

Table 24 — Extent of routine supplementary NDT

Type of weld	Shop and site welds		
	EXC1	EXC2	EXC3 <sup>a</sup>
Transverse butt welds and partial penetration welds in butt joints:	0 % <sup>b</sup>	10 %	20 %
Transverse butt welds and partial penetration welds:			
— in cruciform joints	0 % <sup>b</sup>	10 %	20 %
— in T joints	0 %	5 %	10 %
Transverse fillet welds <sup>c</sup> :			
with $a > 12\text{mm}$ or $t > 30\text{mm}$	0 %	5 %	10 %
with $a \leq 12\text{mm}$ and $t \leq 30\text{mm}$	0 %	0 %	5 %
Full penetration longitudinal welds <sup>d</sup> between web and top flange of crane girders	0 %	10 %	20 %
Other longitudinal welds <sup>d</sup> , welds to stiffeners and welds specified in the execution specification as being in compression	0 %	0 %	5 %
<sup>a</sup> For EXC4 the percentage extent shall be at least that given for EXC3. <sup>b</sup> 10 % for such welds executed in steel S420. <sup>c</sup> Terms $a$ and $t$ refer respectively to the throat thickness and the thickest material being joined. <sup>d</sup> Longitudinal welds are those made parallel to the component axis. All others are considered as transverse welds.			

The execution specification may identify specific joints for inspection together with the extent and method of testing (see 12.4.2.4). This testing may be counted within the extent of routine testing as appropriate.

If inspection gives non-conforming results, investigation shall be carried out in order to find the reason. The guidance in EN ISO 17635:2016, Annex C should be followed.

#### 12.4.2.4 Project specific inspection and testing

For EXC1, EXC2 and EXC3, the execution specification may identify requirements for production testing and specific joints for inspection together with the extent of testing.

For EXC4 execution specification shall identify specific joints for inspection together with the extent of testing, which shall be that specified for EXC3 as a minimum.

If specified, weld inspection classes (WICs) may be used to classify specific welds for inspection, and in this respect to define the scope and percentage extent of supplementary testing and the test methods to be used according to the criticality of the weld (see Annex L for guidance). If weld inspection classes (WICs) are used, the execution specification shall be used to identify the weld inspection class (WIC) for each relevant weld.

#### 12.4.2.5 Visual inspection of welds

The visual inspection shall be performed after completion of welding in an area and before any other NDT inspection is carried out.

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**John Castell- Evans**



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**Design and Analysis of Connections in Steel Structures** Alfredo Boracchini, 2018-07-10 Dieses Buch führt in alle Aspekte der sicheren Berechnung Bemessung und Konstruktion von wirtschaftlichen modernen Verbindungen im Stahlbau ein Die Hintergründerluterungen sind nicht an eine spezifische Norm gekoppelt sondern es werden unterschiedliche Normen und Methoden verglichen die in der Praxis zur Anwendung kommen wie z B Eurocode AISC DIN BS Anhand einer Reihe von Beispielen werden Problemlösungen detailliert beschrieben und illustriert Damit erhält der Leser alle notwendigen Werkzeuge an die Hand um auch komplexe Probleme bei der Konstruktion von Verbindungen zu lösen Das Buch ist für Berufseinsteiger für erfahrene Praktiker sowie auch für Stahlbaufachleute eine Arbeitshilfe denn es werden einfache und komplexe Beanspruchungen an Verbindungen abgebildet Weniger ausführlich werden Erdbebenauslegung Schweißen die Wechselwirkung mit anderen Materialien Beton Holz und kalt geformte Verbindungen behandelt Fatigue Design of Steel and Composite Structures ECCS - European Convention for Constructional Steelwork, 2018-06-05 This volume addresses the specific subject of fatigue a subject not familiar to many engineers but still relevant for proper and good design of numerous steel structures It explains all issues related to the subject Basis of fatigue design reliability and various verification formats determination of stresses and stress ranges fatigue strength application range and limitations It contains detailed examples of applications of the concepts computation methods and verifications Structural Steel Design to Eurocode 3 and AISC Specifications Claudio Bernuzzi, Benedetto Cordova, 2016-03-04 Structural Steel Design to Eurocode 3 and AISC Specifications deals with the theory and practical applications of structural steel design in Europe and the USA The book covers appropriate theoretical and background information followed by a more design oriented coverage focusing on European and United States specifications and practices allowing the reader to directly compare the approaches and results of both codes Chapters follow a general plan covering A general section covering the relevant topics for the chapter based on classical theory and recent research developments A detailed section covering design and detailing to Eurocode 3 specification A detailed section covering design and detailing to AISC specifications Fully worked examples are using both codes are presented With construction companies working in increasingly international environments engineers are more and more likely to encounter both codes Written for design engineers and students of civil and structural engineering this book will help both groups to become conversant with both code systems **Physico-chemical Tables for the Use of Analysts, Physicists, Chemical Manufacturers, and Scientific Chemists ...** John Castell-Evans, 1920 **International Critical Tables of Numerical Data, Physics, Chemistry and Technology** National Research Council (U.S.), 1929 *Physico-chemical tables for the use of analysts [&c.].* John Castell-Evans, 1911 **Tables of the Motion of the Moon** Ernest William Brown, Henry Benjamin Hedrick, 1919 Report of the National Screw Thread Commission (revised 1928) (authorized by Congress, July 18, 1918, H. R. 10852) as Approved June 22, 1928 ... United States. National screw thread

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