

ISO 5817 guide for the assessment of discontinuities and imperfections in fusion-welded joints in steel, nickel and titanium

Appearance limits	Limits for discontinuities and imperfections			Notes
	B	C	D	
General (steel) surface crack (steel) back of butt-joint (steel) back through (steel)				
Surface crack (steel)				
≤ 0.5 mm	Not permitted			Subsequent investigation for a single crack for non-destructive testing procedures Investigation through discontinuities off the steel wall
0.5 to 1 mm	Not permitted			
1 to 2 mm	Not permitted			
2 to 3 mm	Not permitted			
3 to 4 mm	Not permitted			
4 to 5 mm	Not permitted			
5 to 6 mm	Not permitted			
6 to 7 mm	Not permitted			
7 to 8 mm	Not permitted			
8 to 9 mm	Not permitted			
9 to 10 mm	Not permitted			
10 to 11 mm	Not permitted			
Steel member plates (steel)				
≤ 0.5 mm	Not permitted	Not permitted		Not permitted
0.5 to 1 mm	Not permitted	Not permitted		
1 to 2 mm	Not permitted	Not permitted		
2 to 3 mm	Not permitted	Not permitted		
3 to 4 mm	Not permitted	Not permitted		
4 to 5 mm	Not permitted	Not permitted		
5 to 6 mm	Not permitted	Not permitted		
6 to 7 mm	Not permitted	Not permitted		
7 to 8 mm	Not permitted	Not permitted		
8 to 9 mm	Not permitted	Not permitted		
9 to 10 mm	Not permitted	Not permitted		
10 to 11 mm	Not permitted	Not permitted		
Investigation steel penetration (steel)				
≤ 0.5 mm	Not permitted	Not permitted	Not permitted	Not permitted
0.5 to 1 mm	Not permitted	Not permitted	Not permitted	
1 to 2 mm	Not permitted	Not permitted	Not permitted	
2 to 3 mm	Not permitted	Not permitted	Not permitted	
3 to 4 mm	Not permitted	Not permitted	Not permitted	
4 to 5 mm	Not permitted	Not permitted	Not permitted	
5 to 6 mm	Not permitted	Not permitted	Not permitted	
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5 to 6 mm	Not permitted	Not permitted	Not permitted	
6 to 7 mm	Not permitted	Not permitted	Not permitted	
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2 to 3 mm	Not permitted	Not permitted	Not permitted	
3 to 4 mm	Not permitted	Not permitted	Not permitted	
4 to 5 mm	Not permitted	Not permitted	Not permitted	
5 to 6 mm	Not permitted	Not permitted	Not permitted	
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Table of Contents Iso 9020pocket Guide

1. Understanding the eBook Iso 9020pocket Guide
 - The Rise of Digital Reading Iso 9020pocket Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Iso 9020pocket Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Iso 9020pocket Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Iso 9020pocket Guide
 - Personalized Recommendations
 - Iso 9020pocket Guide User Reviews and Ratings
 - Iso 9020pocket Guide and Bestseller Lists
5. Accessing Iso 9020pocket Guide Free and Paid eBooks

- Iso 9020pocket Guide Public Domain eBooks
- Iso 9020pocket Guide eBook Subscription Services
- Iso 9020pocket Guide Budget-Friendly Options
- 6. Navigating Iso 9020pocket Guide eBook Formats
 - ePub, PDF, MOBI, and More
 - Iso 9020pocket Guide Compatibility with Devices
 - Iso 9020pocket Guide Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Iso 9020pocket Guide
 - Highlighting and Note-Taking Iso 9020pocket Guide
 - Interactive Elements Iso 9020pocket Guide
- 8. Staying Engaged with Iso 9020pocket Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Iso 9020pocket Guide
- 9. Balancing eBooks and Physical Books Iso 9020pocket Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Iso 9020pocket Guide
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Iso 9020pocket Guide
 - Setting Reading Goals Iso 9020pocket Guide
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Iso 9020pocket Guide
 - Fact-Checking eBook Content of Iso 9020pocket Guide
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development

- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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