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Have a good day! Please share this post with your friends to make this exclusive version more useful. disclaimer: welderportal.com is supported by its audience. when you buy via links on our site, we can earn a small fee at no extra cost for you. The defects are common in any type of production, including welding. in the process, there may be deviations in the shape and size of the metal structure. can be caused by the use of an incorrect welding process or an incorrect welding technique. below, then, we will know the 7 most common weld defects, their types, causes and remedies. Welding weldingthe most serious type of weld defect is a weld crack and is not accepted by almost all industry standards. can appear on the surface, in the welding metal or in the affected area by the intense heat. There are different types of slots, depending on the temperature at which they occur: Warm Slots. These may occur during the welding process or during the welding joint crystallization process. the temperature at this point can rise over 10,000C. Cold cracks. These cracks appear after the welding has been completed and the metal temperature is dropped. can form hours or even days after welding. mainly happens when weld steel. the cause of this defect is usually the deformity of the steel structure. this happens at the end of the welding process before the operator completes a passage on the welding joint. They usually form towards the end of the welding. when the welding tank cools and solidifies, it must have a sufficient volume to overcome the shrinkage of welded metal. Otherwise a crater crack is formed. Causes of cracks: Use of hydrogen in the welding of ferrous metals. Residual reinforcement due to the withdrawal of solidification. Base metal contamination. High welding speed but low current. No preheating before starting welding. Poor joint design. High sulphur and carbon content in metal. Remedies: preheat metal asadequate cooling of the welding area.Use proper joint design.Remove impurities.Use appropriate metal.Make sure to weld a sufficient cross-section area.Use appropriate welding speeds and amperage current.To prevent cracks in the crater make sure the crater is filled properly.Porosity Porosity Porosity occurs due to contamination of metal contamination. The trapped gases create a weld filled with bubbles which weak and can with time collapse.Causes of porosity:Inadequate deoxidizing electrode.Use of a longer arc.Presence of moisture.Inappropriate gas shield.Wrong surface treatment.Use of too high a gas flow.Contaminated surface.Presence of rust, paints, grease or oil.Remedies:Clean materials before welding. Use electrodes and dry materials.Use the correct arc distance.Check the gas flow meter and make sure it is optimized as required with correct pressure and flow settings.Reduce the speed of the arc, which will allow the gases to escape.Use the right electrodes.Use a correct welding technique.UndercutThis welding imperfection is the groove formation is the groove to the tip welding, reducing the thickness of the cross section of the base metal. The result is the welding and the workpiece weakened.Causes:Welding current too high.Welding speed too fast.Using a wrong angle, which will direct more heat towards the free edges.The electrode is too large.Incorrect use of gas shielding.Wrong welding metal.R Reduce the length of the arc.Reduce the stroke speed of the electrode, but it should not be too slow.Choose shielding gases with the correct composition for the type of material to be welded.Use the correct angle of the electrode, with more heat directed towards thicker components.Use the correct current, reducing it when approaching thinner areas and free edges. Choose a correct welding technique that does not involve excessive weaving.Use the Multi-Step TechniqueIncomplete FusionThis type of welding defect occurs when there is no proper fusion between the base metal and the welding metal. It can also appear between adjacent welding beads. This creates a crack in the joint that is not filled with molten metal.Causes: Low heat input.Surface contamination.Angle of electrode not correct.The diameter of the electrode is not correct for the thickness of the material being welded.The speed of travel is too fast.The welding tank is too large and flows in front of the arc.Remedies:Use very high welding current with the appropriate arc voltage.Before starting the welding, clean the metal.Avoid the molten pool to flood the arc.Use the correct diameter and angle of the electrode.Reduce the deposition rate.Incomplete PenetrationIncomplete penetration occurs when the metal groove is not completely filled, the metal, i.e. the welded metal is not filled. Causes:There was too much space between the metal you are soldering together.You’re moving the bead too fast, which doesn’t allow enough metal to settle in the joint.You are using an amperage setting that is too low, which does the current is not strong enough to melt the metal properly.Large diameter of the Misalignment electrode.Improper articulation.Remedies:Use a correct geometry of the joint.Use a properly sized electrode.Reduce the stroke speed of the arc.Choose the correct welding current.Check the correct alignment.Inclusion of slagSlag inclusion is one of the welding defects that are usually easily visible in welding. welding. It is a vitreous material which is presented as a by-product of rod welding, molten arc welding and submerged arc welding. It can occur when the flux, which is the solid shielding material used during welding, dissolves in the weld or on the surface of the weld zone.Causes:Inappropriate cleaning.The welding speed is too fast.Do not clean the weld passage before starting a new one.Wrong welding angle. The welding pool cools too fast.The welding current is too low.King Remedies:Increase the current density. Reduce rapid cooling.Adjust the angle of the electrode. Remove any slag from the previous heel.Adjust the speed of welding.SpatterSpatter occurs when small particles from the weld stick to the surrounding surface. This is a particularly common occurrence in gaseous metal arc welding. No matter how hard you try, it can’t be completely eliminated. However, there are a few ways to minimize it.Causes:The current amperage is too high.The voltage is too low.The working angle of the electrode is too steep.The surface is contaminated.The arc is too long.Wrong polarity.Eratic wire feeding.Remedies:Cleaned surfaces before welding. Length of the arc.Adjust the welding current.Increase the angle of the electrode.Use the correct polarity.Make sure you don’t have problems with feeding.Then we have listed the 7 most common welding defects, their causes and remedies. Once identified, it is important to remove them to avoid loss of property and strength of the material. Here you can also consult our guide on solving MIG welding defects. troubleshooting.

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