General Notes:

(a) For P-Numbers, see QW-422; for F-Numbers, see QW-432.
(b) The weld and heat-affected zone in the case of a transverse-weld bend specimen shall be completely within the bend portion of the specimen after testing.
(c) See General Note (b) of QW-466.1.

Notes:

(1) Either hardened and greased shoulder or hardened rollers free to rotate shall be used.
(2) The shoulders or rollers shall have a minimum bearing surface of 2 in.; for placement of the specimen. The rollers shall be high enough above the bottom of the jig so that the specimen will clear the rollers when the ram is in the low position.
(3) The body of the ram may be less than the dimensions shown in column 11.
(4) If desired, either rollers or the roller supports may be made adjustable in the horizontal direction to prevent deflection and misalignment while making the bend test. The body of the ram may be less than the dimensions shown in column 11.
(5) The roller supports shall be fitted with an appropriate base designed to safeguard against deflection or misalignment and equipped with means for maintaining the rollers centered midway and aligned with respect to the ram.