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JAPANESE INDUSTRIAL STANDARD

**Method of controlled thermal
severity weld cracking test**

JIS Z 3154—1993

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Method of controlled thermal severity
weld cracking test

Z 3154-1993

1. Scope This Japanese Industrial Standard specifies the method of controlled thermal severity weld cracking test for detecting cold cracking generated in the heat-affected zone of the welds of carbon steel and low alloy steel by shielded metal arc welding, gas shielded arc welding and self-shielded arc welding.

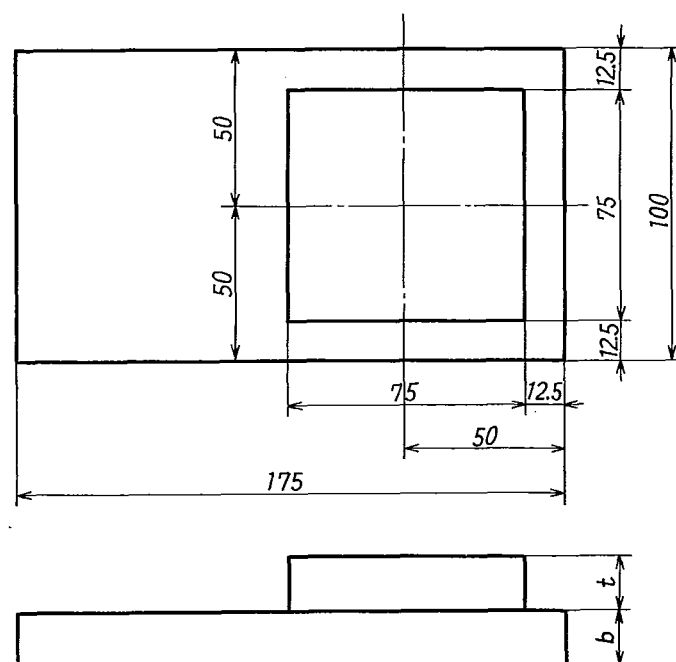
Remarks: The standards cited in this Standard are shown in Attached Table 1.

2. Test plates

2.1 Shape and dimensions of test plates The shape and dimensions of the test plates shall conform to Fig. 1.

Fig. 1. Shape and dimensions of test plates

Unit: mm



where, t : thickness of the upper plate

b : thickness of the lower plate

2.2 Preparation method of test plates

- (1) The edge surface of the upper plate to be test-welded shall be machined (In the case of thermal-cut, shave off the heat-affected zone), and the other edges may be saw-cut or thermal-cut.