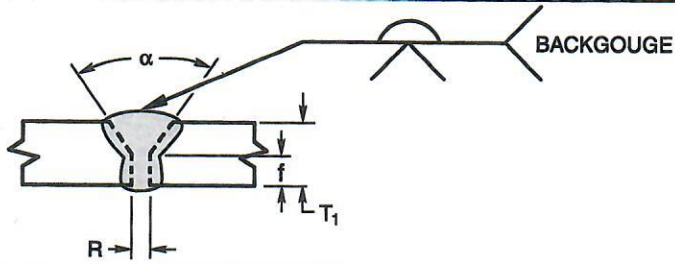


Single-V-groove weld (2)
Butt joint (B)



Welding Process	Joint Designation	Base Metal Thickness (U – unlimited)		Groove Preparation			Allowed Welding Positions	Gas Shielding for FCAW
		T_1	T_2	Root Opening Root Face Groove Angle	Tolerances			
					As Detailed (see 5.4.1.1)	As Fit-Up (see 5.4.1.8)		
SMAW	B-U2	U	—	$R = 0$ to $1/8$ $f = 0$ to $1/8$ $\alpha = 60^\circ$	$+1/16, -0$ $+1/16, -0$ $+10^\circ, -0^\circ$	$+1/16, -1/8$ Not limited $+10^\circ, -5^\circ$	All	—
GMAW FCAW	B-U2-GF	U	—	$R = 0$ to $1/8$ $f = 0$ to $1/8$ $\alpha = 60^\circ$	$+1/16, -0$ $+1/16, -0$ $+10^\circ, -0^\circ$	$+1/16, -1/8$ Not limited $+10^\circ, -5^\circ$	All	Not required