

Table UW-12
Maximum Allowable Joint Efficiencies for Arc and Gas Welded Joints

Type No.	Joint Description	Limitations	Joint Category	Degree of Radiographic Examination		
				(a) Full [Note (1)]	(b) Spot [Note (2)]	(c) None
(1)	Butt joints as attained by double welding or by other means which will obtain the same quality of deposited weld metal on the inside and outside weld surfaces to agree with the requirements of UW 35. Welds using metal backing strips which remain in place are included.	None	A, B, C & D	1.00	0.85	0.70
(2)	Single welded butt joint with backing strip other than those included under (1)	(a) None except as in (b) below (b) Circumferential butt joints with one plate offset, see UW 13(a)(4) and Figure UW 13.1, sketch (i)	A, B, C & D A, B & C	0.90 0.90	0.80 0.80	0.65 0.65
(3)	Single welded butt joint without use of backing strip	Circumferential butt joints only, not over $\frac{3}{8}$ in. (14 mm) thick and not over 24 in. (600 mm) outside diameter	A, B & C	NA	NA	0.60
(4)	Double full fillet lap joint	(a) Longitudinal joints not over $\frac{3}{8}$ in. (10 mm) thick (b) Circumferential joints not over $\frac{3}{8}$ in. (16 mm) thick	A B & C [Note (3)]	NA NA	NA NA	0.55 0.55
(5)	Single full fillet lap joints with plug welds conforming to UW 17	(a) Circumferential joints [Note (4)] for attachment of heads not over 24 in. (600 mm) outside diameter to shells not over $\frac{3}{8}$ in. (13 mm) thick (b) Circumferential joints for the attachment to shells of jackets not over $\frac{3}{8}$ in. (16 mm) in nominal thickness where the distance from the center of the plug weld to the edge of the plate is not less than $1\frac{1}{2}$ times the diameter of the hole for the plug.	B C	NA NA	NA NA	0.50 0.50
(6)	Single full fillet lap joints without plug welds	(a) For the attachment of heads subject to pressure to shells not over $\frac{3}{8}$ in. (16 mm) required thickness, only with use of fillet weld on inside of shell, or (b) for attachment of heads having pressure on either side, to shells not over 24 in. (600 mm) inside diameter and not over $\frac{3}{8}$ in. (6 mm) required thickness with fillet weld on outside of head flange only	A & B A & B	NA NA	NA NA	0.45 0.45
(7)	Corner joints, full penetration, partial penetration, and/or fillet welded	As limited by Figure UW 13.2 and Figure UW 14.1	C & D [Note (5)]	NA	NA	NA
(8)	Angle joints	Design per U 22(g) for Category B and C joints	B, C & D	NA	NA	NA

GENERAL NOTES:

- The single factor shown for each combination of joint category and degree of radiographic examination replaces both the stress reduction factor and the joint efficiency factor considerations previously used in this Division.
- $E = 1.0$ for butt joints in compression.

Iacs Pressure Testing Method

Puja Mehta



Iacs Pressure Testing Method:

The book delves into Iacs Pressure Testing Method. Iacs Pressure Testing Method is a crucial topic that must be grasped by everyone, from students and scholars to the general public. This book will furnish comprehensive and in-depth insights into Iacs Pressure Testing Method, encompassing both the fundamentals and more intricate discussions.

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Table of Contents Iacs Pressure Testing Method

1. Understanding the eBook Iacs Pressure Testing Method
 - The Rise of Digital Reading Iacs Pressure Testing Method
 - Advantages of eBooks Over Traditional Books
2. Identifying Iacs Pressure Testing Method
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Iacs Pressure Testing Method
 - User-Friendly Interface
4. Exploring eBook Recommendations from Iacs Pressure Testing Method
 - Personalized Recommendations
 - Iacs Pressure Testing Method User Reviews and Ratings
 - Iacs Pressure Testing Method and Bestseller Lists
5. Accessing Iacs Pressure Testing Method Free and Paid eBooks
 - Iacs Pressure Testing Method Public Domain eBooks
 - Iacs Pressure Testing Method eBook Subscription Services
 - Iacs Pressure Testing Method Budget-Friendly Options
6. Navigating Iacs Pressure Testing Method eBook Formats
 - ePub, PDF, MOBI, and More
 - Iacs Pressure Testing Method Compatibility with Devices
 - Iacs Pressure Testing Method Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Iacs Pressure Testing Method
 - Highlighting and Note-Taking Iacs Pressure Testing Method
 - Interactive Elements Iacs Pressure Testing Method
8. Staying Engaged with Iacs Pressure Testing Method

- Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Iacs Pressure Testing Method
9. Balancing eBooks and Physical Books Iacs Pressure Testing Method
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Iacs Pressure Testing Method
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Iacs Pressure Testing Method
 - Setting Reading Goals Iacs Pressure Testing Method
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Iacs Pressure Testing Method
 - Fact-Checking eBook Content of Iacs Pressure Testing Method
 - Distinguishing Credible Sources
 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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