

**Table 8-12**  
**Approximate Number of**  
**Passes for Welds**

Weld Size* in.	Fillet Welds	Single-Bevel Groove Welds (Back-Up Weld Not Included)		Single-V Groove Welds (Back-Up Weld Not Included)		
		30° Bevel	45° Bevel	30° Groove Angle	60° Groove Angle	90° Groove Angle
$\frac{3}{16}$	1	—	—	—	—	—
$\frac{1}{4}$	1	1	1	2	3	3
$\frac{5}{16}$	1	1	1	2	3	3
$\frac{3}{8}$	3	2	2	3	4	6
$\frac{7}{16}$	4	2	2	3	4	6
$\frac{1}{2}$	4	2	2	4	5	7
$\frac{5}{8}$	6	3	3	4	6	8
$\frac{3}{4}$	8	4	5	4	7	9
$\frac{7}{8}$	—	5	8	5	10	10
1	—	5	11	5	13	22
$1\frac{1}{8}$	—	7	11	9	15	27
$1\frac{1}{4}$	—	8	11	12	16	32
$1\frac{3}{8}$	—	9	15	13	21	36
$1\frac{1}{2}$	—	9	18	13	25	40
$1\frac{3}{4}$	—	11	21	13	25	40

\*Plate thickness for groove welds.

# Welding Guide Number Of Passes

**Victor M. Corman**

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

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