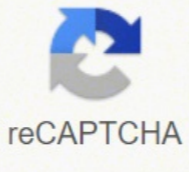




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# CRATER PIT

## DEFINITION

A hole extending into the weld resulting from shrinkage during cooling.

## PREVENTIVE ACTION

1. Remove contaminants from the joint (rust, grease, moisture, etc.) prior to welding.
2. When breaking the arc for TIG welding, rapidly pop the trigger several times to avoid sudden pull-offs. This will provide sufficient post purge of the weld puddle.

## CORRECTIVE ACTION

1. Grind the weld to sound metal.
2. Weld repair the affected area, if needed.

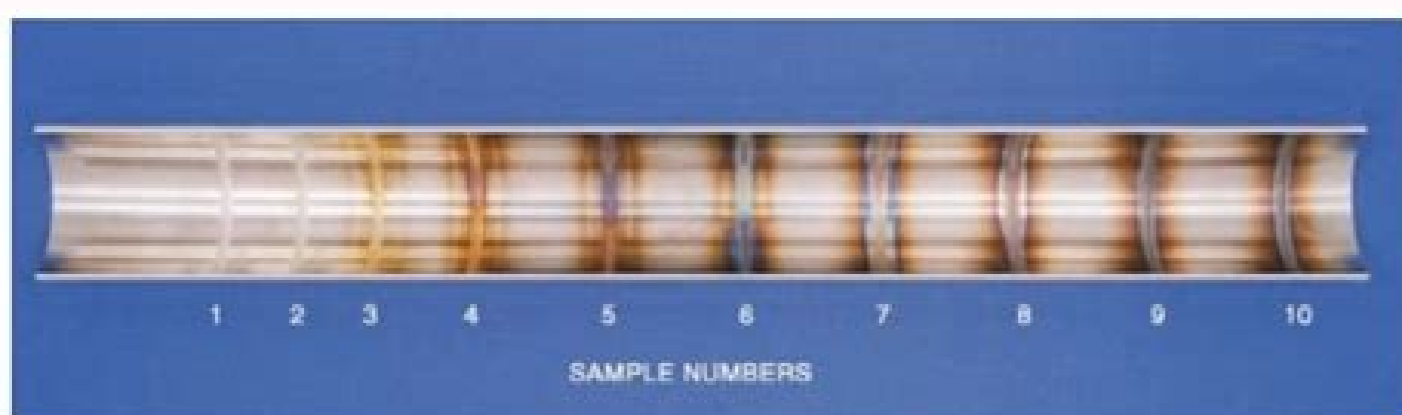


Fig. 2 — AWS D18.2 color chart — inside of orbital tube welds made on 304L with various levels of oxygen in the argon purge gas.

AWS D18.2 Cartilla de color - Interior de soldadura orbital en tubos de acero inoxidable 304L. Se ve una decoloración producida por diferentes niveles de de oxígeno en el argón usado como gas de purga.



