

ASME B31.3-2010

(10)

Table K341.3.2 Acceptance Criteria for Welds

Type of Imperfection	Criteria (A–E) for Types of Welds, and for Required Examination Methods [Note (1)]					
	Methods		Type of Weld			
	Visual	Radiography	Girth Groove	Longitudinal Groove [Note (2)]	Fillet [Note (3)]	Branch Connection [Note (4)]
Crack	X	X	A	A	A	A
Lack of fusion	X	X	A	A	A	A
Incomplete penetration	X	X	A	A	A	A
Internal porosity	...	X	B	B	NA	B
Slag Inclusion or elongated Indication	...	X	C	C	NA	C
Undercutting	X	X	A	A	A	A
Surface porosity or exposed slag inclusion	X	...	A	A	A	A
Concave root surface (suck-up)	X	X	D	D	NA	D
Surface finish	X	...	E	E	E	E
Reinforcement or Internal protrusion	X	...	F	F	F	F

GENERAL NOTE: X = required examination; NA = not applicable; ... = not required.

Criterion Value Notes for Table K341.3.2

Criterion