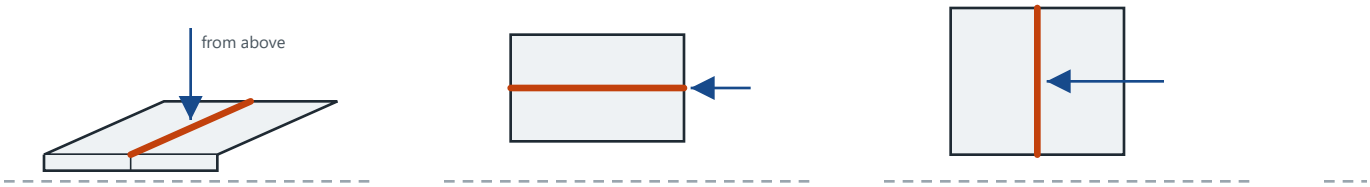
Welding test positions — plate and pipe

IBR designations of regs. 510 and 512 (Figs. 13/1 and 13/3), with the common 1G–6G equivalents in brackets. The Gazette governs.

PLATE GROOVE — reg. 510, Fig. 13/1

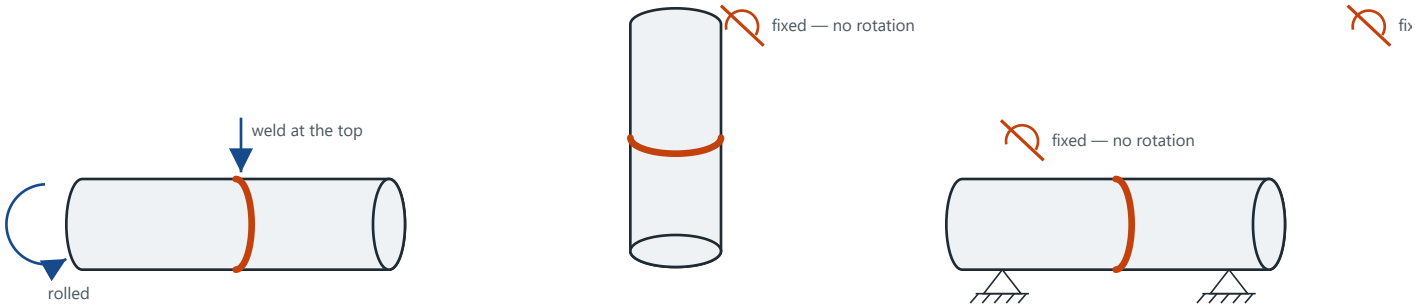


13/LGF — Flat (1G)
plate horizontal; weld metal from above

13/LGH — Horizontal (2G)
plate vertical; weld axis horizontal

13/LGV — Vertical (3G)
plate vertical; weld axis vertical

PIPE GROOVE — reg. 512, Fig. 13/3



13/PGR — Horizontal rolled (1G)
axis horizontal, pipe rolled; weld from above

13/PGV — Vertical fixed (2G)
axis vertical; seam welded horizontally

13/PGH — Horizontal fixed (5G)
axis horizontal; welded without rotating

A change in the welding position in which a welder is qualified requires requalification — reg. 520(vii)(a). Reg. 510 does not state a direction of progression (up or down) for 13/LGV; follow the qualified WPS. Plate fillet positions (13/LFF, LFH, LFV, LFO) are in reg. 511 and Fig. 13/2.

Orientation sketch only. Test positions, coupon sizes and qualification ranges are as stated in IBR 2026 Chapter 13 and its figures.

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Verify against the official Gazette (IBR 2026), amendments and project specifications.
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Figure: fig-welding-positions Rev B
Schematic, not to scale
Date: 2026-11-20
Engineering review: in progress