

پترو فرهان گستر جنوب

## The welding gauge

HJC60



## Instruction for use

FGJ-NDT.IR  
DIGINDT.IR

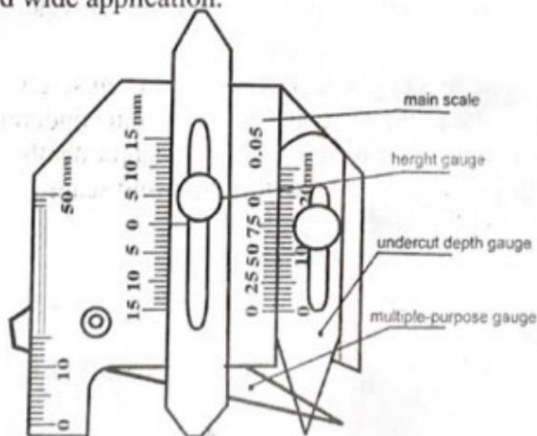
+982165565901  
+982144584619  
+989034119385

### Operation Guide

#### 1) Brief Introduction

The Gauge consists of four components: main scale, height gauge, undercut depth gauge and multiple-purpose gauge and is specially used for the measurement of the bevel angle, height, width, gap and undercut depth of weldment, suitable for the detection of boilers, bridges, ships, pressure vessels and oil pipes.

It is made of stainless steel and is characterized by portable and compact structure, easy operation and wide application.



پترو فرهان گستر جنوب

#### 2) Operation Guide:

##### I) Measurement of height of flat weld:

Set the undercut depth gauge to Zero and fasten screw, then slide the height gauge to contact the weld spot. The reading of the height gauge is the height of the flat weld.

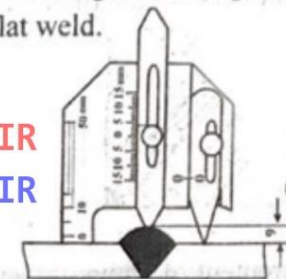


Chart One

FGJ-NDT.IR  
DIGINDT.IR

##### II) Measurement of height of flat weld:

Contact the measuring face of the Gauge tightly to weldment and weld spot and then slide the height gauge to contact the other side of the weldment. The reading of the height gauge is the height of the fillet weld.

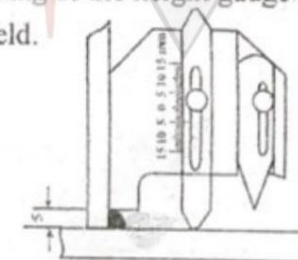


Chart Two

## پترو فرهان گستر جنوب

III) Measurement of thickness of fillet weld:  
Contact the measuring face of the main scale tightly to weldment and then slide the height gauge to contact weld spot. The reading of the height gauge is the thickness of the fillet weld.

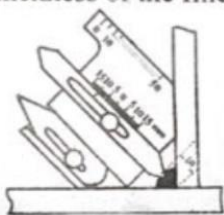


Chart Three

IV) Measurement of width of weld seam:  
Contact the measuring face of the main scale tightly to one side of the weld seam and rotate the measuring face of the multiple-purpose gauge to tightly contact the other side of the weld seam. The reading of the multiple-purpose gauge is the width of the weld seam.

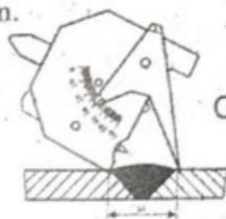


Chart Four

FGJ-NDT.IR  
DIGINDT.IR

+982165565901  
+982144584619  
+989034119385

V) Measurement bevel angle of weldment:

Use the main scale combination with multiple-purpose gauge according to needed bevel angle of weldment to measure the angle between the measuring face of the main scale and that of the multiple-purpose gauge. The reading of the multiple-purpose gauge is the bevel angle of the weldment.

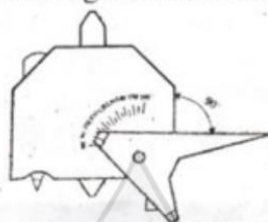


Chart Five

VI) Measurement of undercut depth of weld seam:

Set the height gauge to Zero and fasten screw, then measure the undercut depth with the undercut depth gauge. The reading of the undercut depth gauge is the undercut depth of the weld seam.

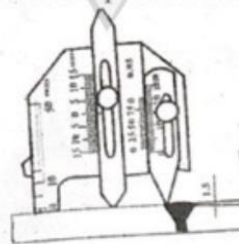


Chart Six

پترو فرهان گستر جنوب

## پترو فرهان گستر جنوب

VII) Measurement of gap size:

Put the multiple-purpose gauge between two weldments to contact the measuring face of the gauge tightly to the two weldments. The reading of the gauge is the gap size.

FGJ-NDT.IR  
DIGINDT.IR

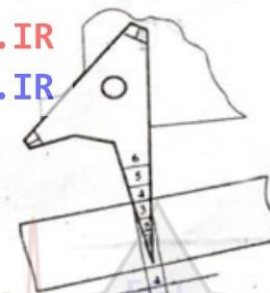


Chart Seven

### 3) Important Information:

- I) The gauge can not be put together with other tools to avoid scuffing or breakage.
- II) Do not clean the graduation part of the gauge with amyl acetate.
- III) The gap meter of the multiple-purpose gauge can't be used as tool for other purposes.