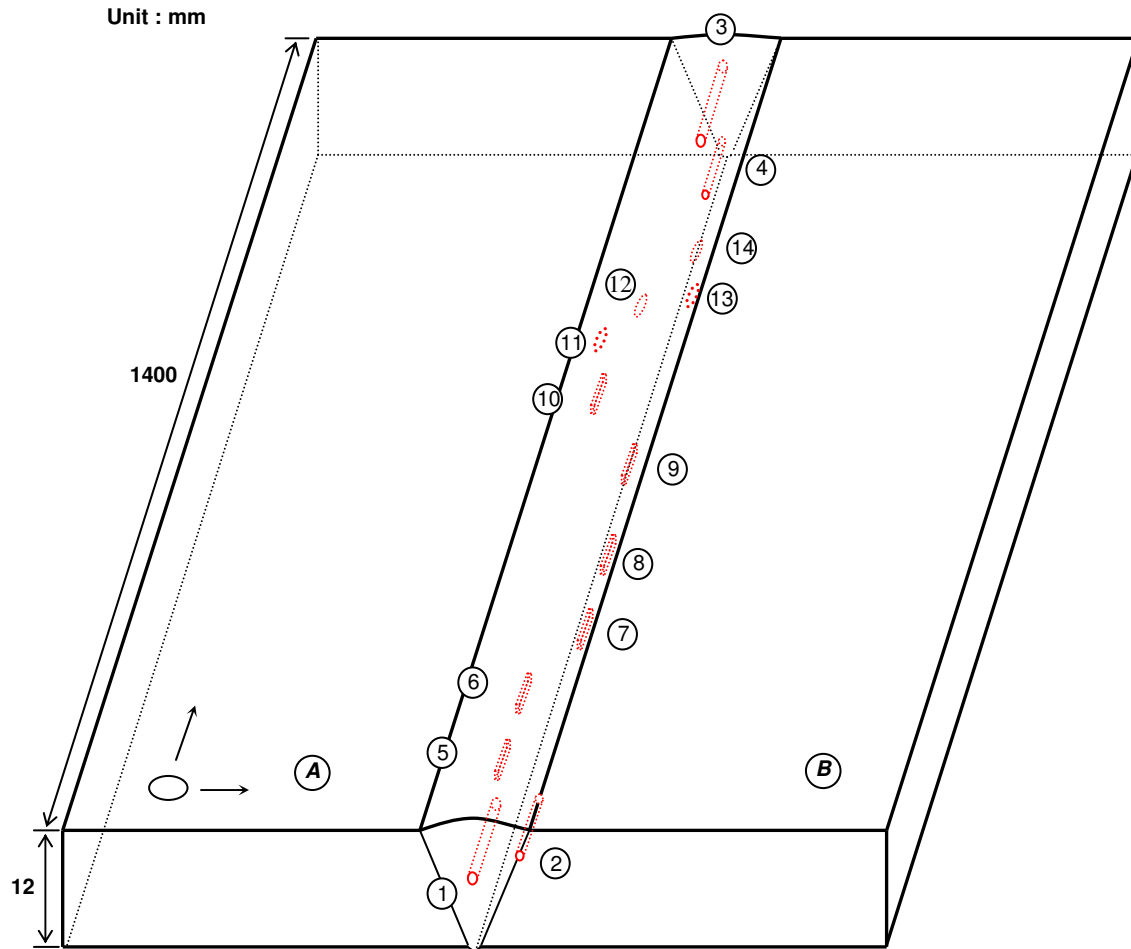
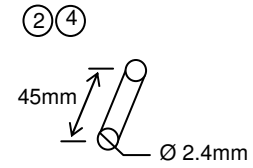
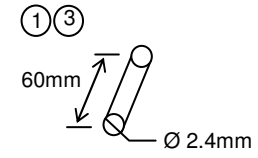
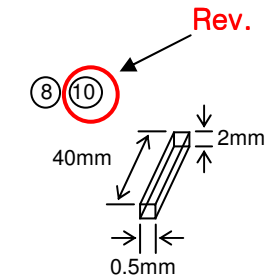
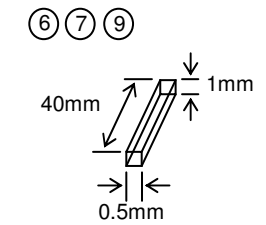
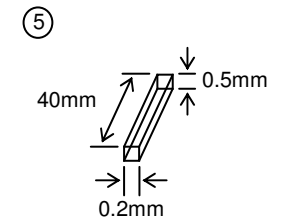
 Outline of Test Piece



* Side Drill Hole



* Slit



* Welding Defect(Lack of Fusion)

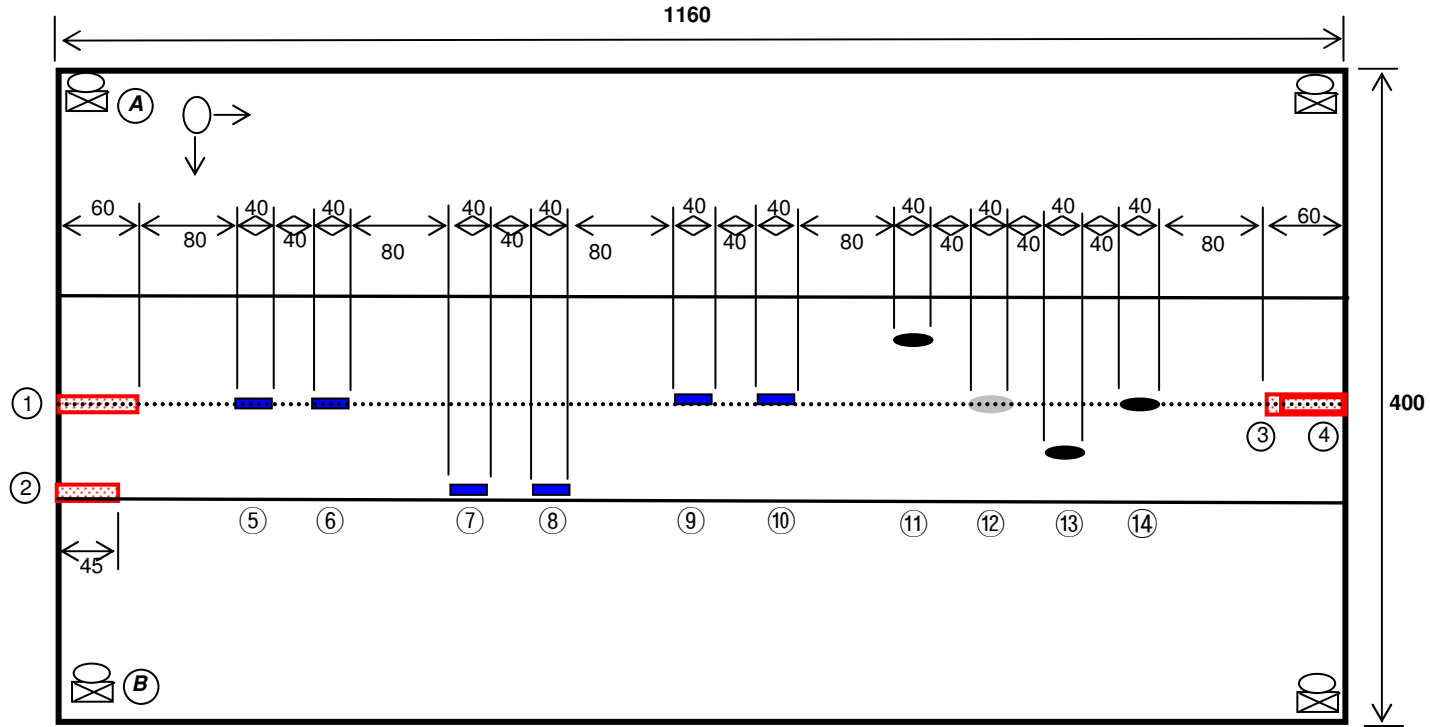
- length : 40mm ⑪ ⑬ ⑭






* Welding Defect(Blow Hole)

- length : 40mm ⑫

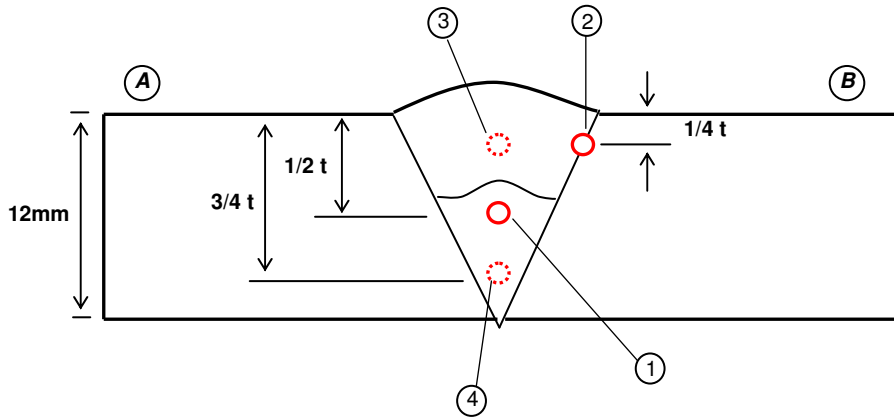
Ground Plan View of Test Piece


Unit : mm

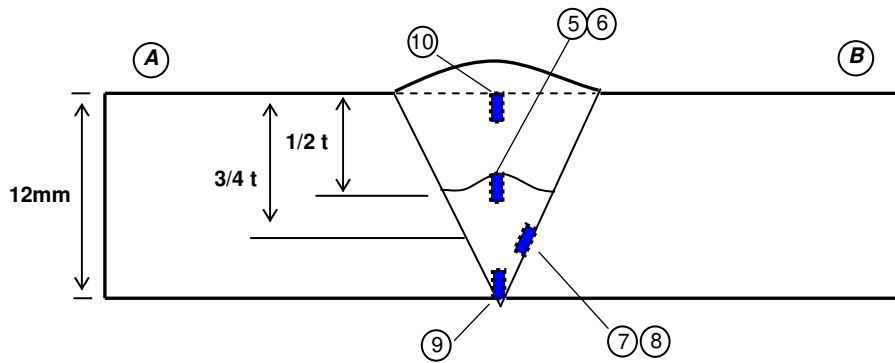



	Round hole defect(Side Drill Hole)
	Slit Defect
	Welding Defect(LF)
	Welding Defect(Blow hole)
	Lug(bolt & nut type)

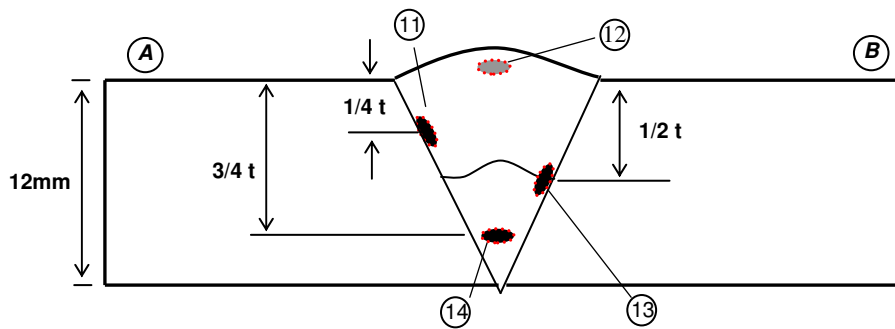
■ *Front View of Test Piece*



 Round hole defect(Side Drill Hole)



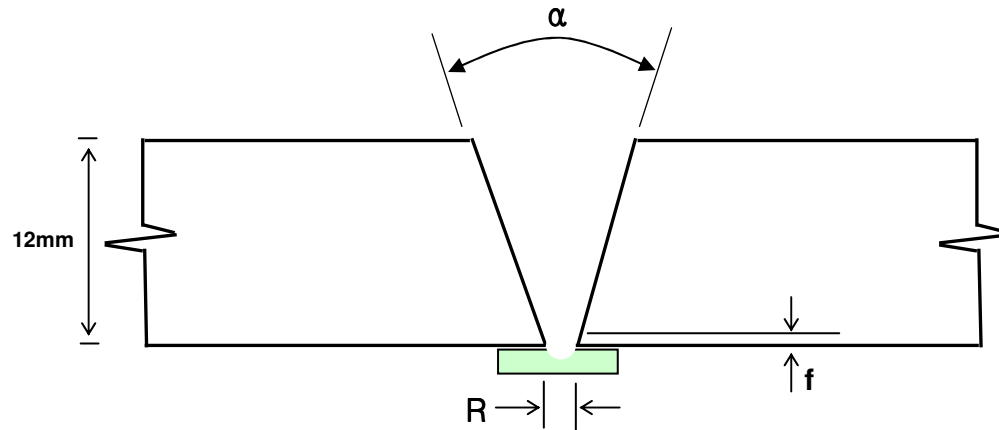
 Slit Defect



 Welding Defect(Blow hole) ⑪

 Welding Defect(LF)

Joint Detail



$$\alpha = 45^{\circ}, R = 5, f = 0$$

PQR data

Thickness (mm)	Backing	Welding Process	Filler Metal	Welding Position	Base metal
12	ceramic backing	FCAW	E308LT-1	1G,2G,3G	SUS 304