

WELDING DEFECT

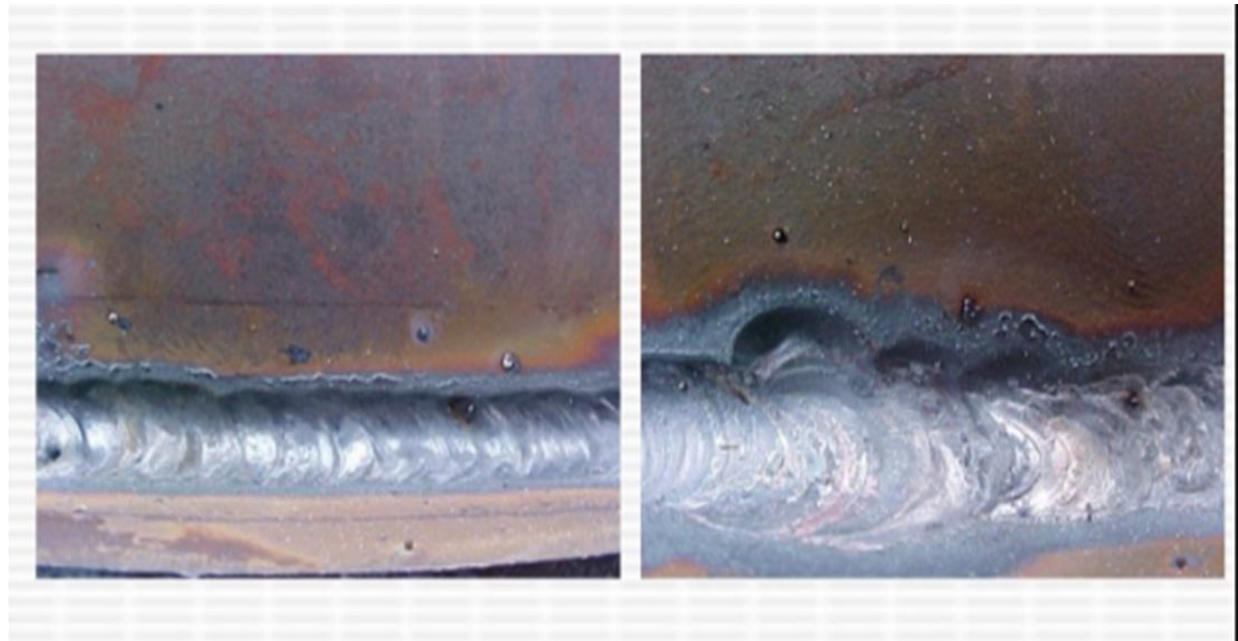
WELDING DEFECT

• Fault (દોષ):- ફોલ્ટ એટલે એ સ્થિતિ કે જે ફીનીશ જોઇંટને જરૂરી બળ / તાકાતનો સામનો ન કરવા દે. વેલ્ડિંગમાં આવતી આવી ખામીઓને મુખ્ય બે ભાગમાં વહેંચવામાં આવે છે.

1. External defects
2. Internal defects

WELDING DEFECT

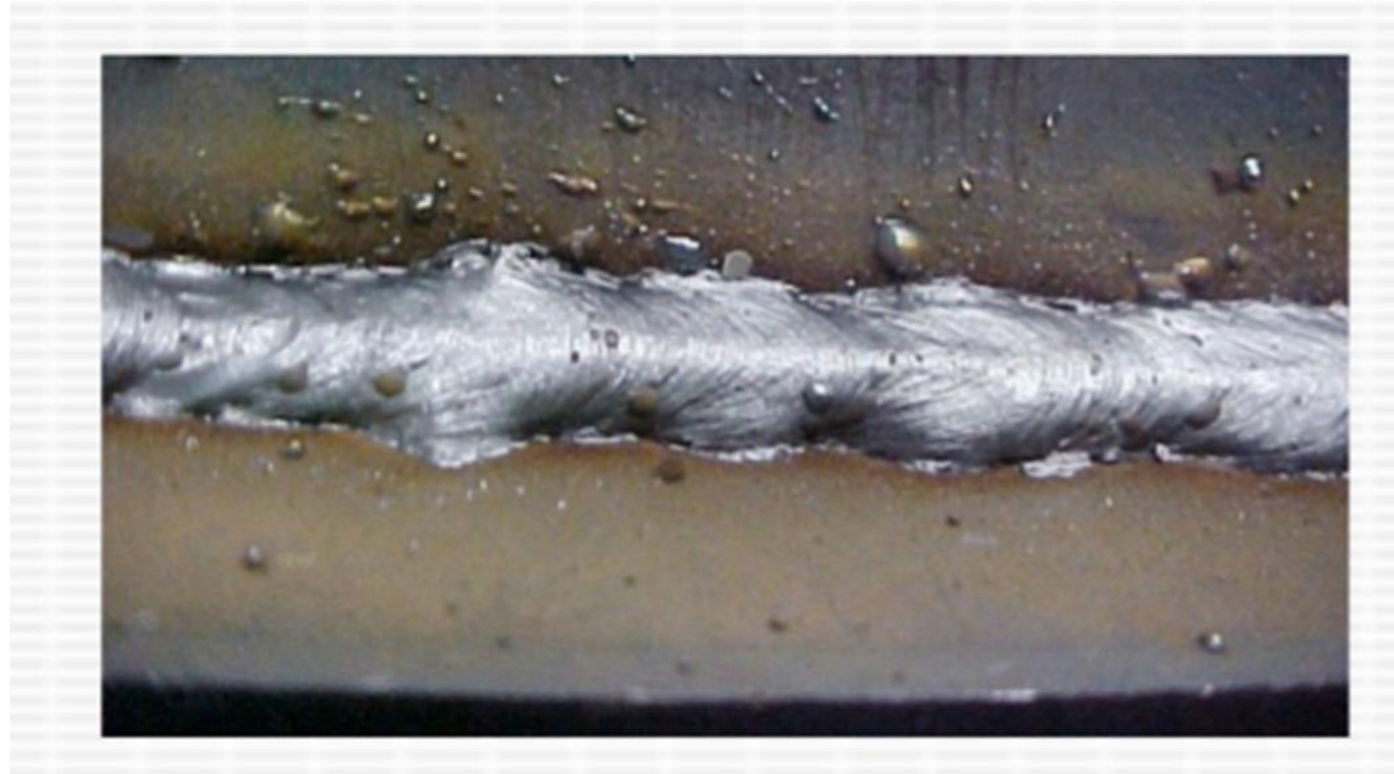
- High current
- Wrong welding angle
- High welding speed
- Improper deposit of molten metal



UNDERCUT

WELDING DEFECT

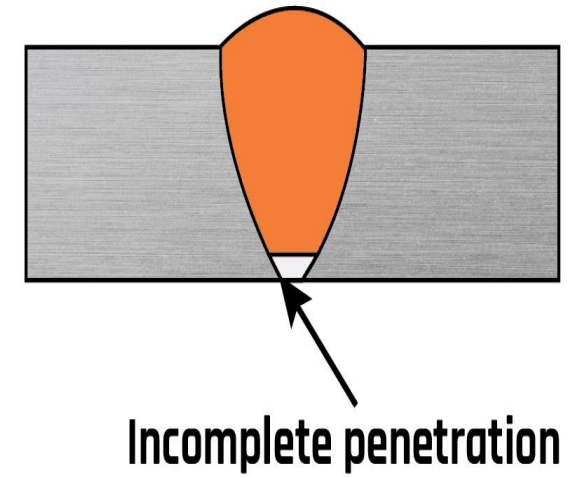
- Low current
- Slow travel speed
- Long arc



OVERLAP

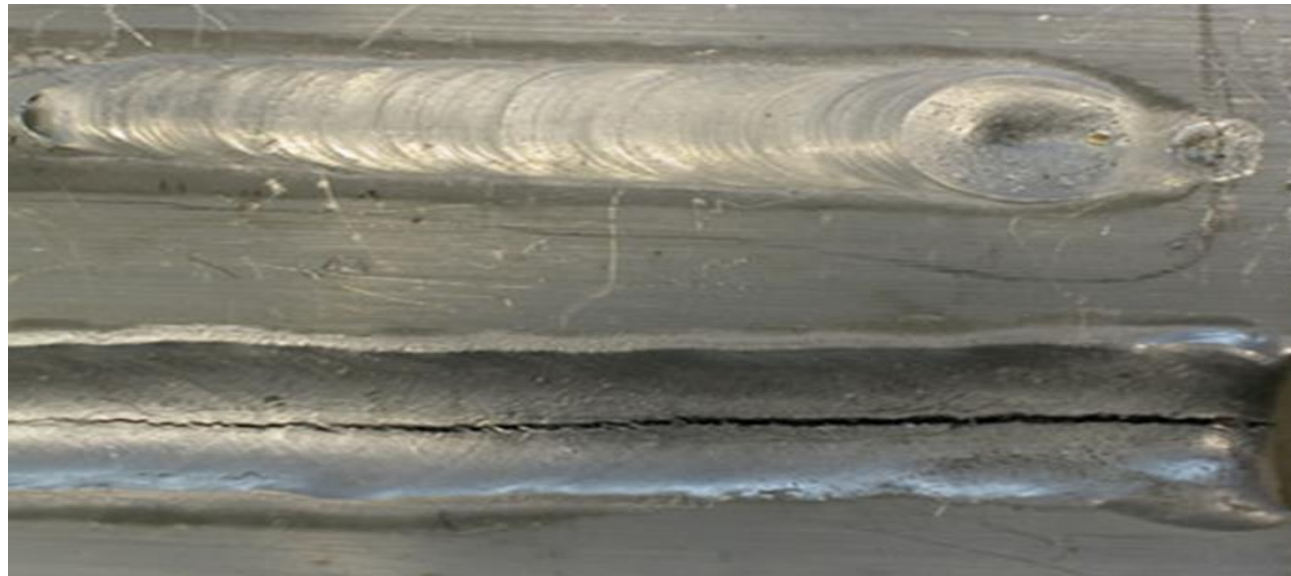
WELDING DEFECT

- Improper angle of groove
- Low current
- High welding speed
- Root gap is not proper



WELDING DEFECT

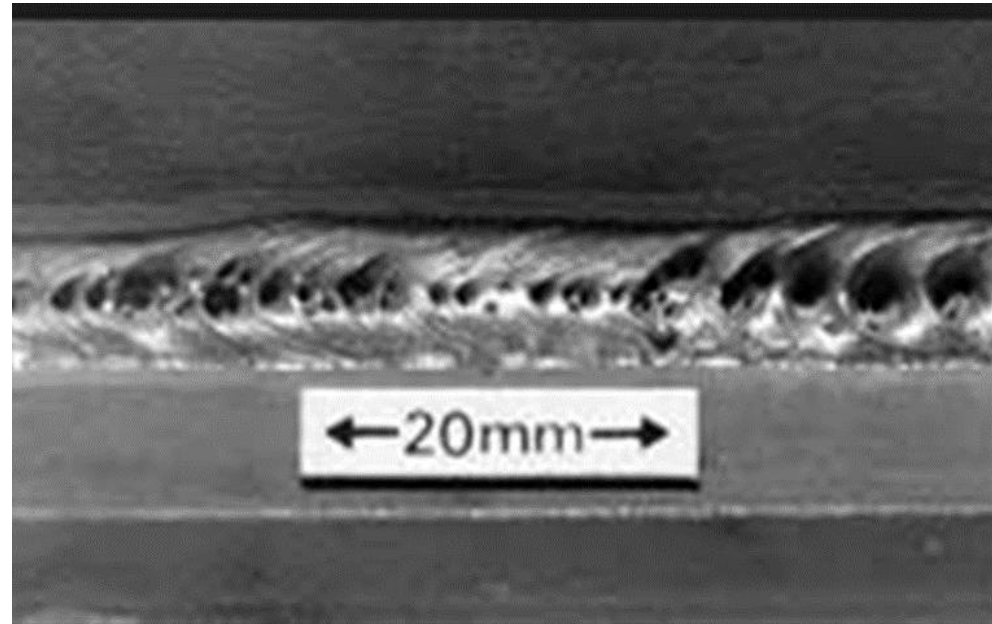
- Fast cooling of weld metal
- Due to hardness of metal
- Without pre-heating and post heating of job piece.



CRACK

WELDING DEFECT

- Moisture in a electrode
- Moisture in a Work piece
- Long arc length
- Wrong welding technique



POROSITY

WELDING DEFECT

- Wrong polarity in DC welding
- Too high current
- Long arc
- Due to arc blow



SPATTER

WELDING DEFECT

- Improper edge preparation
- Too high current
- Long arc
- Wrong welding technique



SLAG INCLUSION