CSI
AL6XN
Welding Samples

For ASME BPE and other High Purity applications

Photos #1- #6: Acceptable Welds
Photos #7- #12: Unacceptable Welds

Tom O'Connor, CWI
CSI Quality Control Manager
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-P25 Ferrule to -P7 Tube

-7 Ferrule to -P25 Tube

-P7 Tube to -P7 Tube

-P25 Tube to -P25 Tube

Acceptable AL6XN Welds
Sample Board

-P25 Tube to -P25 Tube

-P7 Tube to -P25 Tube
-P7 Tube to -P7 Tube
-P25 Ferrule to -P7 Tube
-P25 Tube to -P25 Tube
-P25 Tube to -P25 Tube
-7 Ferrule to -P25 Tube
Incomplete Penetration
Oxidized Tack Weld
Discoloration HAZ

Tack Weld Unconsumed
Oxidized Tack Weld
Discoloration HAZ

Welded Without
Alloy Insert Ring

Metal Shaving In Weld
Undeburred Tube Cut

Discoloration HAZ

Lack of Fusion

Unacceptable
AL6XN Welds
Sample Board
Incomplete Penetration
Oxidized Tack Weld
Discoloration HAZ
Metal Shaving In Weld
Undeburred Tube Cut

Photo #10
Welded Without Alloy Insert Ring