American Welding Society®

AWS Errata Sheet

The following Errata have been identified in AWS D1.1/D1.1M:2025, *Structural Welding Code-Steel* and will be incorporated into the next edition.

Page 5, ASTM 2339, title: change “ASTM 2339” to “ASTM E2339”

Page 5, ASTM 2339, title: change “Nodestructive” to “Nondestructive”

Page 19, 4.5.2: move “4.5.2 Fillet Welds” from the bottom of page 19 to the top of page 20

Page 23, 4.7.3.2, 1st sentence: hyphenate “in plane”

Page 62, list: add a hard return after “Part A – WPS Development” so that “Part B – Base Metal” is a separate line

Page 64, 5.4.4: add a period after the title and change “4.4.5.1, 4.4.5.2, 4.4.5.4, and 4.10” to “4.5.5.1, 4.5.5.2, 4.5.5.4, and 4.11”

Page 65, 5.6.2: Change the parenthesis around “(70 MPa)” to brackets

Page 66, 5.6.4(4), 1st sentence: add “with the shielding gas” after “combination”

Page 68, Table 5.1, column *Requirement*, 1st row: change “[0.8 mm]” to “[8 mm]”

Page 68, Table 5.1, column *Exceptions*, last row: change “5.6.2” to “5.6.3”

Page 69, Table 5.2, column *Exceptions*, 5th row: change “5.6.2” to “5.6.3”

Page 70, Table 5.3, column *Exceptions*, 6th row: change “5.6.2” to “5.6.3”

Page 70, Table 5.3, column *Position*, 9th and 10th row: insert horizontal dividing lines between each position

Page 71, Table 5.4, column *Exceptions*, 5th row: change “5.6.2” to “5.6.3” and add a period to the end of the sentence

Pages 76-77, Table 5.7, column *WELDING PROCESS(ES)*, subheading *SAW*, subheading *A5.23[c], Low-Alloy Steel*: delete superscript “c”

Page 88, Figure 5.1, column *Groove Preparation*, subheading *Root Opening Root Face Groove Angle*, last row: change “f – 5/8 max.” to “f = 5/8 max.”

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Page 79, Table 5.7, note 3: change “4.6” to “10.2”

Page 85, Legend for Figures 5.1, 5.2 and 5.3, Symbol for weld types: change “12 – flare weld” to “12 – fillet weld”

Page 122, Figure 5.2, column *Root Opening Root Face Bend Radius*, all 3 rows: change all 3 instances of “$r = \frac{3T_1}{4}\ min.$” to “$r = \frac{3T_1}{2}\ min.$”

Page 138, 6.17.3, last sentence: change “6.16.1 and 6.16.2” to “6.17.1 and 6.17.2”

Page 138, 6.18.1.1, 1st sentence: change “6.17.1(2)” to “6.18.1(2)”

Page 138, 6.18.1.2, last sentence: change “6.9 or 6.10” to “6.8 or 6.9”

Page 139, 6.22, 1st sentence: change “6.12” to “6.11”

Page 143, 6.27.7, 1st sentence: change “engineer to “Engineer”

Page 145, Table 6.1, column Qualification Test, subheading Weld Type, 3rd row: delete superscript and comma “a,” after “fillet”

Page 148, Table 6.5, column *Test Coupon*, 1st row: change “6.16” to “6.17”

Page 150, Table 6.6, essential variable (17): delete superscript “[d]” after “speed”

Page 154, Table 6.8, (2)(a): delete “less than” before “1/4 in [6 mm]”

Page 160, Table 6.11, column *Qualification Test*, subheading *Weld Type*, 1st row: delete superscript “[g]” after “Groove”

Page 160, Table 6.11, footnote d: change “6.22 and 10.19” to “Tables 6.12 and 10.12”

Page 180, Figure 6.17, Note 2: change “6.6” to “6.5”

Page 194, 7.3.1.2, 2nd sentence: change “A5.32/A5.32M” to “A5.32M/A5.32”

Page 207, 7.22.11: bold title, “Tolerance on Stiffeners”

Page 208, 7.23: change “10.15” to “10.14”

Page 224, 8.1.4.5 (4): underline “NDT,” “VT,” “the company’s written practice developed in accordance with,” and “Testing”

Page 231, 8.17.1, 4th line: change “10.16, and 10.17” to “10.15, and 10.16”

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Page 235, 8.19.1, 2nd sentence: change “Annex O” to “Annex N”

Page 235, 8.19.2, 1st sentence: change “Annex O” to “Annex N”

Page 244, 8.32, 1st sentence: delete “or Clause 8” before “or Part F of Clause 10”

Page 255, Figure 8.1, note 3: change “253” to “254”

Page 293, 10.5.3, 1st sentence: change “4.4.1.5” to “4.5.1.5”

Page 294, 10.5.4: delete the last 4 lines in italics

Page 297, 10.14.4.1, 1st sentence: change “Table 10.8” to “Tables 10.8 and 10.9”

Page 298, 10.16.1, 2nd paragraph, 1st sentence: change “10.8” with “10.12”

Page 299, 10.18, 1st sentence: change “Table 10.8” to “Tables 10.8 and 10.12”

Page 306, Table 10.2, column *Allowable Stress Design (ASD)*, subheading *Allowable Stress*, 6th row: change superscript “e” to superscript “d”

Page 307, Table 10.2, footnotes: change superscript “e” to superscript “d”

Page 307, Table 10.2, footnote d: change “4.6.4.2 and 4.6.4.3” to “4.7.3.2 and 4.7.3.3”

Page 313, Table 10.8, column *Production Pipe Welding Qualified*, subheading *Butt Joint*: change “PJP[b,c]” to “CJP[b,c]”

Page 313, Table 10.8, column *Production Pipe Welding Qualified*, subheading *T-, Y-, K-Connections*[c,d]: delete comma before superscript “d”

Page 313, Table 10.8, column *Production Box Tubing Welding Qualified*, subheading *T-, Y-, K-Connections*[d], subheading *PJP*, 2nd row: change “F, H, V, OH” to “F, H”

Page 313, Table 10.8, column *Production Box Tubing Welding Qualified*, subheading *T-, Y-, K-Connections*[d], subheading *Fillet*, 2nd row: replace blank cell with “F, H”

Page 313, Table 10.8, column *Qualification Test*, subheading *Test Positions*[a], 6th row: change superscript “j” to superscript “e”

Page 313, Table 10.8, column *Qualification Test*, subheading *Test Positions*[a], 8th row: change “10.22” to “10.21”

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Page 317, Table 10.12, 13th row under table title, *Box Groove (Fig. 10.20)*[j], 6th column: change Nominal Pipe Size Qualified Min. from "24" to "4"

Page 317, Table 10.12, 13th row under table title, *Box Groove (Fig. 10.20)*[j], 8th column: change Nominal Pipe Size Qualified Max. from "4" to "24"

Page 317, Table 10.12, footnote a: change "See Table 10.11 for appropriate groove details." to "See Table 10.8 for qualified groove position details."

Page 318, Table 10.12, 13th row under table title, *Box Groove (Fig. 10.20)*[j], 6th column: change Nominal Pipe Size Qualified Min. from "610" to "100"

Page 318, Table 10.12, 13th row under table title, *Box Groove (Fig. 10.20)*[j], 8th column: change Nominal Pipe Size Qualified Max. from "100" to "610"

Page 318, Table 10.12, footnote a: change "See Table 10.11 for appropriate groove details." to "See Table 10.8 for qualified groove position details."

Page 361, Table B.2, 1st heading under table title: change "Minimum Preheat an Interpass Temperature (°F)[a]" to "Minimum Preheat and Interpass Temperature (°F)[a]"

Page 362, Table B.2 (Continued), 1st heading under table title: change "Minimum Preheat an Interpass Temperature (°F)[a]" to "Minimum Preheat and Interpass Temperature (°F)[a]"

Page 390, H5.7.2, last paragraph, 1st sentence: change "sensitivty" to "sensitivity"

Page 392, H7.4.5: add "that" after "configurations"

Page 404, 5th line, meaning for the symbol H: hyphenate "in plane"

Page 408, Index of Forms, page numbers: change numbering from "405" to "409," "411" to "415," "416" to "420," "417" to "421," "419" to "423," "421" to "425," "422" to "426," and "423" to "427"

Page 429, Annex K, subclauses, left column: change "4.4.1.4" to "4.5.1.4," "4.4.4.2" to "4.5.4.2," and "4.4.3" to "4.5.3"

Page 445, N2., 3rd line: delete "the" before "shipbuilding"

Page 449, N10.4, 2nd sentence: change "in regards" to "with regard"

Page 462, Form O-8, 2nd to last line: insert space in between "Form" and "O-9"

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Page 463, Form O-8, SUPPLEMENTAL INSTRUCTIONS, numbered list: change numbering from “9-16” to “1-8”

Page 477, Q2., 3rd sentence: change “Figure R.2” to “Figure Q.2”

Page 478, Q3.1, 3rd paragraph, last sentence: change “Figure R.3” to “Figure Q.3”

Page 483, Annex R: delete “American Institute of Steel Construction (AISC) standard: ANSI/AISC 360, *Specification for Structural Steel Buildings*”

Page 501, 3rd line from the top of the page: change “4.6.3” to “4.7.3”

Page 501, C-4.7.3.3, 1st paragraph, last sentence: change “elements” to “element’s”

Page 501, C-4.7.3.3, 2nd paragraph, 1st sentence: hyphenate “in plane”

Page 531, C-7.3.2.1, 4th paragraph, 6th line: delete hyphen and space from “depos- its”

Page 531, C-7.3.2.1, 4th paragraph, last sentence: delete space from “low- hydrogen”

Page 532, C-7.3.2.1, 6th line from the top of the page: delete hyphen and space from “accept- able”

Page 534, C-7.8.2, last sentence: change “Figure C-7.X” to “Figure C-7.9”

Page 536, C-7.14.2, title: change “Mill-Induced” to “Base Metal”

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Page 546, after Figure C-7.8: add Figure C-7.9 as follows:

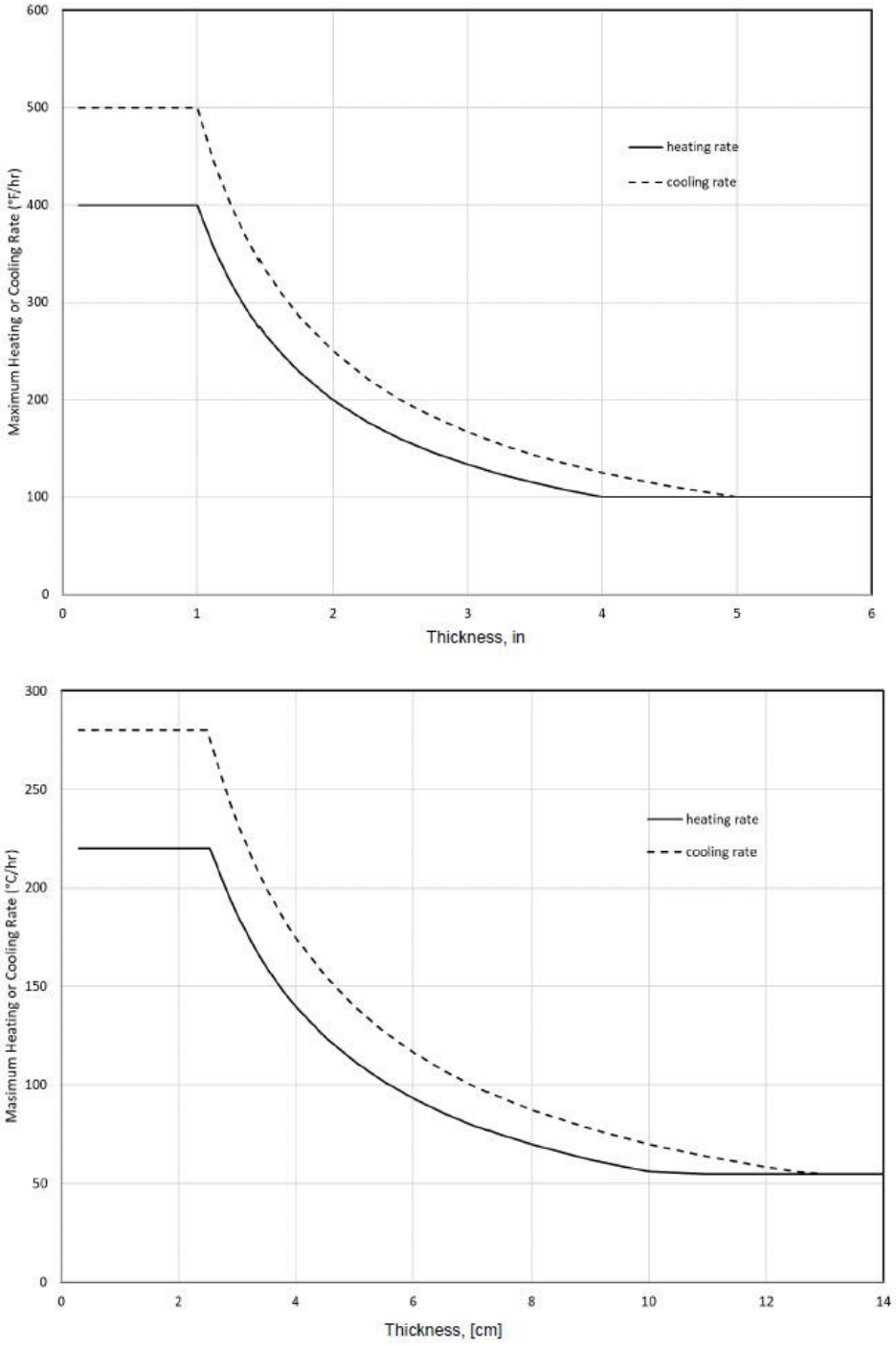


Figure C-7.9—Maximum Heating and Cooling Rates

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Page 547, above C-8.1 Scope: add the title “Part A General Requirements”

Page 573, C-10.2.3.7, 1st paragraph, last sentence: change “Reference 12” to “Reference 6”

Page 574, C-10.3(1), last sentence: change "Annex R” to Annex Q”

Page 574, C-10.3(2), last sentence: change "Annex R” to Annex Q”

Page 579, 2nd to last paragraph, 2nd sentence: delete “of Clause C-2”

Page 588, Table C-10.7, title: change “10.14.1.1” to “10.14.4.4”

Page 593, item (3), last sentence, last reference: change “36” to “33”

Page 611, Index, *Faying Surface*: change “7.21.2” to “7.21.1”

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