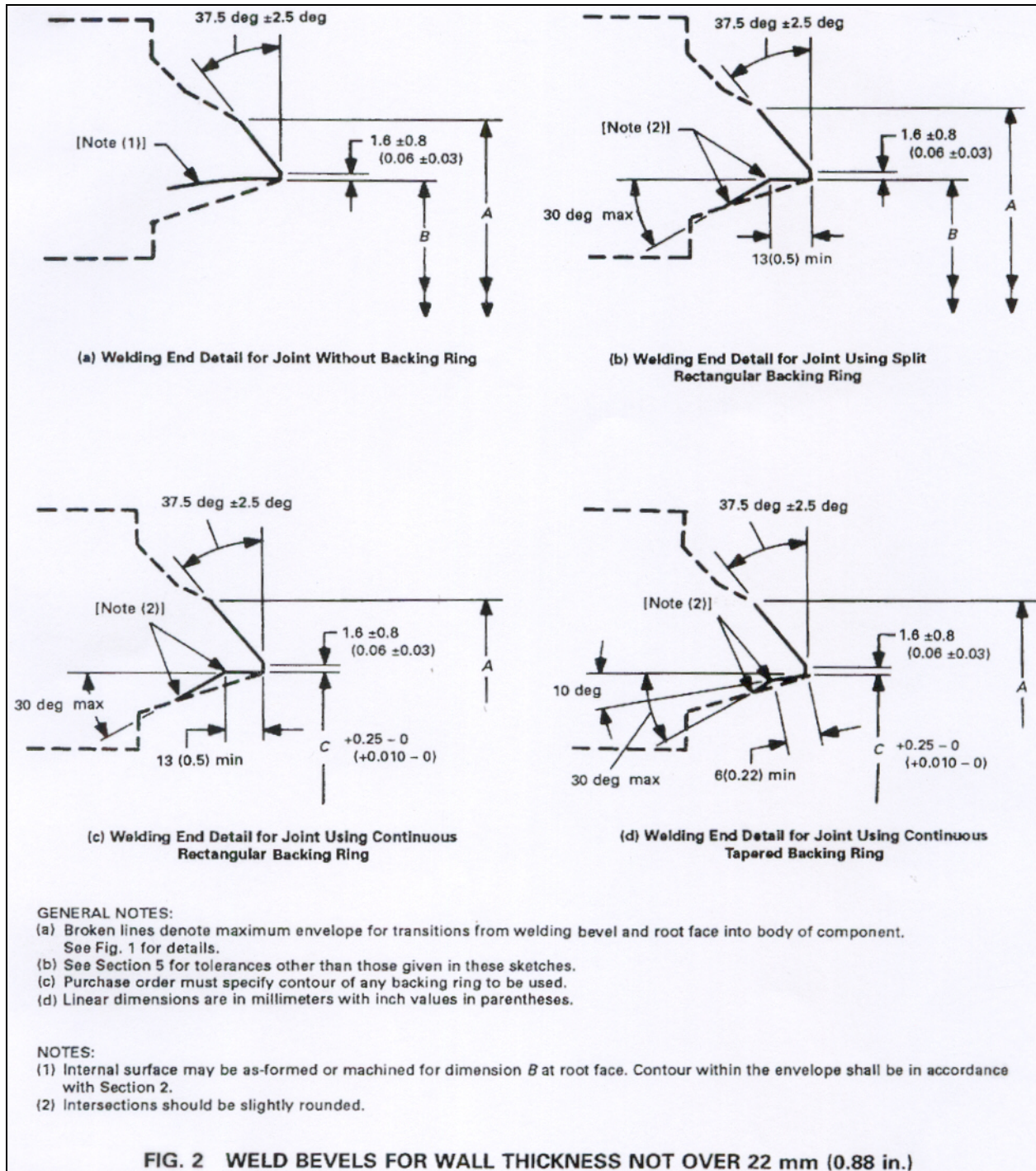
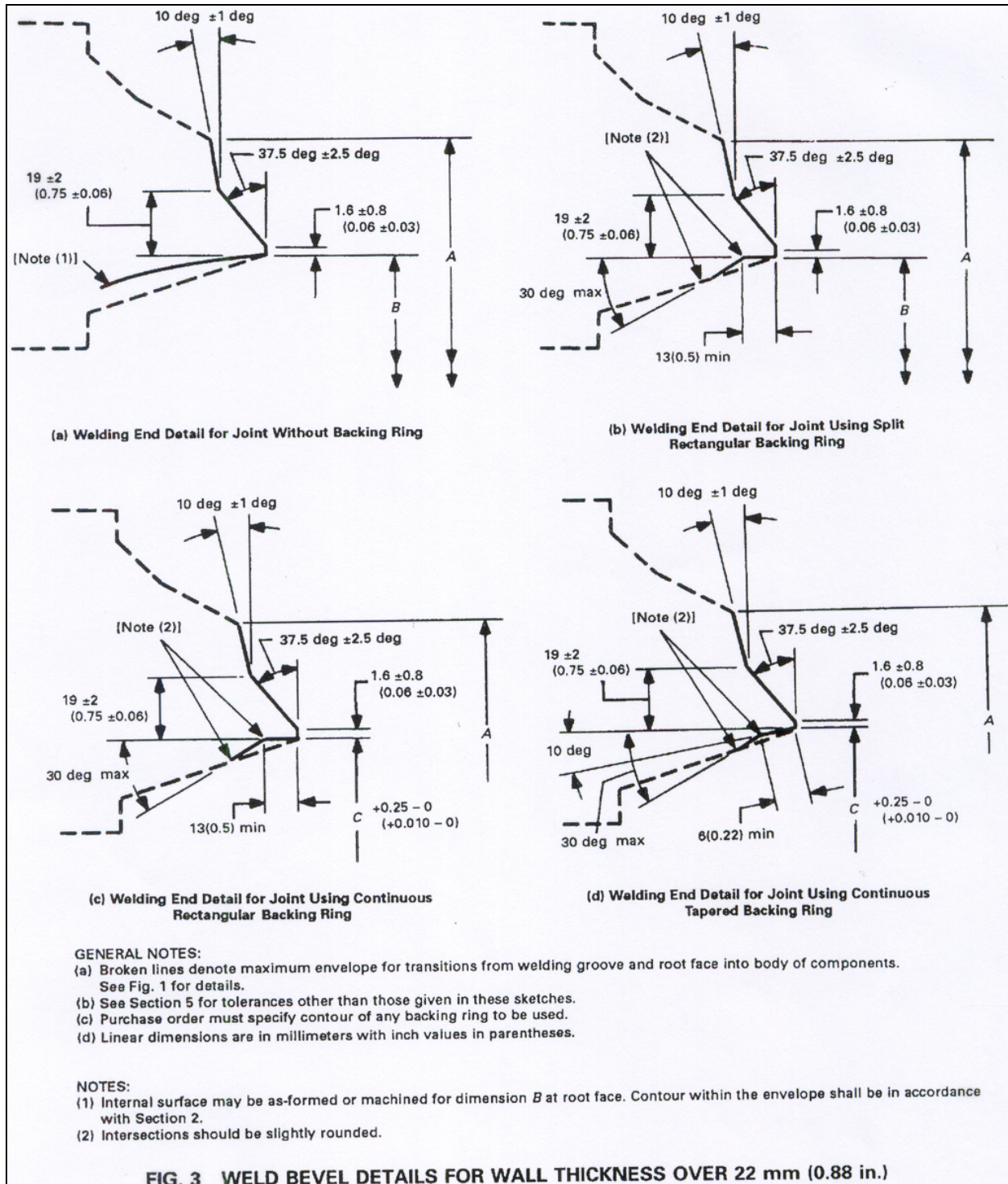
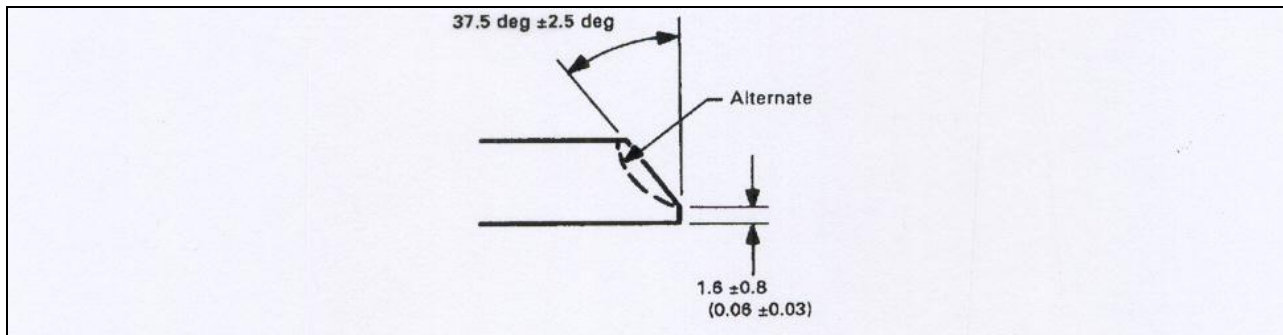


Pipe End Prep Details





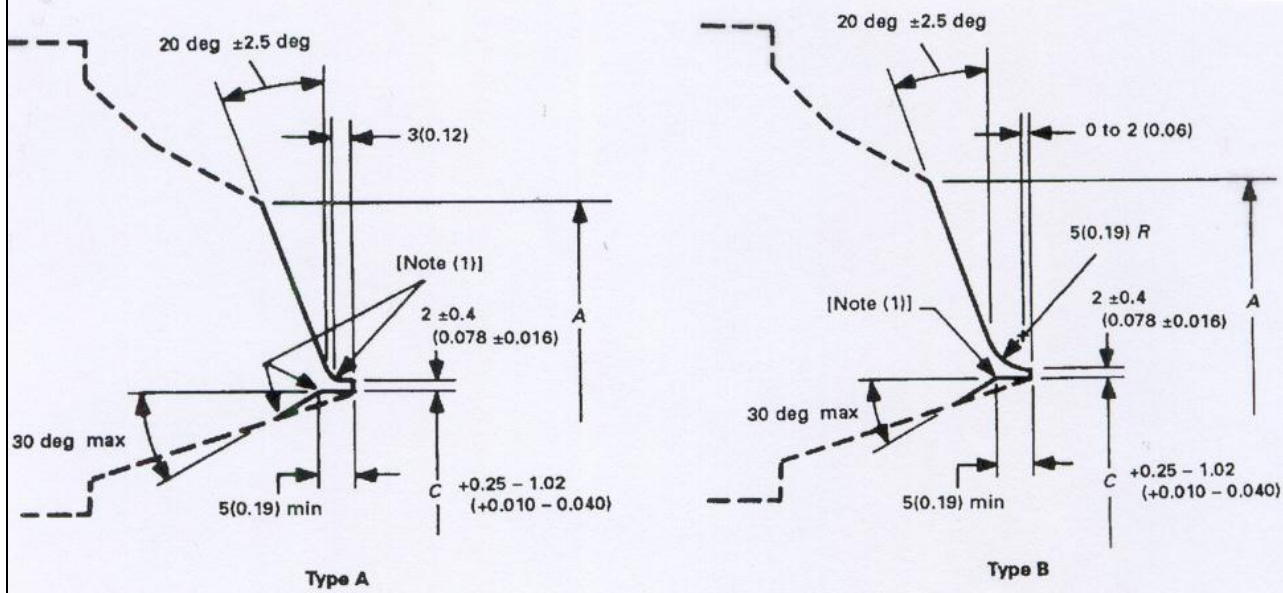




**GENERAL NOTES:**

- (a) This detail applies for gas tungsten arc welding (GTAW) of the root pass where nominal wall thickness is over 3 mm (0.12 in.) to 10 mm (0.38 in.) inclusive.
- (b) Linear dimensions are in millimeters with inch values in parentheses.

**FIG. 4 WELD BEVEL DETAILS FOR GTAW ROOT PASS**  
**[Wall Thickness Over 3 mm (0.12 in.) to 10 mm (0.38 in.), Inclusive]**



**GENERAL NOTES:**

- (a) This detail applies for gas tungsten arc welding (GTAW) of the root pass where nominal wall thickness is over 10 mm (0.38 in.) to 25 mm (1.0 in.) inclusive.
- (b) Broken lines denote maximum envelope for transitions from welding groove and land into body of component. See Fig. 1 for details.
- (c) See Section 5 for tolerances other than those given in these sketches.
- (d) Linear dimensions are in millimeters with inch values in parentheses.

**NOTE:**

- (1) Inside corners should be slightly rounded.

**FIG. 5 WELD BEVEL DETAILS FOR GTAW ROOT PASS**  
**[Wall Thickness Over 10 mm (0.38 in.) to 25 mm (1.0 in.), Inclusive]**

