



VISUAL INSPECTION OF WELDS

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GENERAL

1. Before Welding The Welder Shall Ensure Welding Preparation And Conditions Comply With Applicable Weld Procedure Specification.
2. Selected Welds For Inspection Shall Be 100% Examined.
3. Examine Weld And Heat Affected Zones For Below Characteristics.
4. Arc Strikes Adjacent to The HAZ Are NOT Permitted

MEASURED CHARACTERISTIC	ACCEPTANCE CRITERIA
CRACKS	NOT PERMITTED
LACK OF SIDEWALL FUSION	NOT PERMITTED
SURFACE POROSITY	NOT PERMITTED
COLDLAP	NOT PERMITTED
OVERLAP	NOT PERMITTED
UNDERCUT	INTERMITTENT NOT EXCEEDING 1.0mm DEPTH OR 5% OF THE MATERIAL THICKNESS (WHICHEVER IS LESS)
SLAG / SCALE	ALL LOOSE TO BE REMOVED.
SPATTER	ALL SPATTER TO BE REMOVED (ANTI-SPATTER SPRAY SHALL BE USED)
WELD SIZE (LEG LENGTH)	SHALL NOT BE LESS THAN REQUIRED AND NO MORE THAN 1.5mm GREATER.
WELD SURFACE	1. WELDS SHALL BE STRAIGHT AND REGULAR IN PROFILE. 2. THE TOES OF WELDS SHALL BLEND SMOOTHLY WITH THE PARENT METAL. 3. SURFACE SHALL BE FLAT OR SLIGHTLY CONVEX.

REPAIR

THE WELDER SHALL REMOVE WELDS CONTAINING REJECTABLE DEFECTS BY GRINDING BACK TO THE ORIGINAL PREPARATION AND RE-WELD IN ACCORDANCE WITH THE APPLICABLE WELD PROCEDURE SPECIFICATION.

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California. Division of Highways



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Materials Manual of Testing and Control Procedures California. Division of Highways,1956 Kaiser Aluminum Weldor's Training Manual Kaiser Aluminum and Chemical Sales, inc,1958 Operator's and Organizational Maintenance Manual (including Repair Parts and Special Tools List) ,1991 *Nondestructive Test Seminar, 20-24 October 1958* United States Naval Ammunition Depot, Concord, Calif,1958 **Inspection Handbook for Manual Metal are Welding** American Welding Society. Army Ordnance Advisory Committee,1945 **Welding Handbook** ,1969 ASCE Manuals and Reports on Engineering Practice ,1990 *Welding Handbook: Welding processes* American Welding Society,1964 Welding Handbook American Welding Society,1962 **Metals Handbook: Nondestructive inspection and quality control** ,1961
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