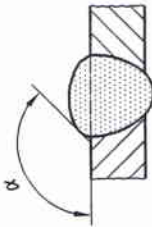
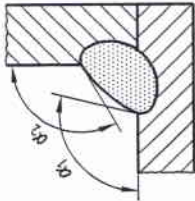
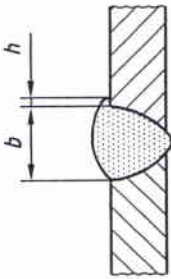
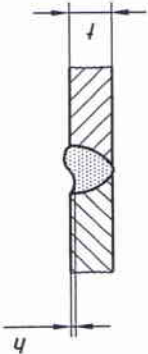


Table 1 (continued)

| No.  | Reference to ISO 6520-1:1998 | Imperfection designation              | Remarks  | t<br>mm             | Limits for imperfections for quality levels |  |  |  |
|------|------------------------------|---------------------------------------|--|---------------------|---|--|--|--|
|      |                              |                                       |  |                     | D   | C                                      | B  |  |
| 1.12 | 505                          | Incorrect weld toe                    | <p>— butt welds</p>  <p>— fillet welds</p>  <p><math>\alpha_1 \geq \alpha</math><br/><math>\alpha_2 \geq \alpha</math></p> | $\geq 0,5$          | $\alpha \geq 90^\circ$                      | $\alpha \geq 100^\circ$                | $\alpha \geq 150^\circ$                                    |  |
| 1.13 | 506                          | Overlap                               |    | $\geq 0,5$          | $h \leq 0,2 b$                              | Not permitted                          | Not permitted  |  |
| 1.14 | 509<br>511                   | Sagging<br>Incompletely filled groove | <p>Smooth transition is required</p>    | 0,5 to 3<br><br>> 3 | Short imperfections:<br>$h \leq 0,25 t$     | Short imperfections:<br>$h \leq 0,1 t$ | Short imperfections:<br>$h \leq 0,05 t$<br>but max. 0,5 mm |  |
| 1.15 | 510                          | Burn through                          | —  | $\geq 0,5$          | Not permitted                               | Not permitted                          | Not permitted  |  |