**Visual Inspection Criteria**

1. There shall be no cracks or incomplete fusion.

2. There shall be no incomplete joint penetration in groove welds except as permitted for partial joint penetration groove welds.

3. The Test Supervisor shall examine the weld for acceptable appearance, and shall be satisfied that the welder is skilled in using the process and procedure specified for the test.

4. Undercut shall not exceed the lesser of 10% of the base metal thickness or 1/32 in. (0.8 mm).

5. Where visual examination is the only criterion for acceptance, all weld passes are subject to visual examination, at the discretion of the Test Supervisor.

6. The frequency of porosity shall not exceed one in each 4 in. (100 mm) of weld length and the maximum diameter shall not exceed

3/32 in. (2.4 mm).

7. Welds shall be free from overlap.