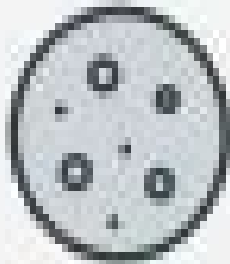
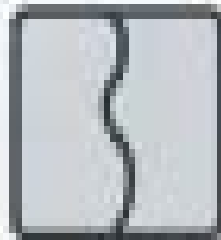


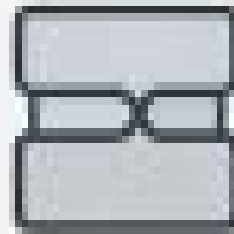
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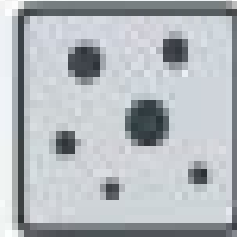
Gas Porosity



Shrinkage



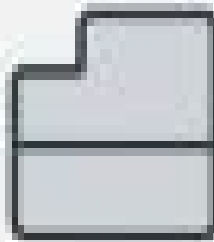
Cold Shut



Inclusion



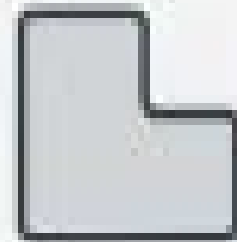
Hot Tear



Mold Shift



Oxide Film
/ Dross



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