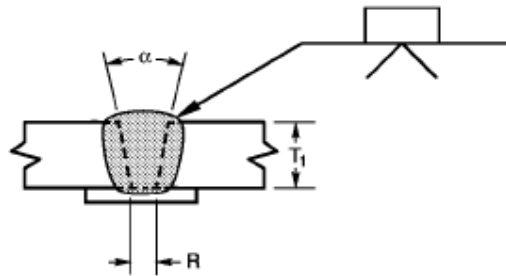


Single-V-groove weld (2)
Butt joint (B)



ALL DIMENSIONS IN mm

Tolerances

As Detailed (see 3.13.1)	As Fit-Up (see 3.13.1)
R = +2, -0	+6, -2
$\alpha = +10^\circ, -0^\circ$	$+10^\circ, -5^\circ$

Welding Process	Joint Designation	Base Metal Thickness (U = unlimited)		Groove Preparation		Allowed Welding Positions	Gas Shielding for FCAW	Notes
		T ₁	T ₂	Root Opening	Groove Angle			
SMAW	B-U2a	U	—	R = 6	$\alpha = 45^\circ$	All	—	5, 10
				R = 10	$\alpha = 30^\circ$	F, V, OH	—	5, 10
				R = 12	$\alpha = 20^\circ$	F, V, OH	—	5, 10
GMAW FCAW	B-U2a-GF	U	—	R = 5	$\alpha = 30^\circ$	F, V, OH	Required	1, 10
				R = 10	$\alpha = 30^\circ$	F, V, OH	Not req.	1, 10
				R = 6	$\alpha = 45^\circ$	F, V, OH	Not req.	1, 10
SAW	B-L2a-S	50 max	—	R = 6	$\alpha = 30^\circ$	F	—	10
SAW	B-U2-S	U	—	R = 16	$\alpha = 20^\circ$	F	—	10