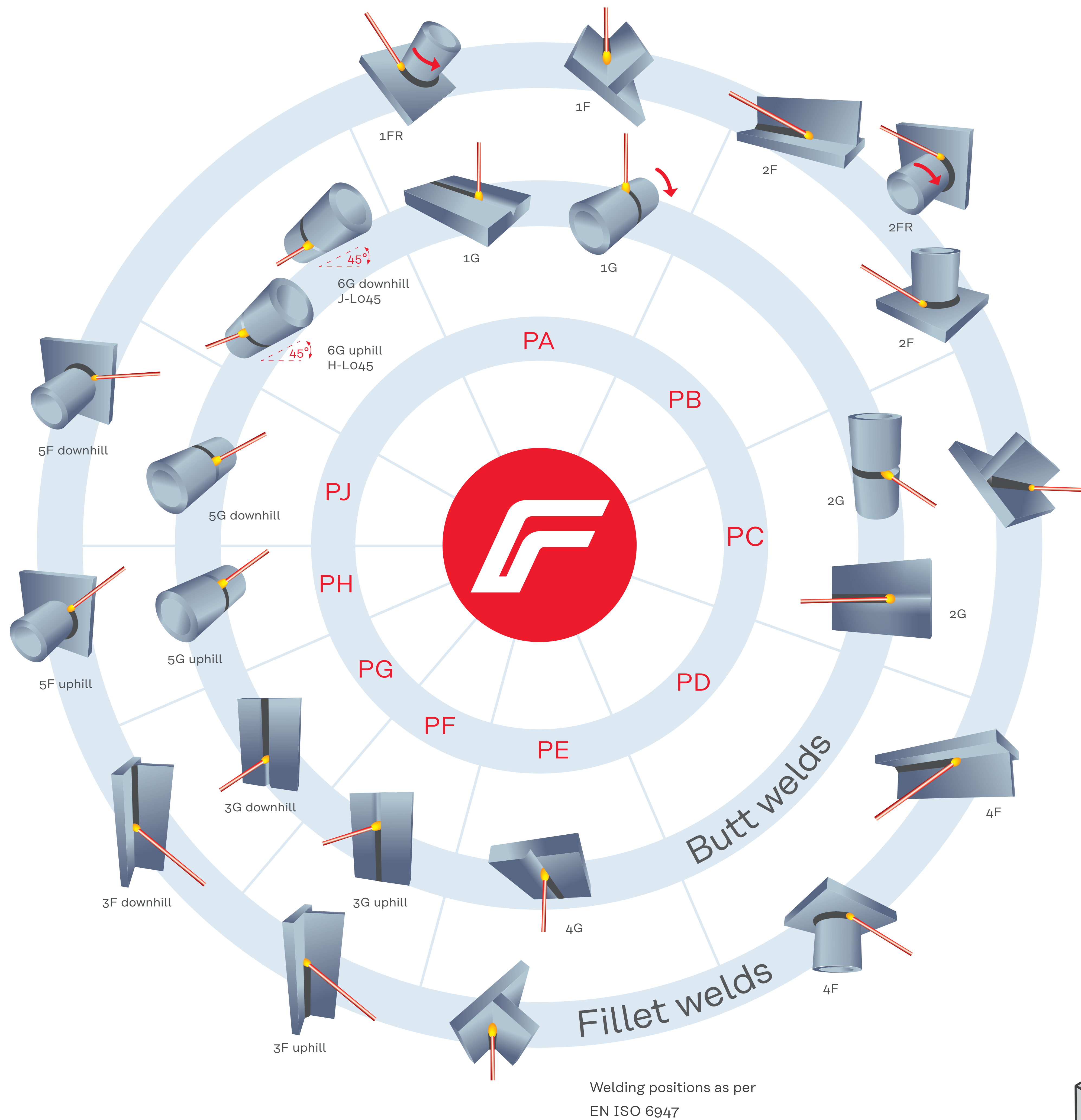


Welding positions



Key

- PA Flat position (1G, 1F)
- PB Horizontal position (2F)
- PC Horizontal position (2G)
- PD Horizontal overhead position (4F)
- PE Overhead position (4G)
- PF Vertical-up position (3G, 3F)
- PG Vertical-down position (3G, 3F)
- PH Pipe position for vertical-up (5G, 5F)
- PJ Pipe position for vertical-down (5G, 5F)
- H-LO45 Pipe fixed inclined position welding upwards (6G)
- J-LO45 Pipe fixed inclined position welding downwards (6G)

Welding joints

Basic symbols*

Designation	Weld illustration	Symbol
Square butt weld		
Single-V butt weld		
Single-V butt weld with broad root face		
Single-bevel butt weld		
Single-bevel tee butt weld		
Single-U butt weld		
Flair bevel groove weld		

Designation	Weld illustration	Symbol
Fillet weld		
Flare-V groove weld		

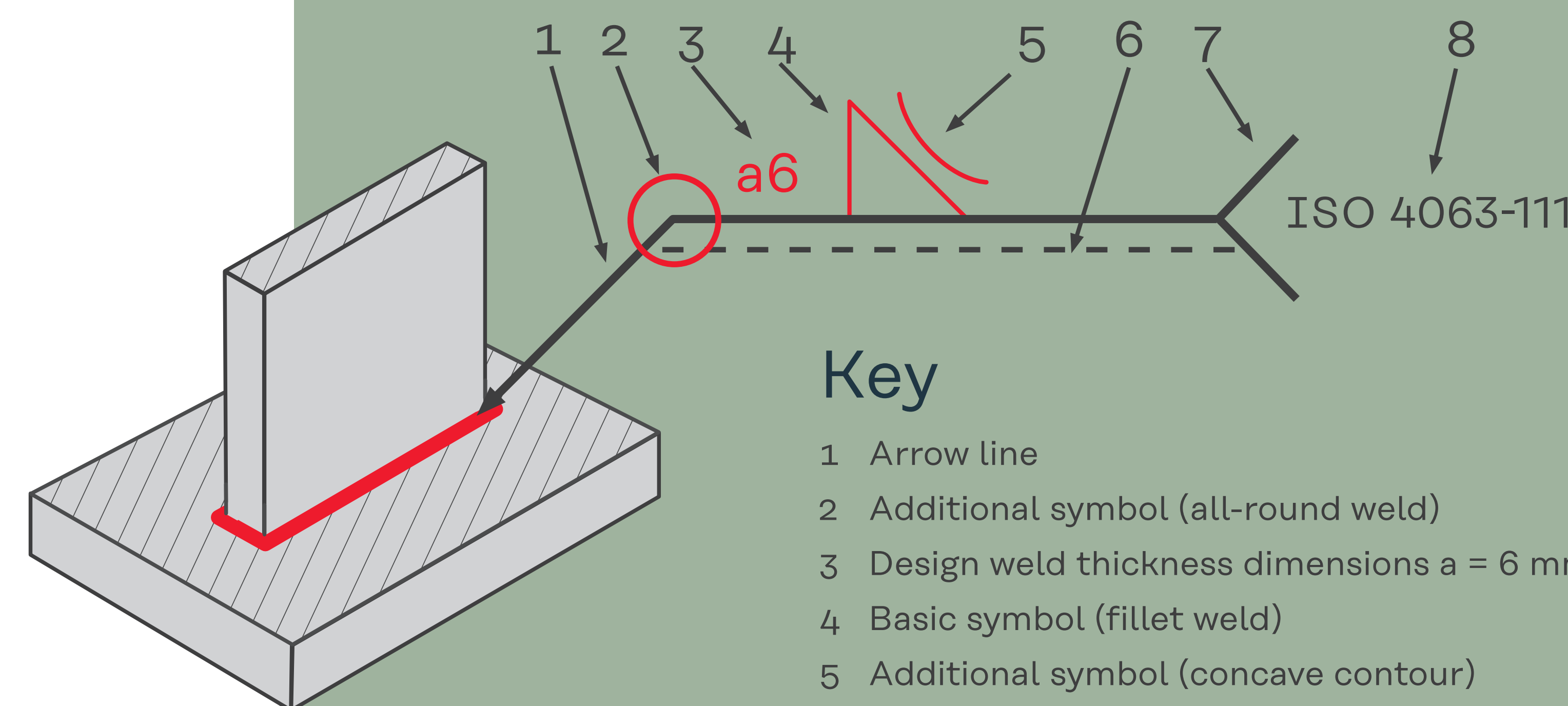
Combined symbols*

Designation	Weld illustration	Symbol
Double-V butt weld		
Double-bevel butt weld		
Double-U butt weld		
Double-bevel butt weld with fillet weld		

*Excerpt from: DIN EN ISO 2553

System A

As per DIN EN ISO 2553



Key

- 1 Arrow line
- 2 Additional symbol (all-round weld)
- 3 Design weld thickness dimensions a = 6 mm
- 4 Basic symbol (fillet weld)
- 5 Additional symbol (concave contour)
- 6 Reference line (continuous line) + dashed line (identification line)
- 7 Tail
- 8 Additional information (manual arc welding process 111 as per ISO 4063)

Application example Symbols

The example shows a fillet weld which should be welded all the way around using the manual arc welding process. The design weld thickness is a = 6 mm and the weld seam should be concave in shape.