



Prerit Consultancy Services

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Format no. : PCS/F/VT/01

Rev. No.: 0

Welding Visual Inspection Check List

Rev date : 01/07/2024

Company Name: GNU Steel Casting Private Limited

ACCEPTANCE STANDARD : EN-ISO-15614-1:2017 Table 4

Name of Project : Welding Samples

Welder Name : Manoj Kumar (13)

Material & Thickness: ISO/TR 15608, Unassigned (Mn 12%, C 1.1%, Si 0.8%, Cr 0.7%, Fe Casting), 30mm

Welding Process : 111

Type of joint : FW

WPS NO: GNU ISO 15609-1 111 P FW t 30.0 PA ml 2025 01

Report no. PCS/GNU/VT/FW/02

Report date : 30/04/2025

ISO 5817 Ref. no.	ISO 6520-1 Ref. no.	Discontinuity category	Figure	t mm	Acceptance criteria/ Tolerance	Observation	Observation after Rework	STATUS
1.1	100	Cracks		≥ 0.5	Not Permitted	NSD	-	OK
1.5	401	Lack of Fusion	 Incomplete Fusion	≥ 0.5	Not Permitted	NSD	-	OK
1.6	4021	Incomplete Root Penetration	 Only for single side butt welds	≥ 0.5	Not Permitted	-	-	-
1.70	5011	Continuous Undercut		0.5 to 3	Short imperfections: $h \leq 0.1 t$	-	-	-
	5012	Intermittent Undercut		> 3	$h \leq 0.1 t$, but max. 0.5 mm	NSD	-	OK
1.9	502	Excess weld metal		≥ 0.5	$h \leq 1 \text{ mm} + 0.15 b$, but max. 7 mm	NSD	-	OK
1.10	503	Excess Convexity (Fillet Weld)		≥ 0.5	$h \leq 1 \text{ mm} + 0.15 b$, but max. 4mm	-	-	-
1.11	504	Excess Penetration		0.5 to 3	$h \leq 1 \text{ mm} + 0.3 b$	NSD	-	OK
				> 3	$h \leq 1 \text{ mm} + 0.6 b$, but max. 4 mm			
1.12	505	Incorrect Weld Toe (Butt Weld)		≥ 0.5	$\alpha \geq 110^\circ$	NSD	-	OK
	505	Incorrect Weld Toe (Fillet Weld)	 $\alpha_1 \geq \alpha$ and $\alpha_2 \geq \alpha$	≥ 0.5	$\alpha \geq 100^\circ$	NSD	-	OK
1.16	512	Excessive asymmetry of fillet weld (excessive unequal leg length)		≥ 0.5	$h \leq 1.5 \text{ mm} + 0.15 a$	NSD	-	OK
1.21	5214	Excessive Throat Thickness		≥ 0.5	$h \leq 1 \text{ mm} + 0.2 a$, but max. 4mm	NSD	-	OK
-	-	All other imperfections		-	Not permitted	NSD	-	OK

REMARKS

EXAMINED BY

(NDT LEVEL II)



EVALUATED BY

Welding Coordinator

