



**PRIN PREZENTA VA COMUNICAM CA INCEPAND CU 09.01.2023 SUNT DISPONIBILE KITURI EDUCATIONALE pentru urmatoarele metode de examinari nedistructive :**

- Examinari cu **ULTRASUNETE**
- Examinari cu **RADIATII PENETRANTE**
- Examinari cu **PARTICULE MAGNETICE**
- Examinari cu **LICHIDE PENETRANTE**
- Examinari **VIZUALE**
- Pentru **TOATE METODELE – KIT DEMONSTRATIV**





**KIT-urile sunt recomandate pentru :**

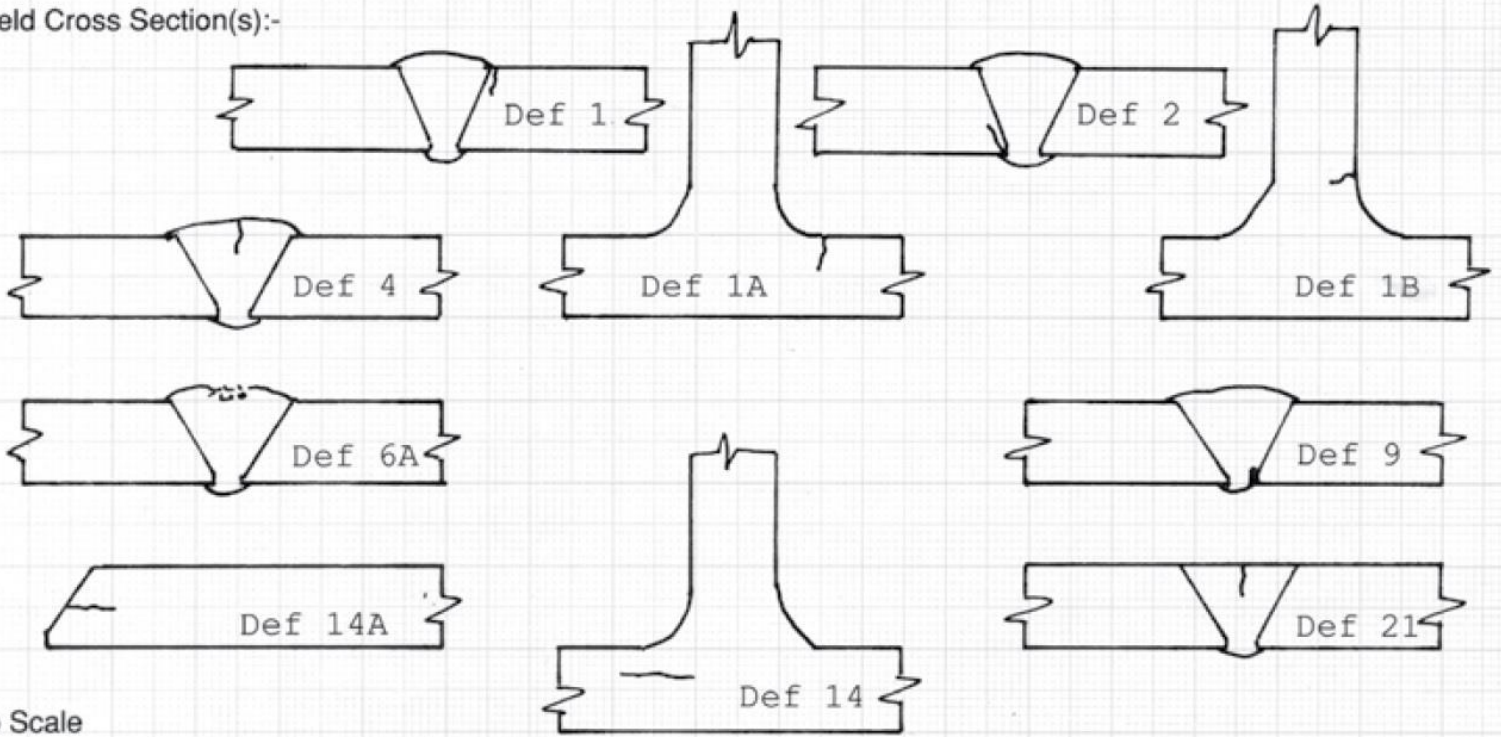
- Introducere in defectele de sudura
- Demonstrati principiile de detectare a defectelor
- Demonstrati raspunsurile tipice ale defectelor NDT
- Demonstrati principiile interpretarii defectelor
- Dimensiunea de baza a defectelor







Weld Cross Section(s):-



To Scale



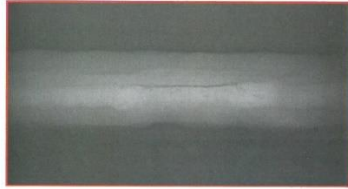


**FLAW TYPE**  
**ROOT CRACK**



**DESCRIPTION:** A crack which usually runs parallel with the weld run either along the centre line or at the edge of the root pass.

**RADIOGRAPHIC IMAGE:** Fine dark wavy lines with a feathery appearance found along the edge or at the centre of the lighter image density of the root pass. Can be distinguished from incomplete root penetration because of the tortuous twisting effect.



**FLAW TYPE**  
**SIDE WALL CRACK**



**DESCRIPTION:** A crack which runs parallel to the centre line of the weld, midway between the cap and the root. It may be situated in the weld metal, heat affected zone or the parent metal.

**RADIOGRAPHIC IMAGE:** Fine dark wavy lines with a feathery appearance usually seen midway between the lighter image of the root pass and the image of the outer edge of the cap weld. It can also be found to change direction.

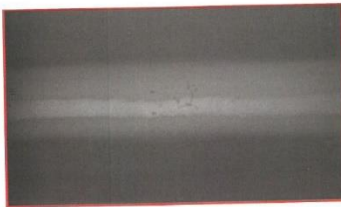


**FLAW TYPE**  
**CRATER CRACK**



**DESCRIPTION:** Cracks which occur in the end crater of a weld run due to incorrect welding technique can be found either at the stop or start of a weld run.

**RADIOGRAPHIC IMAGE:** Fine dark wavy lines with a feathery appearance usually emanating from the centre of the weld crater in the shape of a star. Sometimes as a single wavy line longitudinal or transverse to the crater.

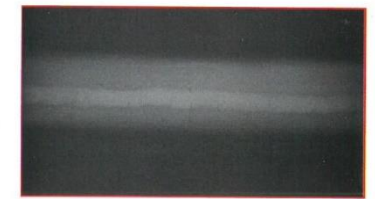


**FLAW TYPE**  
**TRANSVERSE CRACK**



**DESCRIPTION:** A crack which runs across the main axis of the weld, sometimes extending into the heat affected zone and the parent metal.

**RADIOGRAPHIC IMAGE:** Fine dark wavy lines (often discontinuous) with a feathery appearance and situated close together depending on the severity of the crack.



**FLAW TYPE**  
**TOE CRACK**



**DESCRIPTION:** A crack which runs parallel to the edge of the weld cap, it may be situated in the weld metal, weld junction, heat affected zone or the parent metal.

**RADIOGRAPHIC IMAGE:** Fine dark wavy lines (often discontinuous) with a feathery appearance and situated close together depending on the severity of the crack.



**FLAW TYPE**  
**CENTRE LINE CRACK - WELD BODY**



**DESCRIPTION:** A crack beneath the top surface of the weld which usually runs parallel to or along the centre line of the weld, sometimes changing direction diagonally.

**RADIOGRAPHIC IMAGE:** Fine dark wavy lines with a feathery appearance running parallel to or along the centre line of the weld (not quite as sharply defined as surface cracks).

**N.B. -** Not to be confused with root cracks which usually follow the profile of the root pass.

