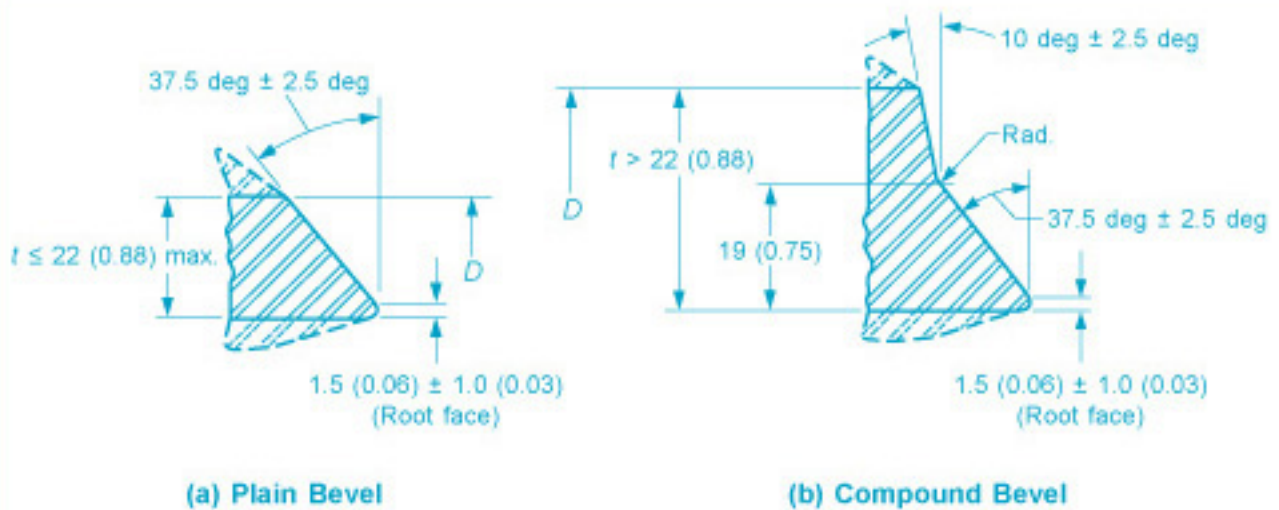


ASME B16.9

WELDING END PREPARATION



| Nominal Wall Thickness, t | End Preparation |
|-----------------------------|---|
| Less than x [Note] | Cut square or slightly chamfer, at manufacturer's option (not illustrated). |
| x to 22 (0.88), inclusive | Plain bevel as in sketch (a) above. |
| More than 22 (0.88) | Compound bevel as in sketch (b) above. |

GENERAL NOTES:

(a) Dimensions in parentheses are in inchs.

(b) Other dimensions are in millimeters.

NOTE: $x = 5$ (0.19) for carbon steel or ferritic alloy steel.