

❖ گروه بندی عیوب جوشکاری مطابق با استاندارد ایزو ۶۵۲۰

۱- ترک ها (Cracks)

۲- تخلخل (Gas pores and porosity)

۳- ذوب ناقص ((L.O.F) Lack of fusion)

۴- نفوذ ناقص ((L.O.P) Lack of penetration)

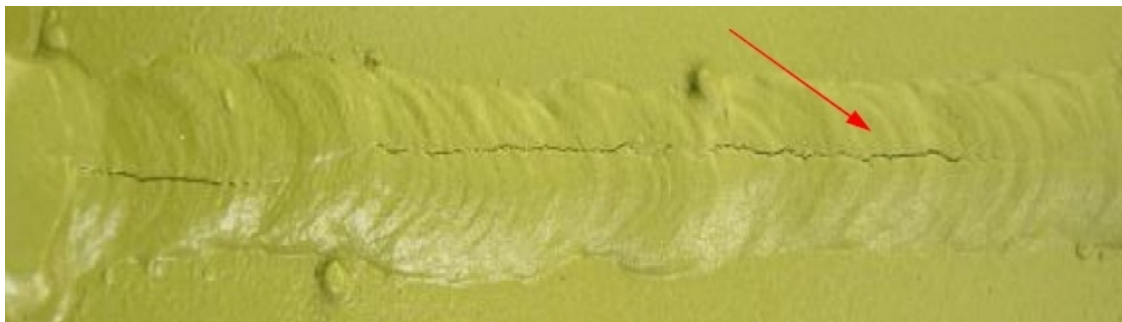
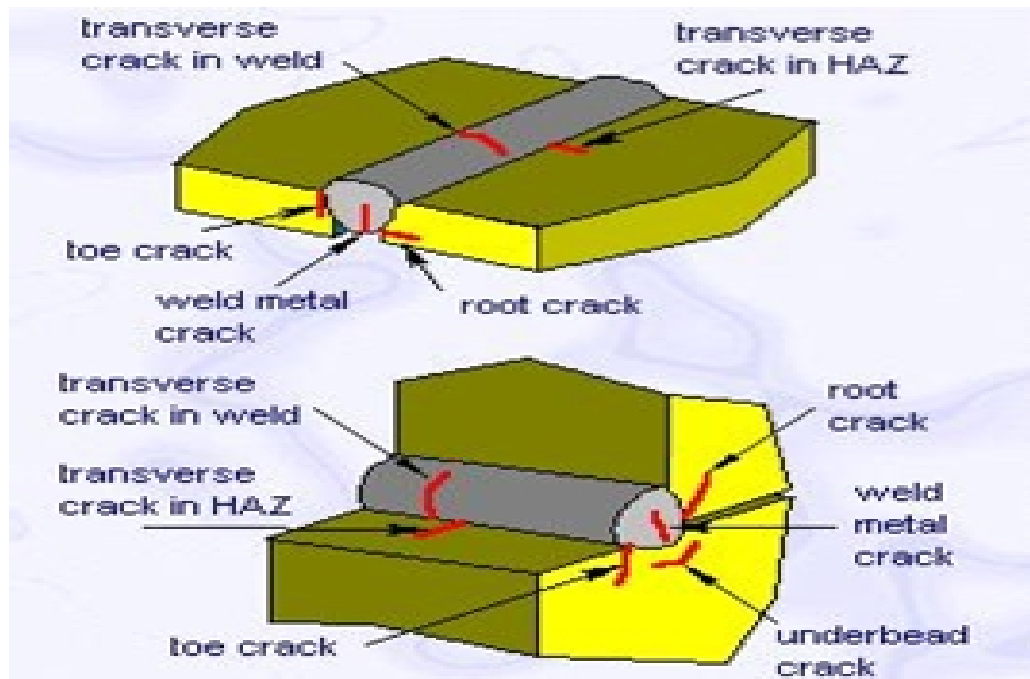
۵- سوختگی یا بریدگی کناره جوش (Undercut)

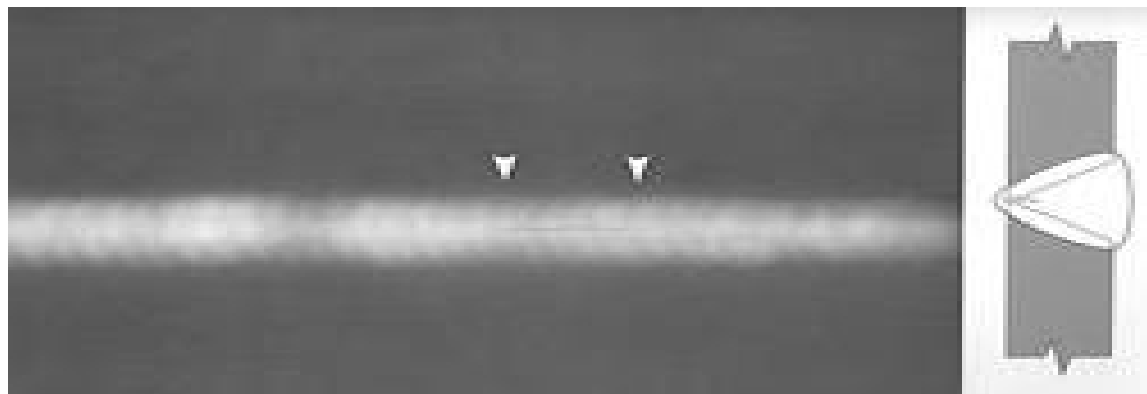
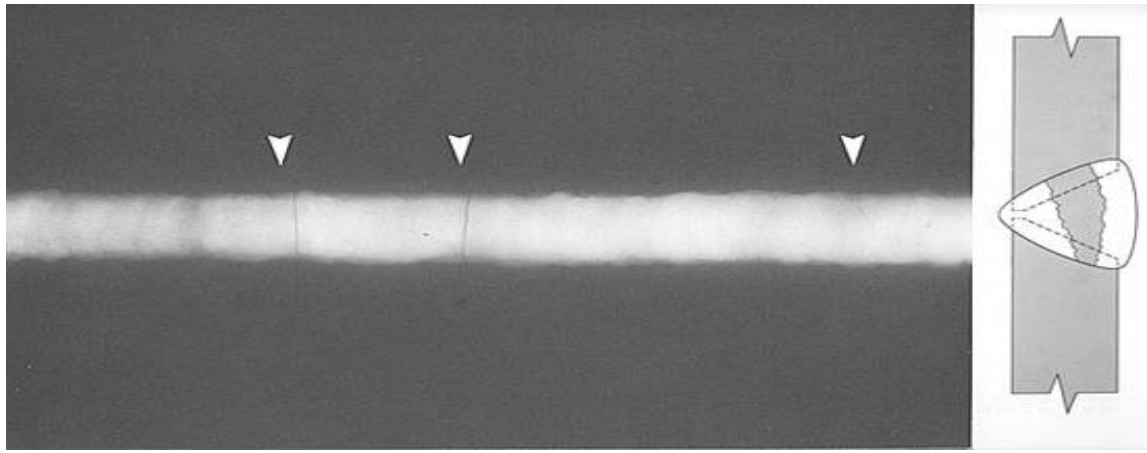
۶- روی هم افتادگی انباشتگی جوش در کناره ها (overlap or over – roll)

۷- آخالهای سرباره (Slag inclusion)

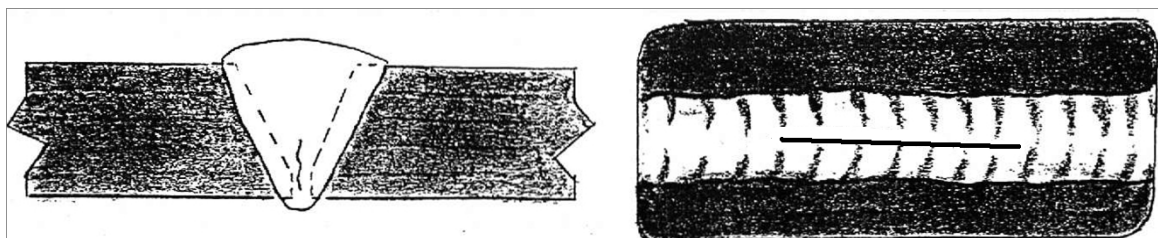
۸- همراستا نبودن اتصال جوش (Join misalignment)

ترک ها (Cracks)

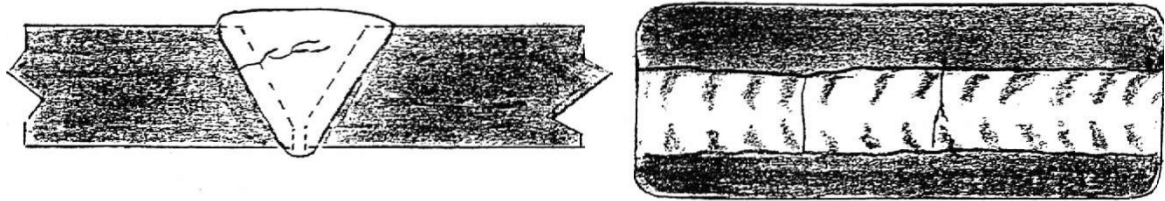




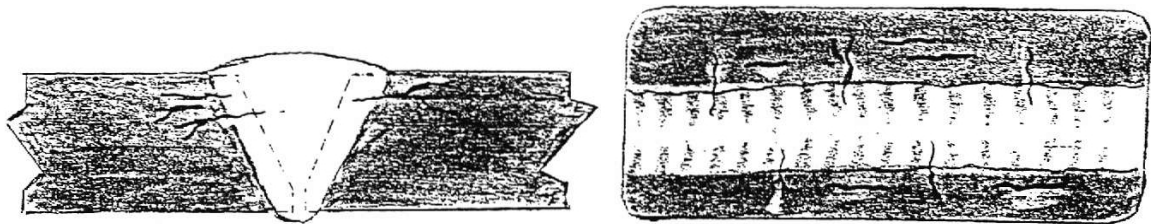
:LIGUATION CRACKING ترك طولي يا گرم



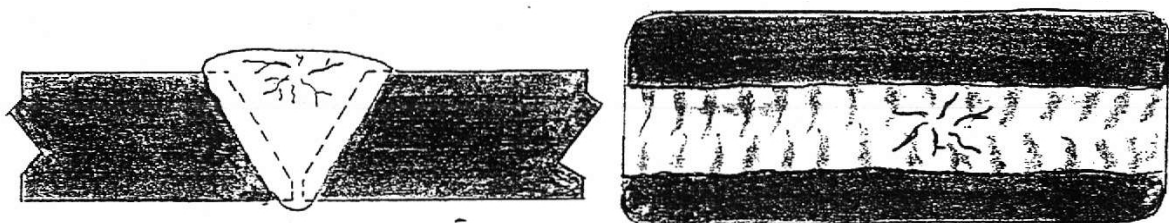
SOLIDIFICATION CRACK ترک سرد یا عرضي



Hydrogen Cracking ترک هیدروژني

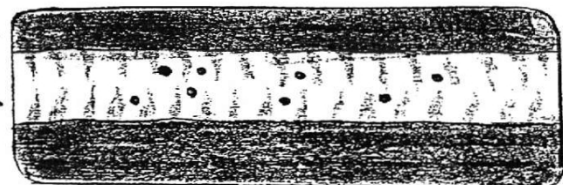
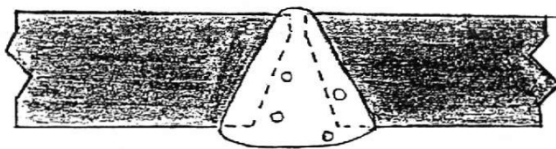
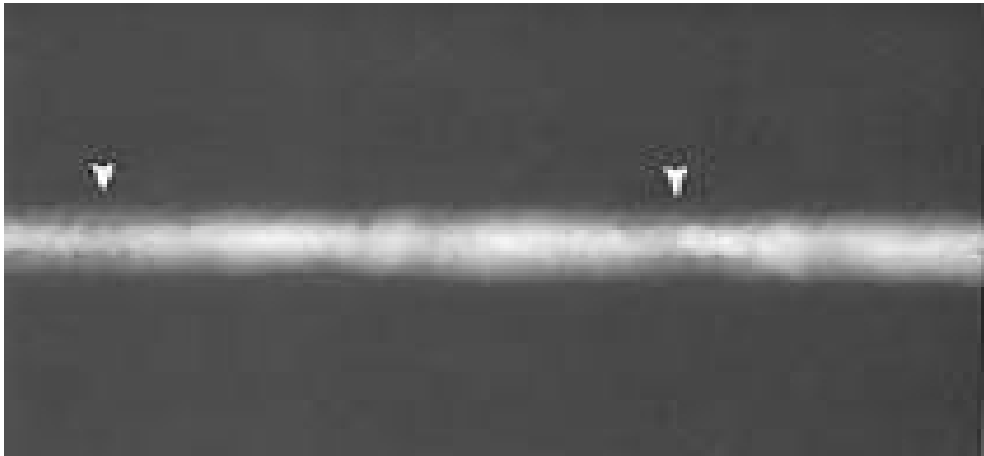
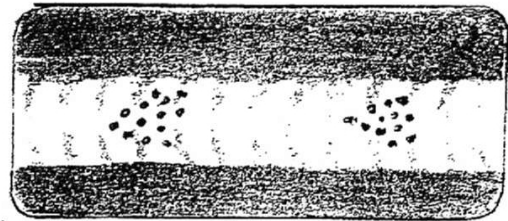
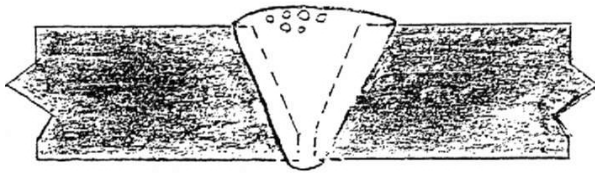
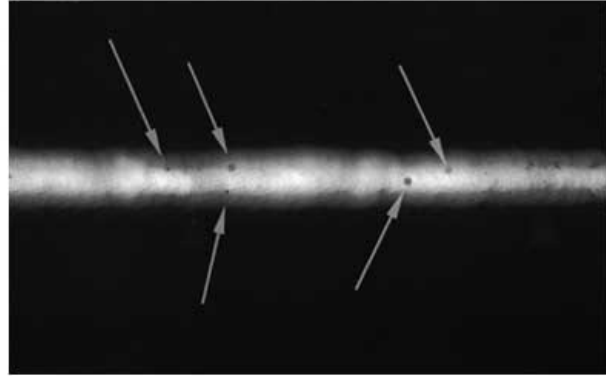
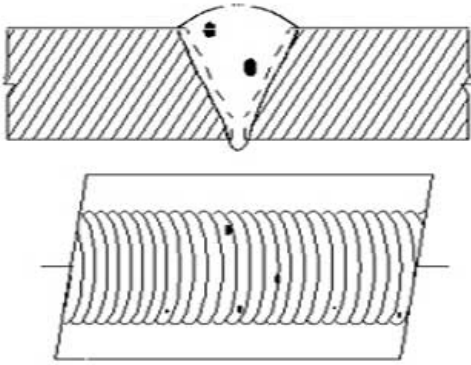


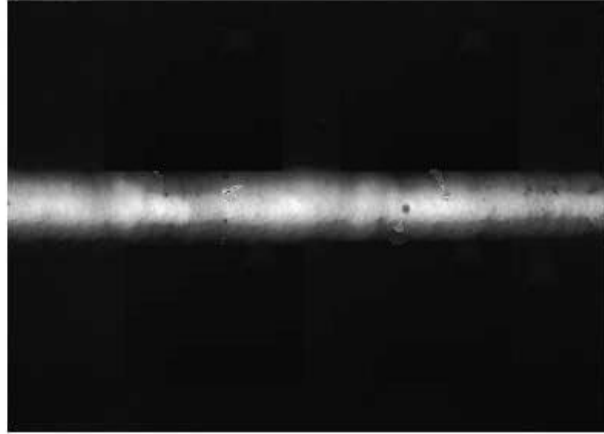
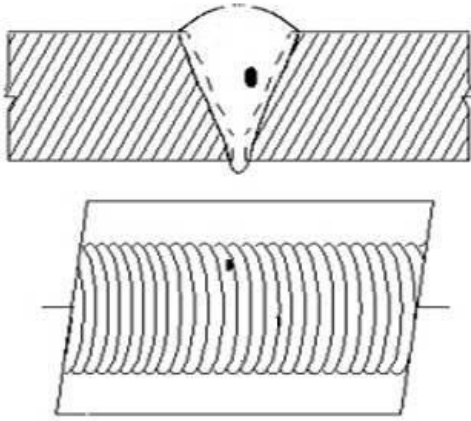
Star Cracking ترک خوشه اي



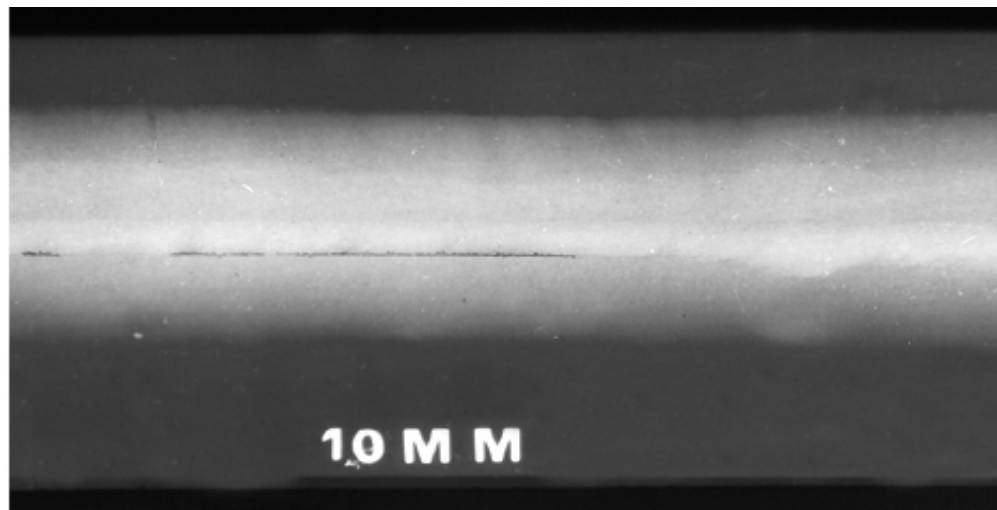
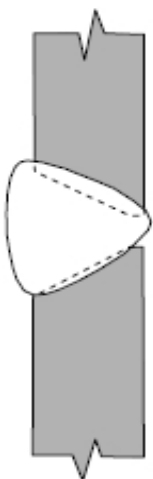
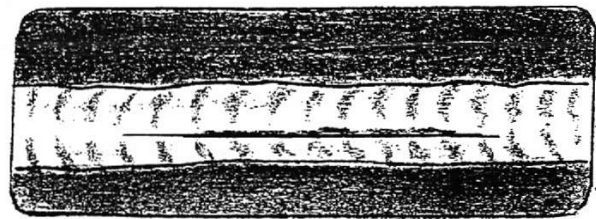
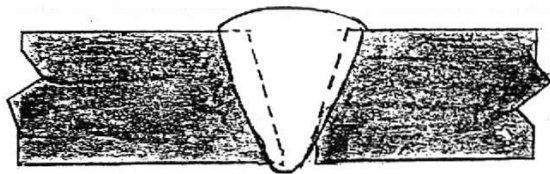
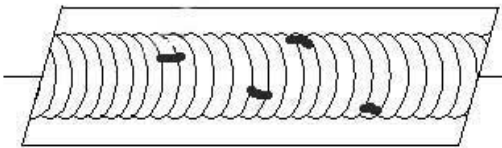
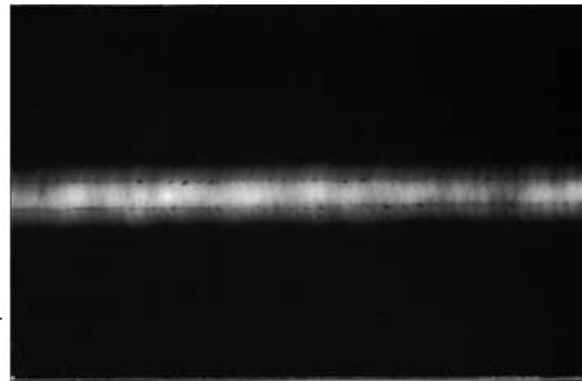
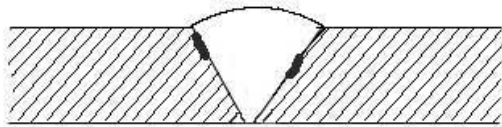
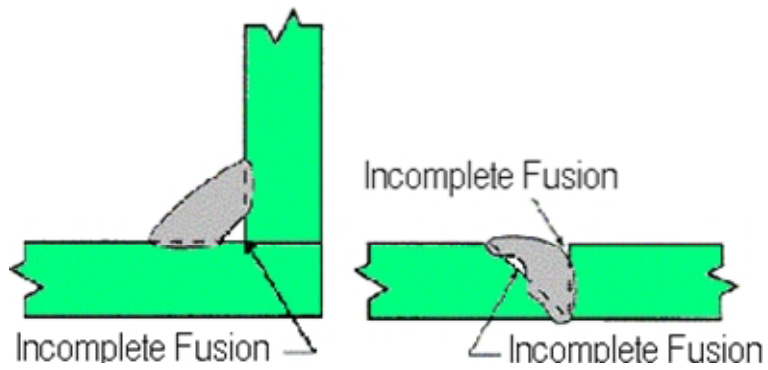
Porosity تخلخل



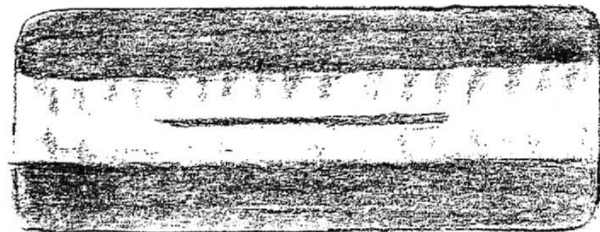
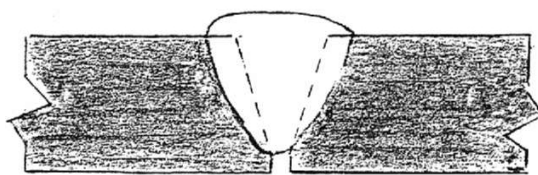
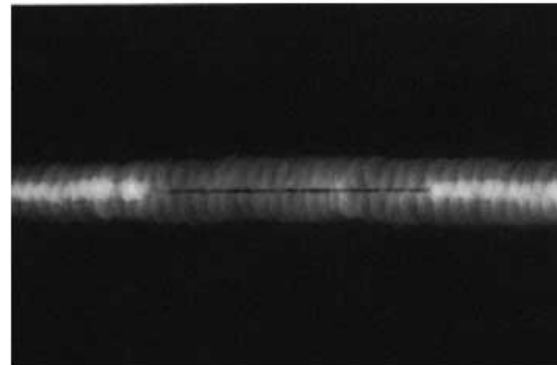
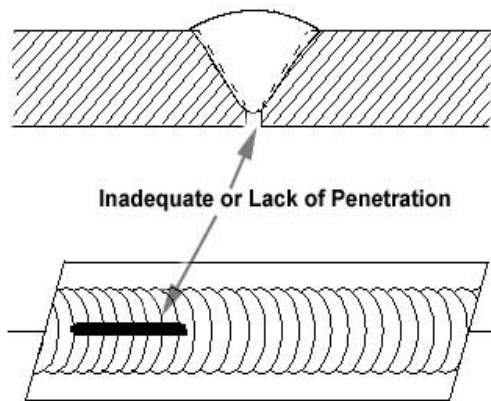
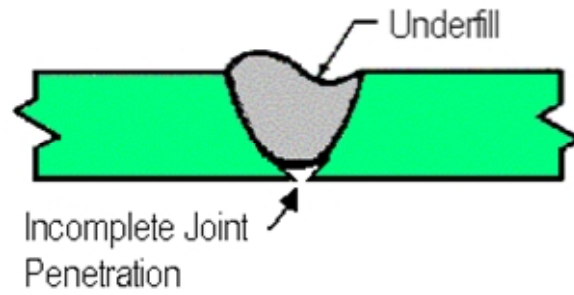




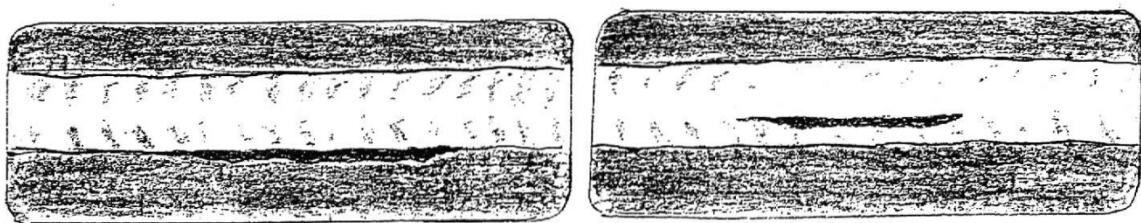
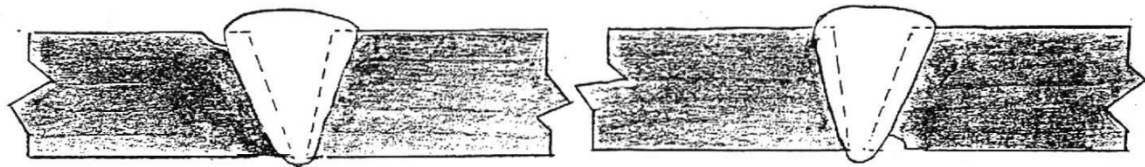
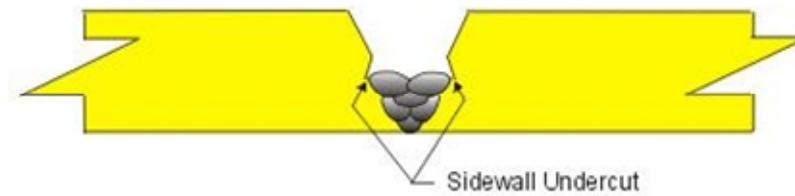
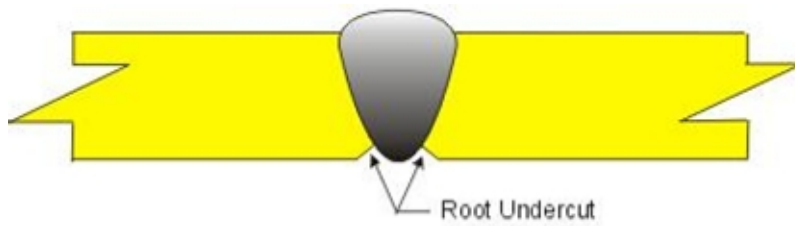
(L.O.F) Lack of fusion ذوب ناقص

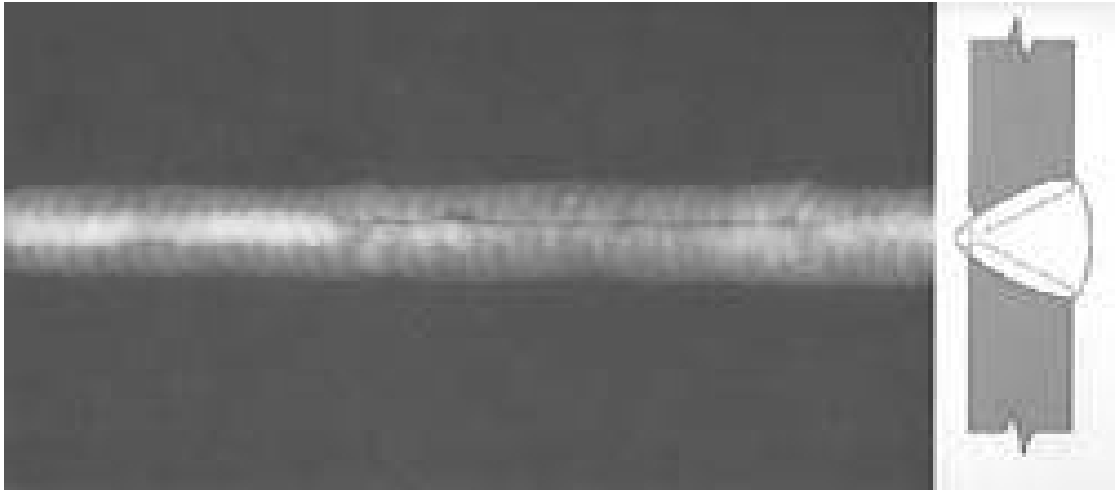
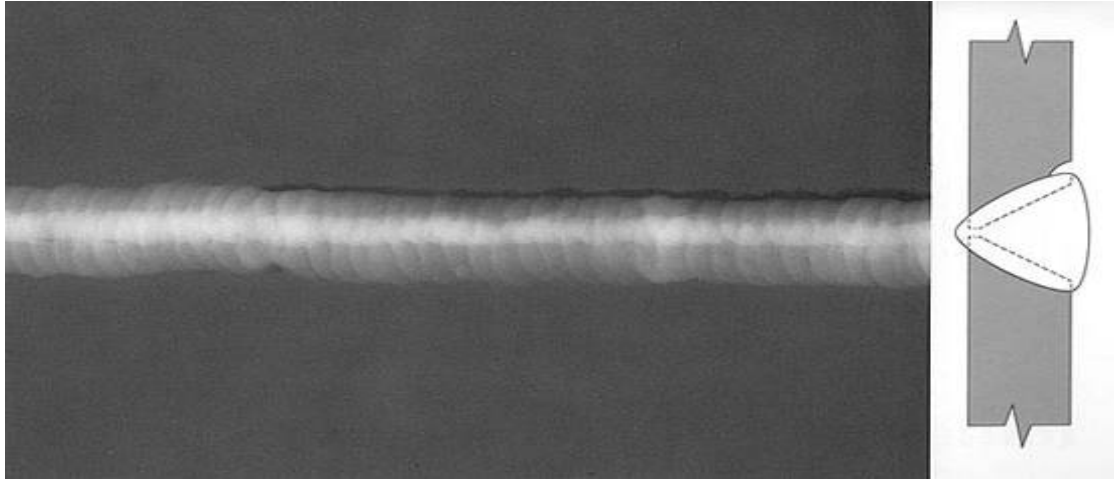


(L.O.P) Lack of penetration نفوذ ناقص

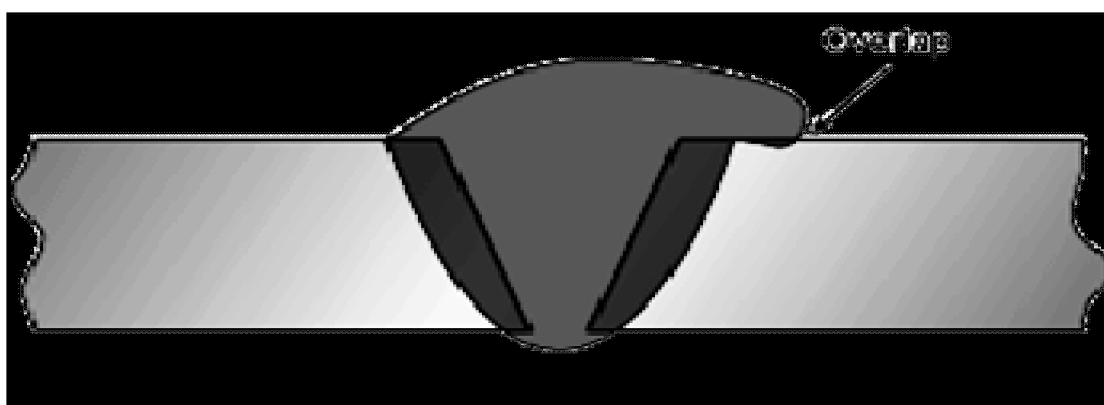
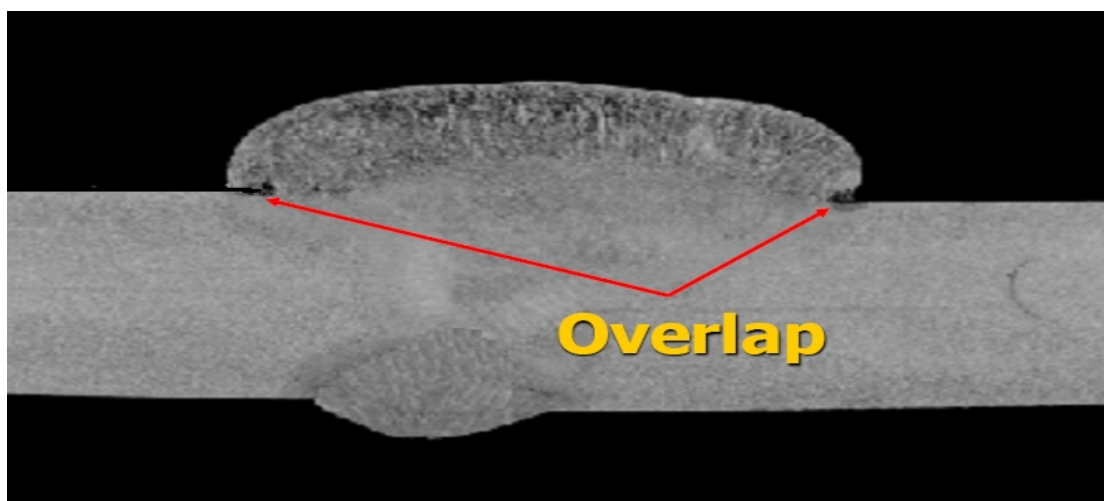
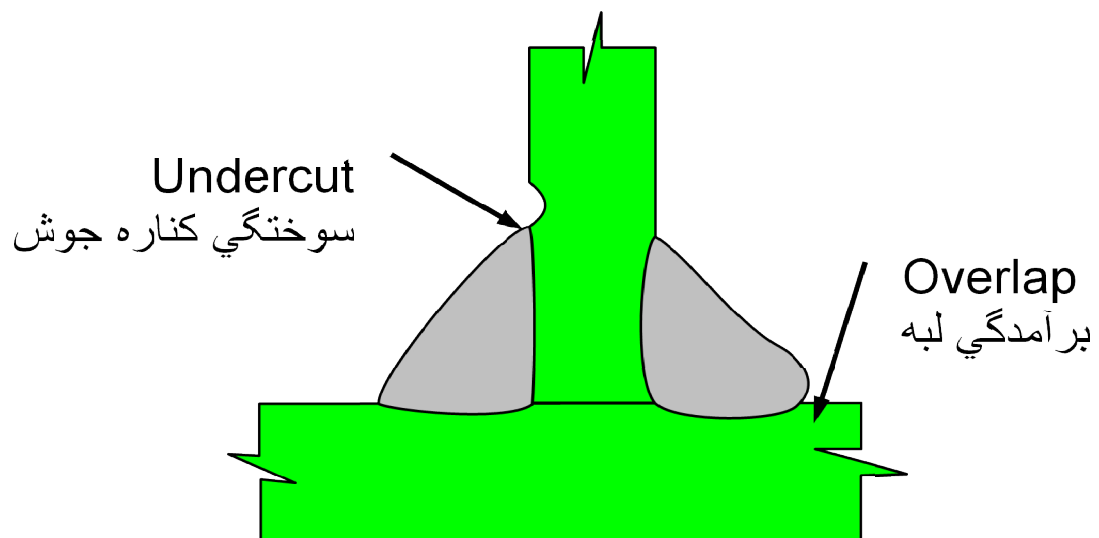


Undercut یا بریدگی کناره جوش Undercut





روی هم افتادگی جوش در کناره‌ها overlap or over-roll

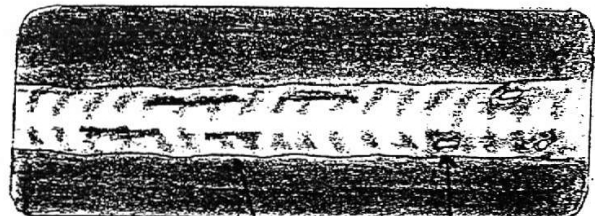
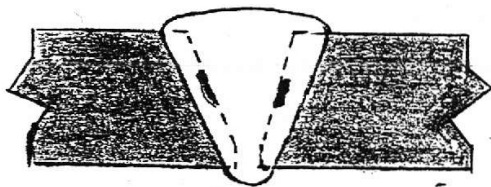
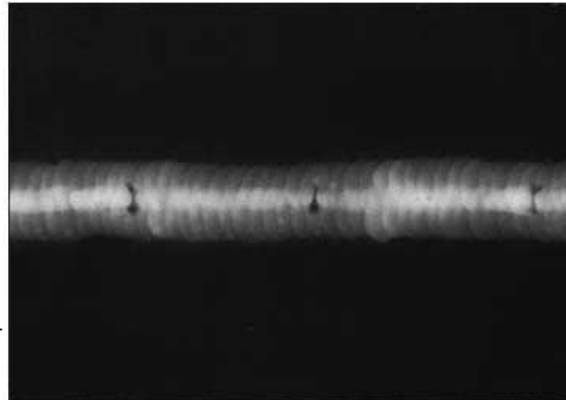
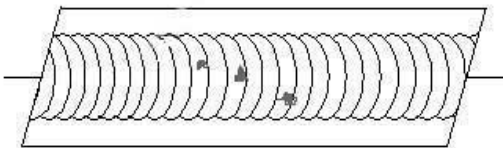
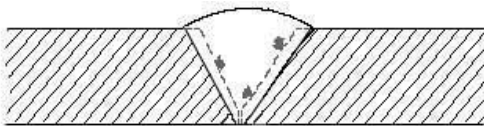
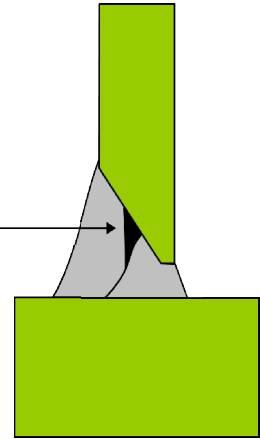


آخالهاي سرباره Slag inclusion

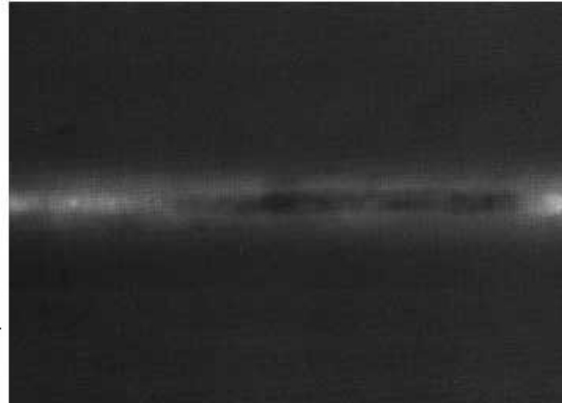
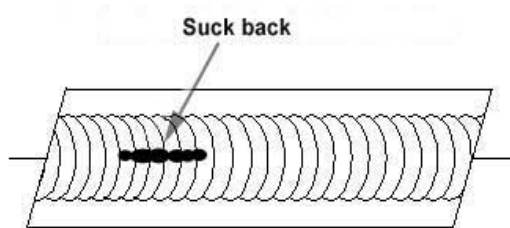
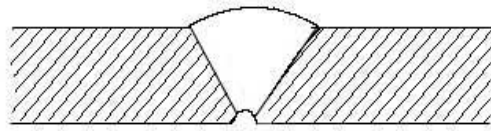


آخال

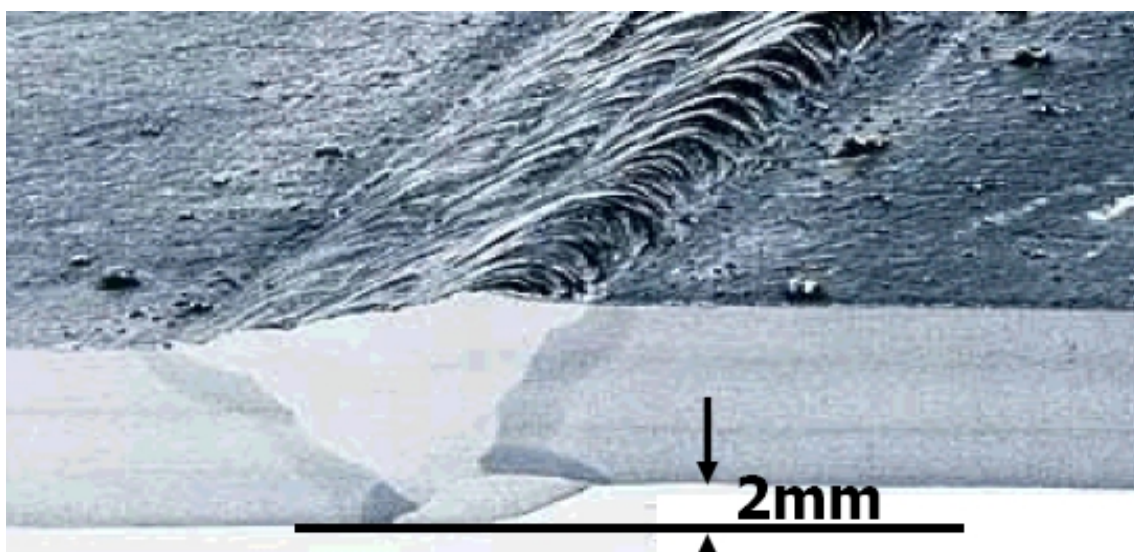
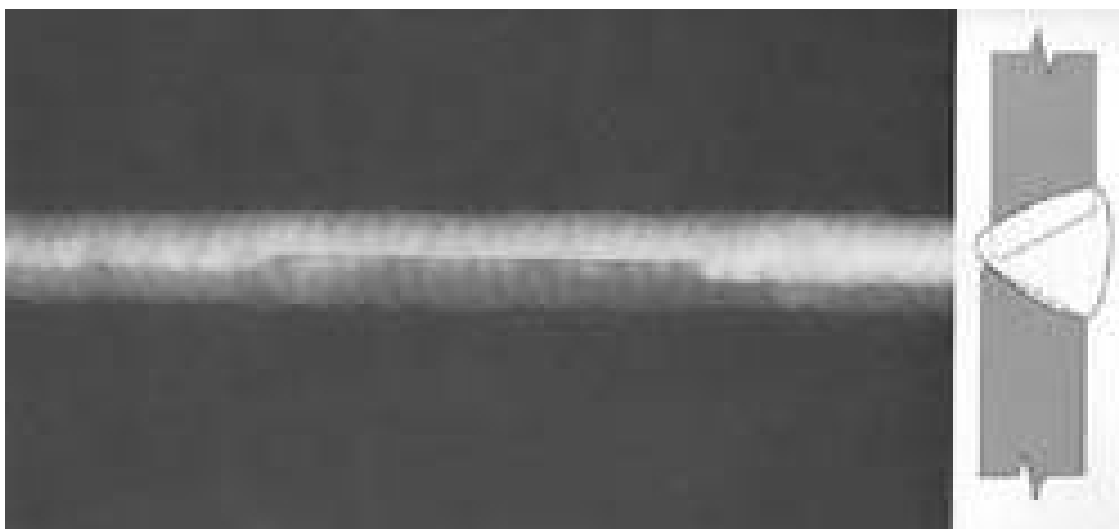
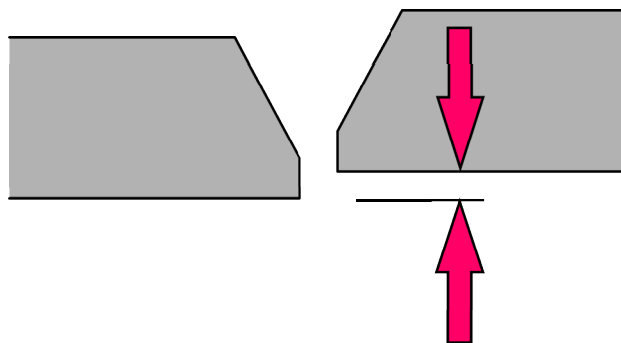
Slag inclusion



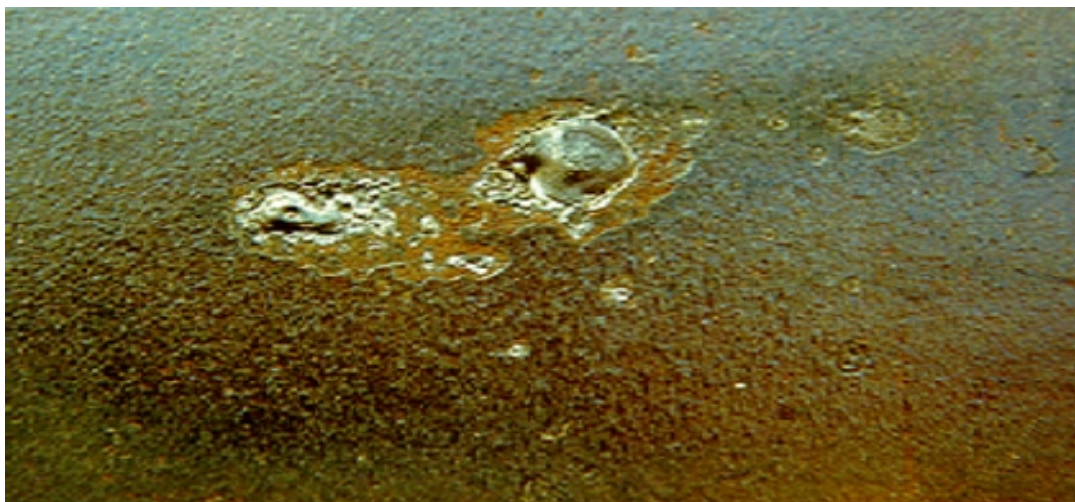
INTERNAL CONCAVITY تعقر داخلي



Join misalignment همراه نبودن اتصال جوش



لکه قوس ARC-STRICKS



روی هم افتادگی در جوشکاری سر بالا

روی هم افتادگی