

Measures the following:

- * cap reinforcement from 0 to 7/16"
- * undercut and pit from 0 to 1/4" deep
- * fillet leg from 0 to 1"
- * fillet throat from 0 to 7/8"
- * fillet hypotenuse
- * hi-lo from 0 to 7/8"
- * bevel angle from 0 to 90 °
- * porosity 1/16" and 1/8"
- * weld width from 0 to 1-3/8"
- * concavity, convexity, and overlap
- * complete weld profile
- * accuracy capability to 1/64"
- * all butt weld dimensions at once
- * all fillet weld dimensions at once

General Recommendations

To measure hi-lo on welded joint, set one gauge leg on the highest base-metal plane. Slowly lower other side of gauge until the pins are level with the dimension lines. Press the Profile Hold Button and read dimension.

If the weld or joint being measured is not in the flat position, keep slight pressure on button while pushing pins forward until they conform to the profile on the tips of the pins, or use the slots on the back of pins.

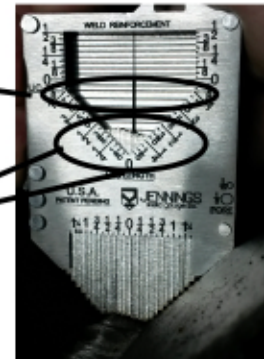
Fillet Weld

Place gauge on weld and press Profile Hold button firmly.

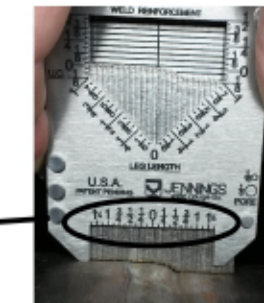
Read throat from this scale on the right side.



Measure convexity and concavity from this scale (under zero).



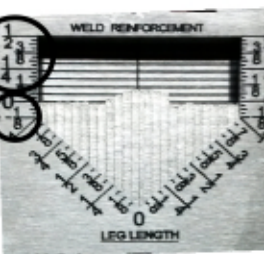
Read both fillet legs from these scales.



Butt Weld

Place gauge on weld and press Profile Hold button firmly.

Read width from this scale.



Read reinforcement from this scale.

Read undercut from this scale.



Hi-Lo

Set gauge on highest plane; raise dial indicator until it stops. Read from this scale.

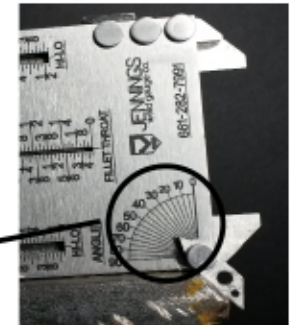


Read Hi-Lo after weld completion from these scales. Read under fill from this scale on the left.



Bevel Angle

Set dial to 0°. Set gauge flush on base metal; slide back until dial conforms to bevel. Read from this scale.



Porosity Diameter

Flip out Protractor. Compare pore to 1/16" or 1/8" holes.



Undercut

Set gauge on base metal; raise dial indicator until it stops. Read from this scale.

