

**Standard Welding
Procedure
Specification (SWPS)
for Gas Tungsten Arc
Welding of Carbon
Steel (M-1/P-1) to
Austenitic Stainless
Steel (M-8/ P-8), 18
through 10 Gauge,
in the As-Welded
Condition, with or
without Backing**

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AWS B2.1-1/8-010:2015
An American National Standard

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Prepared by the
American Welding Society (AWS) B2 Committee on Procedure and Performance Qualification

Under the Direction of the
AWS Technical Activities Committee

Approved for Publication by the
AWS Board of Directors

Abstract

This standard contains the essential welding variables for welding carbon steel to austenitic stainless steel in the thickness range of 18 through 10 gauge, using manual gas tungsten arc welding. It cites the base metals and operating conditions necessary to make the weldment, the filler metal specifications, and the allowable joint designs for fillet welds and groove welds.



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