



Deprecated per ISO5817
 style orthodoxies =
 * "poor" weld bead shape
 / fillet mitre shape
 * undulating c-x along length
 * borderline toe-groove (D.N.5011)

However:
 * HIGH FATIGUE
 PERFORMANCE

Very favoured per ISO5817
 style orthodoxies =
 * perfect weld bead shape
 / perfect fillet mitre

However:
 * LOW FATIGUE
 PERFORMANCE

Fatigue endurance fall
 [rapid / steep]

Loss of section on toe-groove
 [shallow / gradual]

Confused welding style
 [shallow / gradual]

Cold lap defects
 [very rapid / very steep]

"Mode High EXC3" →

"Mode Low EXC2" →

Weld "service quality"

Weld "balance of conditions"