

Sketches in this column are all **acceptable** to EN ISO 5817-B

Sketches in this column are all **not acceptable** to EN ISO 5817-B



Acceptable at the weld toe



Angle approximately 110°, measured at a thickness reduced area



Borderline example, but not acceptable, angle approximately 140°

Subject to changes without notice

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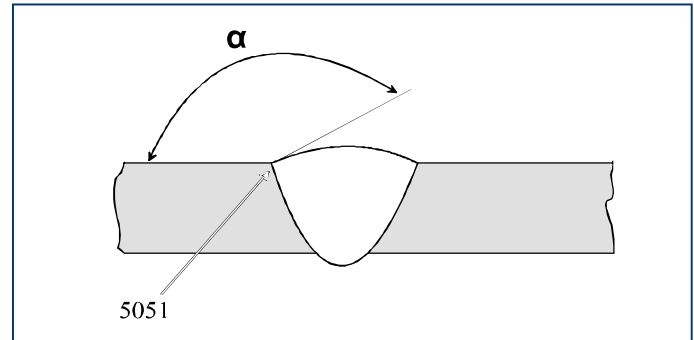
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33344-3-en

## Assessment Guide for imperfection type incorrect transition profile according to EN ISO 5817:2007 quality level B

This guide is intended to ease the use of EN ISO 5817:2007 when assessing weld toe angle requirements in submerged arc welded welds by providing practical examples of conforming and nonconforming welds.

The guide is not an interpretation of the standard, as only the national standardization organizations are authorized to perform interpretations of standards. Therefore in case of doubt or contradiction the standard shall prevail.

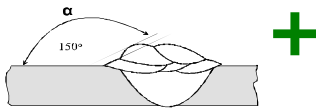


Above: The imperfection type incorrect weld toe angle as described and drawn in EN ISO 6520-1:2007. Reference No. 5051: Too small an angle ( $\alpha$ ) between the plane of the parent metal surface and a plane tangential to the weld run surface at the toe of the weld.

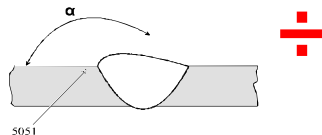
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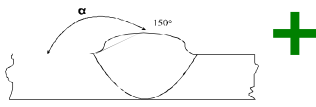
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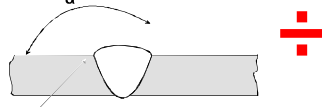
The transition profile at the weld toe is acceptable



The angle at the weld toe is less than 150°



If the weld has a smooth transition, for example. Obtained by grinding, this has to be accepted.



This weld reinforcement do not have a smooth transition (the angle is approximately 90°)



Dressed weld reinforcement



Incorrect angle in connection with the weld run completion



If the weld has a smooth transition, for example. Obtained by grinding, this has to be accepted.



Incorrect angle in connection with the weld run start

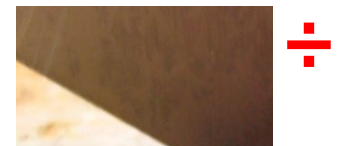
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Multi- run weld



This weld reinforcement do not have a smooth transition (the angle is approximately 110°)



A borderline example, but acceptable



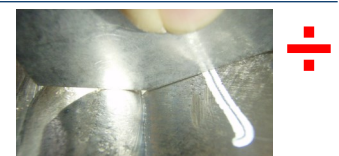
Angle approximately 130°, measured at a thickness reduced area



Multi- run weld



Angle approximately 110°



Angle approximately 110°, measured at a thickness reduced area