



All welds shall be visually inspected throughout their entire length.
If surface breaking defects are detected, surface testing by penetrant testing or magnetic particle inspection shall be carried out on the inspected weld.

The visual inspection shall be performed after completion of welding in an area and before any other NDT inspection carried out.

For EXC2 welds, the extent of supplementary NDT is specified in table 24 EN 1090-2:2018+A1:2024. Testing must be carried out in all blue marked zones.

Welds described by green, as 100% have to be inspected as fully tested weld (e.g. perimeter weld).
Butt welds are recommended to be tested UT (ultrasonic testing), fillet welds are recommended to be tested MT (magnetic particle testing); unmarked zones at the technologist's recommendations.

The supplementary NDT of a weld shall generally not be completed until after the minimum hold time after welding according to table 23 EN 1090-2:2018+A1:2024.

To avoid lamellar tearing, the components must be heated prior to welding - see table 3.2 of EN 1993-1-10 ($\geq 100^{\circ}\text{C}$)

(Drawing to be read in conjunction with workshop assembly drawings)