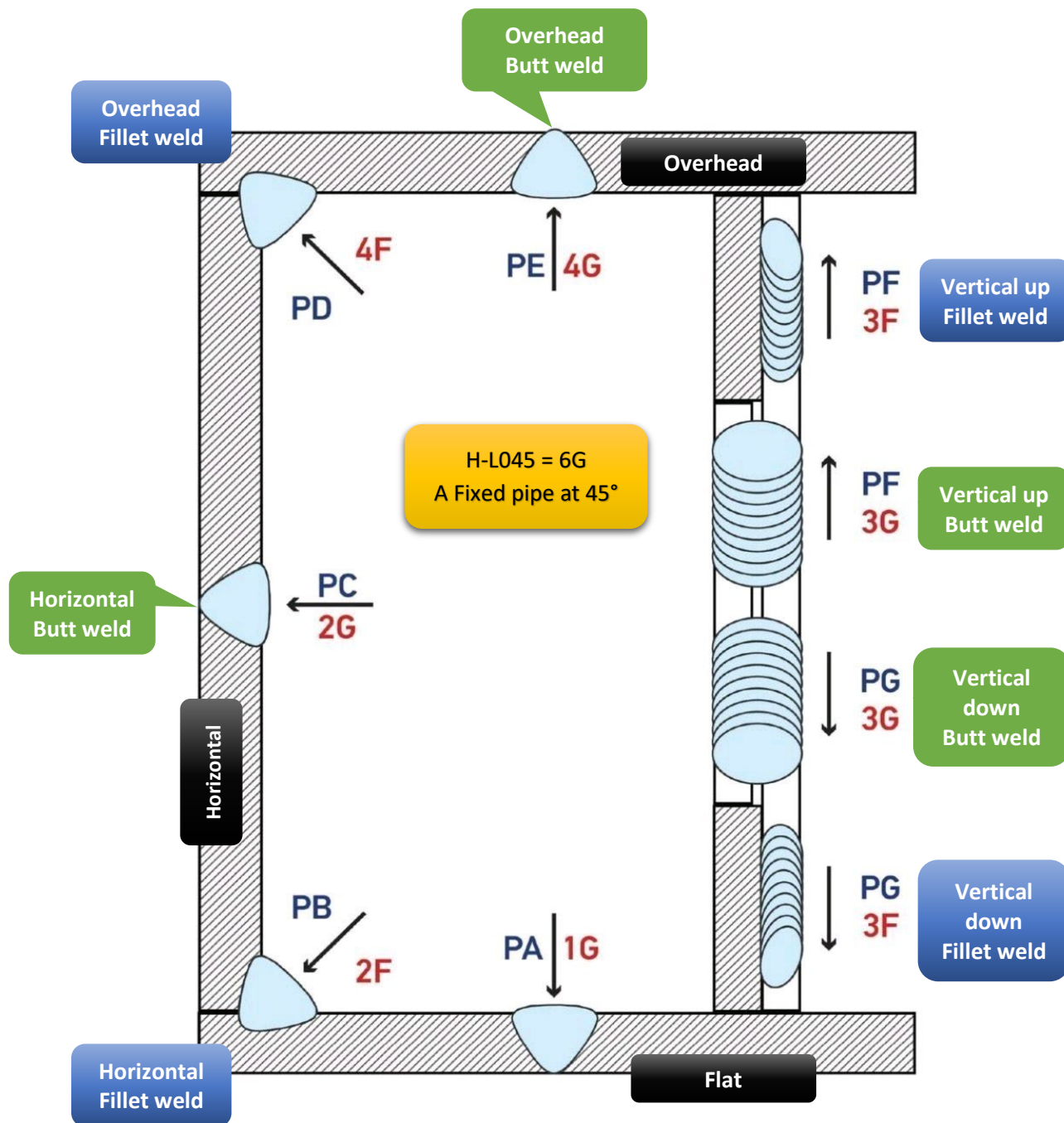


Help Guide to Welder Positions

This picture shows the different welder positions for BS EN ISO 9606-1 and ASME IX, see QW-461. A new welder starting at a manufacturer can show evidence of previous codes, but this can't be used by the new manufacturer for welding parts. Their company name will not be on the code certificate, the new welder will have to do another new weld test before welding any product assuming the products need coded welders.



Blue are EN ISO 9606

RED are ASME IX

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Help Guide to Welder Positions

Range of qualification in Butt welds					
Welding Position	PA Flat	PC Horizontal	PE Overhead	PF Vertical up	PG Vertical Down
PA		-	-	-	-
PC			-	-	-
PE (Plate)				-	-
PF (Plate)		-	-		-
PH (Pipe)		-			-
PG (Plate)	-	-	-	-	
PJ (Pipe)		-		-	
H-L045					-
J-L045				-	
a) Welds with outside pipe diameter >25mm cover welds in plates b) Welds in plates cover welds in fixed pipe >500 mm c) Welds in plates cover welds in rotating pipes >75 mm for welding positions PA, PB, PC, and PD					

Range of qualification in Fillet welds							
Welding Position	PA Flat	PB Horizontal	PC Horizontal	PD Overhead	PE Overhead	PF Vertical up	PG Vertical Down
PA		-	-	-	-	-	-
PB			-	-	-	-	-
PC				-	-	-	-
PD						-	-
PE (Plate)						-	-
PF (Plate)			-	-	-		-
PH (Pipe)							-
PG (Plate)	-	-	-	-	-	-	
PJ (Pipe)			-			-	
a) Welds with outside pipe diameter >25mm cover welds in plates b) Welds in plates cover welds in fixed pipe >500 mm c) Welds in plates cover welds in rotating pipes >75 mm for welding positions PA, PB, PC, and PD							

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