NOTES:
1. The value of $f_{\text{min}}$ is whichever of the following is applicable:
   (a) the minimum ordered wall thickness of the pipe;
   (b) 0.875 times the nominal wall thickness of pipe ordered to a pipe schedule wall thickness that has an under-tolerance of 12.5%;
   (c) the minimum ordered wall thickness of the cylindrical welding end of a component or fitting (or the thinner of the two) when the joint is between two components.
2. The maximum thickness at the end of the component is:
   (a) the greater of $f_{\text{min}} + 4$ mm (0.16 in.) or $1.15f_{\text{nom}}$ when ordered on a minimum wall basis;
   (b) the greater of $f_{\text{min}} + 4$ mm (0.16 in.) or $1.19f_{\text{nom}}$ when ordered on a nominal wall basis.
3. Weld bevel shown is for illustration only.
4. The weld reinforcement permitted by applicable code may lie outside the maximum envelope.
5. Where transitions using maximum slope do not intersect inside or outside surface, as shown by phantom outlines, maximum slopes shown or alternate radii shall be used.

**FIG. 1** MAXIMUM ENVELOPE FOR WELDING END TRANSITIONS
FIG. 2 WELD BEVELS FOR WALL THICKNESS NOT OVER 22 mm (0.88 in.)
FIG. 3 WELD BEVEL DETAILS FOR WALL THICKNESS OVER 22 mm (0.88 in.)
FIG. 4 WELD BEVEL DETAILS FOR GTAW ROOT PASS
[Wall Thickness Over 3 mm (0.12 in.) to 10 mm (0.38 in.), Inclusive]

FIG. 5 WELD BEVEL DETAILS FOR GTAW ROOT PASS
[Wall Thickness Over 10 mm (0.38 in.) to 25 mm (1.0 in.), Inclusive]
FIG. 6 WELD BEVEL DETAILS FOR GTAW ROOT PASS  
[Wall Thickness Over 25 mm (1.0 in.)]

GENERAL NOTES:
(a) This detail applies for gas tungsten arc welding (GTAW) of root pass where nominal wall thickness is greater than 25 mm (1.0 in.).
(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.