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TABLE 1 WELD DEFECTS, DEFINITION / VISUAL APPEARANCE AND TYPICAL CAUSE(S)

Defect	Definition / Visual Appearance	Typical Cause(s)
ARC STRIKE	A localized heat affected zone caused by an arc or heat generated when passing current through the work piece. Arc strikes are generally recognized by evidence of melting or overheating of the material and are often caused by weld rod or wire striking the part or by MT prods arcing to the part surface.	<ul style="list-style-type: none">Arc or heat generated when passing current through the work piece.
BURN THROUGH	An open void or through-wall hole extending into a backing ring, backing strip, fused root or base material.	<ul style="list-style-type: none">Current too high.Travel speed too low.Combination of high current and low travel speed.
CRACK or TEAR	A linear rupture of material under stress having a length at least 3 times its width.	<ul style="list-style-type: none">Improper weld bead aspect ratio.Improper filler selection.Insufficient preheat.Excessive interpass temperature.
CRATER CRACK	A star like rupture coming out of a weld stop crater.	<ul style="list-style-type: none">Improper electrode manipulation.Improper parameter tapering at the weld stop.Improper material handling
DAMAGED BASE METAL SURFACE AFTER WELDING	Base material shall be free from excessive localized discontinuities such as gouges, handling marks and excessive surface roughness or melt through of areas not intended to be penetrated by welding.	
INCOMPLETE CONSUMABLE INSERT MELTING	Incomplete melting of the consumable insert either with or without fusion and bonding to the base metal along one or both sides of the consumable insert.	<ul style="list-style-type: none">Improper weld joint preparation.Improper electrode manipulation.Current too low.Travel speed too high.
INCOMPLETE FUSION	Failure of the weld metal to fuse completely at some portion of the weld zone or adjacent base metal. This includes incomplete fusion of consumable inserts.	<ul style="list-style-type: none">Improper weld joint preparation.Improper electrode manipulation.Current too low.Travel speed too high.
INCOMPLETE JOINT PENETRATION	A joint root condition in a groove weld in which weld metal does not extend through the joint thickness.	<ul style="list-style-type: none">Improper weld joint preparation.Improper electrode manipulation.Current too low.Voltage too high.Travel speed too high.
IRREGULAR BEAD PROFILE	Under fill, valleys, or depressions in multipass welds greater than 2 times the undercut allowance or any depth that goes below the base metal cross section.	<ul style="list-style-type: none">Poor weld bead spacing.Poor wetability due to incorrect weld parameters, such as low voltage or high travel speed.
OVERLAP (ROLL-OVER)	The protrusion of weld metal beyond the weld toe or weld root.	<ul style="list-style-type: none">Travel speed too slow.Welding electrode too large for the parameters or position.
SLAG INCLUSION	A discontinuity consisting of slag entrapped in weld metal or at the weld interface. Weld surfaces shall be free of slag.	<ul style="list-style-type: none">Welds in joints with too narrow a joint angle or initial joint gap.In multipass welds, improper bead spacing can result in a valley, between beads with too narrow a gap or side walls with too narrow a joint angle.

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visual inspection procedure

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visual inspection standard

The investigation involved visual inspection, chemical analysis, metallography, hardness test, scanning electron microscope analysis, and thermal-hydraulic requirements are specified in parts of BS EN 60601-1 relevant to the specific equipment type. whilst the ... DEF STAN 00-970 PART 1/5, SECTION 7. See paragraph 112 for ... This assessment can be undertaken through visual inspection or through test. Should ... Workshop Manual/Maintenance Manual d. Drawings and ... Nothing from this edition may be multiplied, or made public in any form or manner, either ... 73/23 EEC. Seaward Electronic Ltd is registered under BS EN ISO9001:2000 Certificate No: Q05356. ... You can download the data from your Apollo to PATGuard 3 software. ... All preset test sequences start with a Visual Inspection., contacting Reflex Marine or by downloading the latest version from ... 4.10 Visual Inspection Checklist Form ... BS EN 13852-1:2013. ... Note: The tare weight of the FROG-XT10 is approximately 970 kg (2.139 lb) but may vary.. 20 Post-weld heat treatment. 20 Welding inspection, testing and correction ... Service categories are determined from Table B.1 of BS EN 1090-2. In the ... Visual inspection. NDT: See ... Covered electrodes for manual arc welding of high-strength steels. Tubular ... Inspection of welds in accordance with EN 970. • Stray arcs ... 7fd0c77640