

JIS

JAPANESE INDUSTRIAL STANDARD

**Method of H-type restrained
weld cracking test**

JIS Z 3159—1993

Translated and Published

by

Japanese Standards Association



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Method of H-type restrained weld cracking test

Z 3159-1993

1. Scope This Japanese Industrial Standard specifies the method of H-type restrained weld cracking test for detecting the weld cracking generated in the welds of the steel by shielded metal arc welding, gas shielded arc welding, self-shielded arc welding and submerged arc welding.

Remarks: The standards cited in this Standard are shown below.

JIS G 0565 Method for magnetic particle testing of ferromagnetic materials and classification of magnetic particle indication

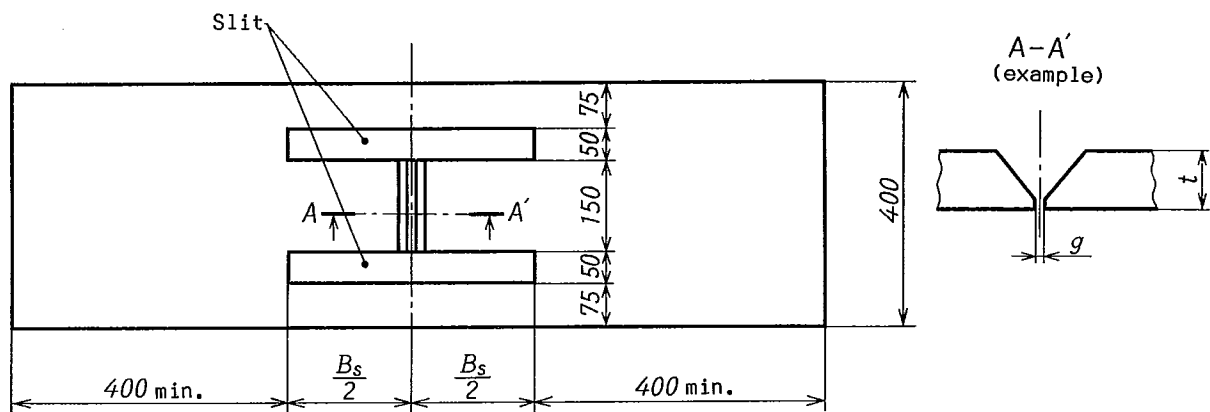
JIS Z 2343 Method for liquid penetrant testing and classification of the indication

2. Test plates

2.1 Shape and dimensions of test plates The shape and dimensions of the test plates shall conform to Fig. 1. However, it may be made T-joint or angle joint with attaching vertical plate as shown in Fig. 2.

Fig. 1. Shape and dimensions of test plates

Unit: mm



where, t : thickness of the test plate
 g : root gap
 B_s : slit length of the test plate