

Table 24 — Extent of routine supplementary NDT

Type of weld	Shop and site welds		
	EXC1	EXC2	EXC3 <sup>a</sup>
Transverse butt welds and partial penetration welds in butt joints:	0 % <sup>b</sup>	10 %	20 %
Transverse butt welds and partial penetration welds:			
— in cruciform joints	0 % <sup>b</sup>	10 %	20 %
— in T joints	0 %	5 %	10 %
Transverse fillet welds <sup>c</sup> :			
with $a > 12\text{mm}$ or $t > 30\text{mm}$	0 %	5 %	10 %
with $a \leq 12\text{mm}$ and $t \leq 30\text{mm}$	0 %	0 %	5 %
Full penetration longitudinal welds <sup>d</sup> between web and top flange of crane girders	0 %	10 %	20 %
Other longitudinal welds <sup>d</sup> , welds to stiffeners and welds specified in the execution specification as being in compression	0 %	0 %	5 %
<sup>a</sup> For EXC4 the percentage extent shall be at least that given for EXC3. <sup>b</sup> 10 % for such welds executed in steel S120. <sup>c</sup> Terms $a$ and $t$ refer respectively to the throat thickness and the thickest material being joined. <sup>d</sup> Longitudinal welds are those made parallel to the component axis. All others are considered as transverse welds.			

The execution specification may identify specific joints for inspection together with the extent and method of testing (see 12.4.2.4). This testing may be counted within the extent of routine testing as appropriate.

If inspection gives non-conforming results, investigation shall be carried out in order to find the reason. The guidance in EN ISO 17635:2016, Annex C should be followed.

#### 12.4.2.4 Project specific inspection and testing

For EXC1, EXC2 and EXC3, the execution specification may identify requirements for production testing and specific joints for inspection together with the extent of testing.

For EXC4 execution specification shall identify specific joints for inspection together with the extent of testing, which shall be that specified for EXC3 as a minimum.

If specified, weld inspection classes (WICs) may be used to classify specific welds for inspection, and in this respect to define the scope and percentage extent of supplementary testing and the test methods to be used according to the criticality of the weld (see Annex L for guidance). If weld inspection classes (WICs) are used, the execution specification shall be used to identify the weld inspection class (WIC) for each relevant weld.

#### 12.4.2.5 Visual inspection of welds

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

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