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JAPANESE INDUSTRIAL STANDARD

Method of FISCO test

JIS Z 3155—1993

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Method of FISCO test

Z 3155-1993

1. Scope This Japanese Industrial Standard specifies the method of FISCO test for detecting the hot cracking generated in the welds of carbon steel, low alloy steel and stainless steel by shielded metal arc welding, gas shielded arc welding and self-shielded arc welding.

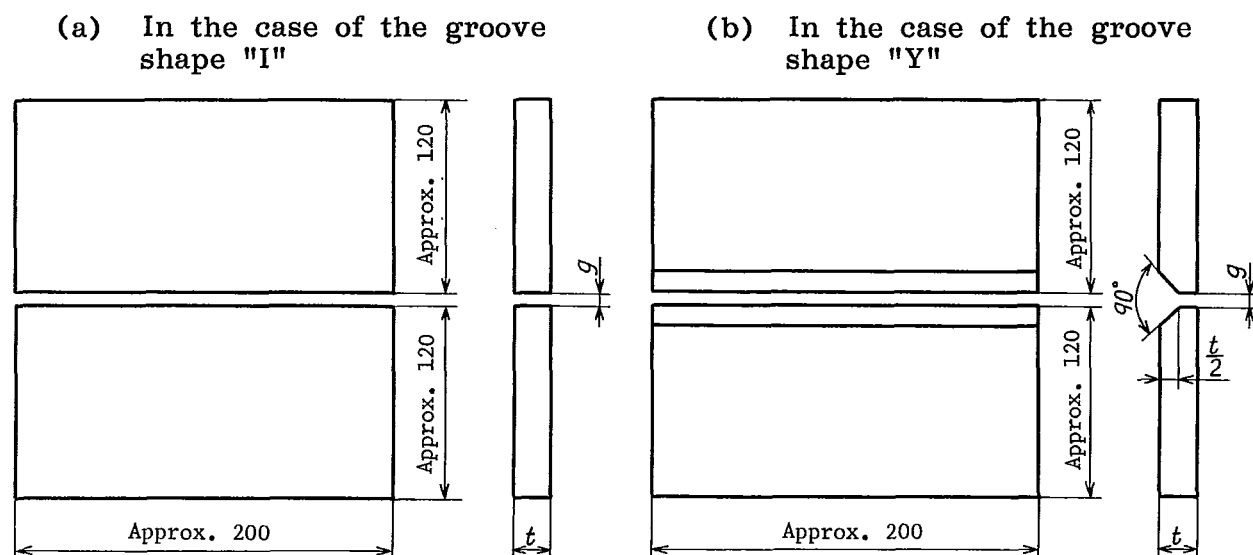
Remarks: The standards cited in this Standard are shown in Attached Table 1.

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 test plate

g : root gap

2.2 Groove shape

- (1) The groove shape of the test plates shall be of "I" shape or of "Y" shape.
- (2) The portions of the test plates to be welded shall be machined slightly on the surface for eliminating the effect of oxide film.
- (3) The root gap " g " of the test plates shall be determined by selecting the appropriate value in the range of 0 mm to 6 mm according to the welding method, the welding materials or the like, and its tolerance shall be ± 0.3 mm.