

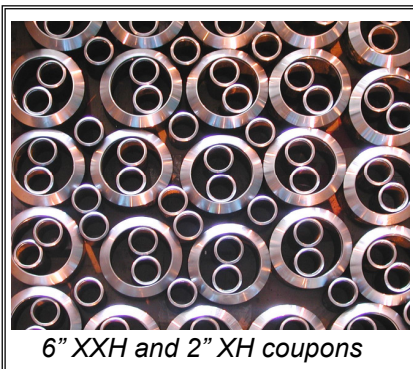
## How to Meet Welding Codes and Standards

Welding coupons can be made in many sizes, shapes, and materials. There are several reasons:

- Industry standards vary
- Job requirements vary
- Procedure vs. performance qualification requirements are different

Fischer Engineering supplies welding coupons to the manufacturing and construction industries throughout the United States. The photos give an idea of the variety of coupons we have available.

Of the many welding codes and standards that we can meet, ASME Section IX and AWS D1.1 are the two that are most often called for. We stock many coupons for performing welder qualification in accordance with ASME and AWS.



### HOW TO DETERMINE THE CORRECT COUPON FOR AWS D1.1

1. Select the type of weld to qualify. Groove welds qualify fillets, but not vice versa. Most contractors use a groove weld with backing to qualify fillets because it is more versatile and about the same difficulty as a fillet weld.
2. Select pipe or plate based upon job requirements. Remember, pipe qualifies plate, but plate only qualifies only certain sizes of pipe (see table 6.10 & 10.12).
3. Select the thickness of test coupon from Table 6.11, based upon the job thickness to be qualified (Qualified Dimensions).
4. Select the pipe diameter on the basis of Table 10.13 (Nominal Pipe or Tube Size Qualified).
5. Select the other dimensions as follows: 4" minimum Length for pipe; 3" x 7" minimum for plate over 3/8" thick.
6. With the above information, see if the required sample is listed on our price list. If not, give us a call.

### HOW TO DETERMINE THE CORRECT COUPON FOR ASME IX

1. Select the material group that needs to be qualified. Table QW/QB-422 lists all the possible code materials and P-No. groups.
2. Select P-No. 1 as the test material group if allowed by paragraph QW-423.1.
3. Select the type of weld to qualify. Remember, groove welds qualify fillets, but not vice versa. Most contractors use a groove weld with backing to qualify fillets because it is more versatile and about the same difficulty as a fillet weld.
4. Select the thickness of test coupon from Table QW-452.1, based upon the thickness of deposited weld metal to be qualified (maximum job thickness).
5. Select pipe or plate based upon job requirements. Remember, pipe qualifies plate, but plate only qualifies certain sizes of pipe (see Table QW-461.9).
6. Select the pipe diameter on the basis of Table QW-452.3.
7. Select the other dimensions as follows: 4" minimum length for pipe; 3" x 7" minimum for plate up to 3/8" thick, and 3" x 6" minimum for plate over 3/8" thick.
8. With the above information, see if the required sample is listed on our price list. If not, give us a call.

**For procedure coupons or for sizes not listed on our price list, please give us a call**

**FISCHER  
ENGINEERING  
Company,  
LLC**

# STOCK COUPONS

## PIPE COUPONS — CARBON STEEL

Part Number	Description
T01-2141 / 2141L	SA/A106-B PIPE; 2 XS X 4; 37½° BEVEL 1 END; KNIFE EDGE OR 1/16" LAND
T01-2142 / 2142L	SA/A106-B PIPE; 2 XS X 4; 37½° BEVEL 2 ENDS; KNIFE EDGE OR 1/16" LAND
T01-2241 / 2241L	SA/A106-B PIPE; 2 XXS X 4; 37½° BEVEL 1 END; KNIFE EDGE OR 1/16" LAND
T01-2242 / 2242L	SA/A106-B PIPE; 2 XXS X 4; 37½° BEVEL 2 ENDS; KNIFE EDGE OR 1/16" LAND
T01-2341 / 2341L	SA/A106-B SUPER COUPON @; 2.75OD X .63 WALL X 4; 37½° BEVEL 1 END; KNIFE EDGE OR 1/16" LAND
T01-2342 / 2342L	SA/A106-B SUPER COUPON @; 2.75OD X .63 WALL X 4; 37½° BEVEL 2 ENDS; KNIFE EDGE OR 1/16" LAND
T01-6041 / 6041L	SA/A53-B PIPE; 6 STD X 4; 37½° BEVEL 1 END; KNIFE EDGE OR 1/16" LAND
T01-6042 / 6042L	SA/A53-B PIPE; 6 STD X 4; 37½° BEVEL 2 ENDS; KNIFE EDGE OR 1/16" LAND
T01-6122 / 6122L	SA/A106-B PIPE; 6 XS X 2; 37½° BEVEL 2 ENDS; KNIFE EDGE OR 1/16" LAND
T01-6141 / 6141L	SA/A106-B PIPE; 6 XS X 4; 37½° BEVEL 1 END; KNIFE EDGE OR 1/16" LAND
T01-6142 / 6142L	SA/A106-B PIPE; 6 XS X 4; 37½° BEVEL 2 ENDS; KNIFE EDGE OR 1/16" LAND
T01-6241 / 6241L	SA/A106-B PIPE; 6 XXS X 4; 37½° BEVEL 1 END; KNIFE EDGE OR 1/16" LAND
T01-6242 / 6242L	SA/A106-B PIPE; 6 XXS X 4; 37½° BEVEL 2 ENDS; KNIFE EDGE OR 1/16" LAND

## PIPE COUPONS — STAINLESS

Part Number	Description
T08-20040	A312 TYPE 304; 2 SCH 10 X 4; NO BEVEL
T08-2141 / 2141L	A312 TP304/304L; 2XS X 4; 37½° BEVEL 1 END; KNIFE EDGE OR 1/16" LAND
T08-2142 / 2142L	A312 TP304/304L; 2 XS X 4; 37½° BEVEL 2 ENDS; KNIFE EDGE OR 1/16" LAND

## PLATE COUPONS — CARBON STEEL

Part Number	Description
T01-2518N	A-36; 1/4 X 1 X 8; NO BEVEL (BACKING BAR)
T01-383722	A-36; 3/8 X 3 X 7; 22½° BEVEL 2 SIDES
T01-384722	A-36; 3/8 X 4 X 7; 22½° BEVEL 2 SIDES
T01-5047	A-36; 1/2 X 4 X 7; 37½° BEVEL 2 SIDES
T01-1.03622	A-36; 1 X 3 X 6; 22½° BEVEL 2 SIDES

For procedure coupons or for sizes not listed on our price list, please contact us by phone or email, [sales@fischerengr.com](mailto:sales@fischerengr.com).

**FISCHER ENGINEERING COMPANY, LLC**