

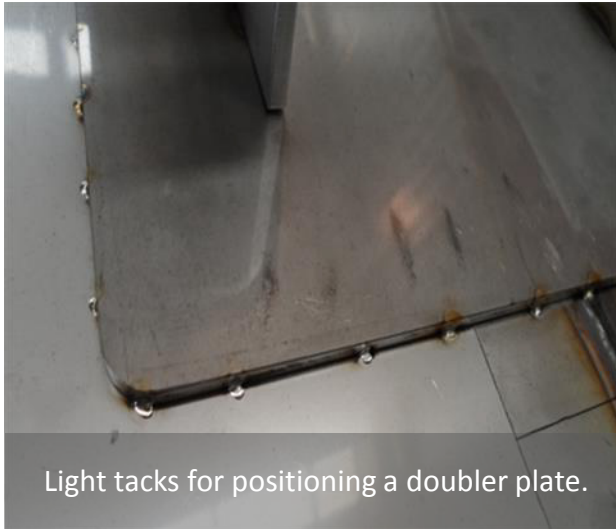
Weld Finishes



FINISH TYPE	APPEARANCE	PROCEDURE	APPLICATION
LOCAL BLAST	Bead Blasted Weld Area	Bead blast minimum possible area to remove weld burn	<i>Most cost effective alternative to acid passivation</i>
STRIP BLAST	Bead Blasted weld area with masked edges	Bead blast weld area, plus surrounding area, up to sharp masked defined edges	<i>More cost effective alternative to acid passivation.</i>
ACID CLEAN AND SCOTCH BRITE	Non uniform brushed finish	Pickle/Passivate welds by applying acid, leave to soak then rinse with water and polish by hand with scotch brite to blend acid stain. A strip buff without masked edges will be used for long runs.	<i>Traditional basic weld finish</i>
STRIP BUFF	Brushed/Buffered appearance with visible protruding weld bead and masked edges	Passivate with acid, then buff over weld with 180 grit buffing wheel.	<i>External welds on tanks. More cost effective than acid & scotch brite for long runs</i>
STRIP POLISH	Brushed weld area with no visible weld bead	Remove weld bead by grinding and polishing to 0.8 Ra	<i>Dairy, USDA, 3A, Hygiene</i>

Weld Finishes

EXAMPLES



Light tacks for positioning a doubler plate.



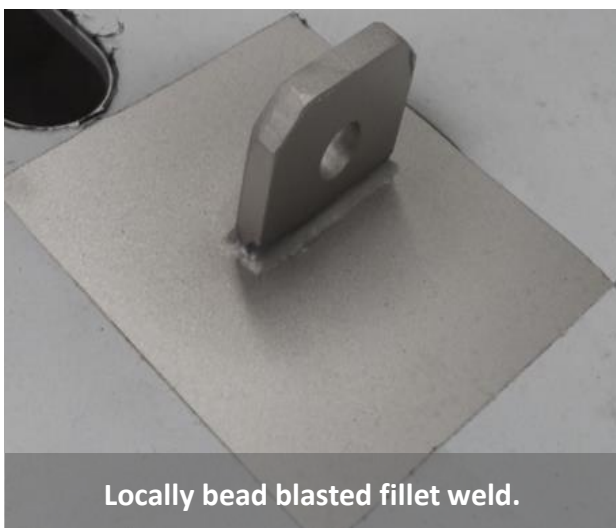
Local beadblast to remove heat marks due to welding on opposite side of material.



Locally beadblasted plug welds.



Dual butt weld on 3.0mm 2B stainless left "as laid".



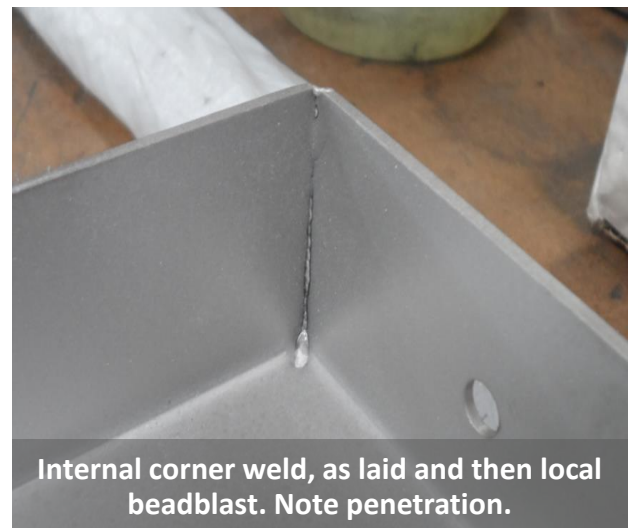
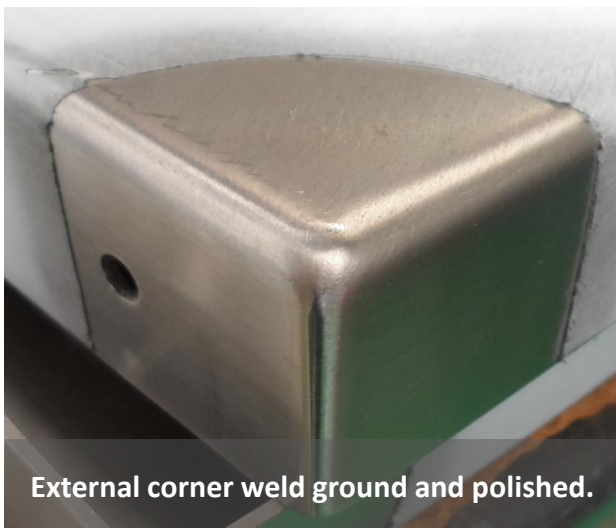
Locally bead blasted fillet weld.



Heat marks on opposite side of tabbed plug weld.

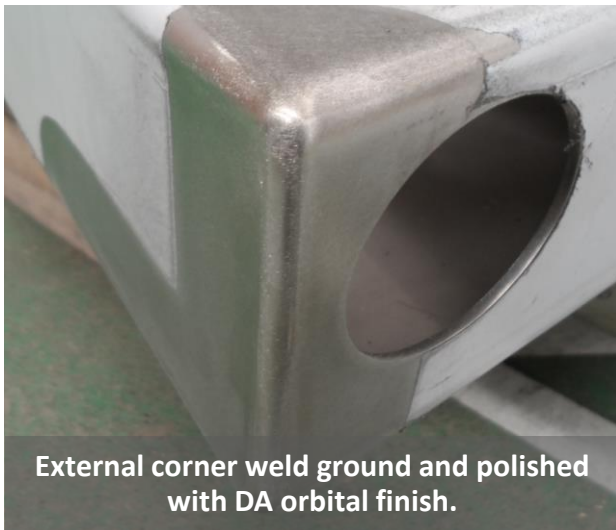
Weld Finishes

EXAMPLES



Weld Finishes

EXAMPLES



Weld Finishes

EXAMPLES

