

Assesing the competition welds by measurement

| Method 111 | Weld | Item | Size, number | Points | Size | Points | Size | Points | Size | Points | |
|------------|------------|--|--|------------|----------|---------------------------------------|--------|--------|--------|--------|------|
| | | | | | | | | | | | Size |
| Method 111 | Weld BW PF | Surface | Superelevation | 1~2 | 6 | >2~3 | 4 | >3~4 | 2 | <1, >4 | 0 |
| | | | Width- difference between the widest and the narrowest | to 0,5 | 6 | >0,5~1 | 4 | >1~2 | 2 | >2 | 0 |
| | | | Undercut - length | 0 | 6 | deduction of 1 point for 2mm undercut | | | | | |
| | | | Incompletely filled groove | 0 | 6 | deduction of 1 point for 5mm | | | | | |
| | | | Crater shrinkage cavity-incomplete filling | 0 (number) | 6 | 1 | 4 | 2 | 2 | >3 | 0 |
| | Root | Root penetration | 1~2 | 6 | >2~3 | 4 | >3~4 | 2 | <1, >4 | 0 | |
| | | Thin root - 515 | 0 | 6 | >0~3 | 4 | >3~7 | 2 | >7 | 0 | |
| | | Notch in root, crater shrinkage cavity | 0 (number) | 6 | 1 | 4 | 2 | 2 | >3 | 0 | |
| | Geometry | Linear misalignment | 0~0,4 | 6 | >0,4~0,6 | 4 | >0,6~1 | 2 | >1 | 0 | |
| | | Angular misalignment | 0~1° | 6 | >1°~2° | 4 | >2°~4° | 2 | 4° | 0 | |

| Method 135 | Weld | Item | Size | Points | Size | Points | Size | Points | Size | Points | |
|------------|------------|--|---|------------|----------|---------------------------------------|--------|--------|--------|--------|------|
| | | | | | | | | | | | Size |
| Method 135 | Weld BW PF | Surface | Superelevation | 1~2 | 6 | >2~3 | 4 | >3~4 | 2 | <1, >4 | 0 |
| | | | Width-difference between the widest and the narrowest | to 0,5 | 6 | >0,5~1 | 4 | >1~2 | 2 | >2 | 0 |
| | | | Undercut | 0 | 6 | deduction of 1 point for 2mm undercut | | | | | |
| | | | Incompletely filled groove | 0 | 6 | deduction of 1 point for 5mm | | | | | |
| | | | Crater shrinkage cavity-incomplete filling | 0 (number) | 6 | 1 | 4 | 2 | 2 | >3 | 0 |
| | Root | Root penetration | 1~2 | 6 | >2~3 | 4 | >3~4 | 2 | <1, >4 | 0 | |
| | | Thin root - 515 | 0 | 6 | >0~3 | 4 | >3~7 | 2 | >7 | 0 | |
| | | Notch in root, crater shrinkage cavity | 0 (number) | 6 | 1 | 4 | 2 | 2 | >3 | 0 | |
| | Geometry | Linear misalignment | 0~0,4 | 6 | >0,4~0,6 | 4 | >0,6~1 | 2 | >1 | 0 | |
| | | Angular misalignment | 0~1° | 6 | >1°~2° | 4 | >2°~4° | 2 | 4° | 0 | |

| Metoda 141 | Weld | Item | Size | Points | Size | Points | Size | Points | Size | Points | |
|------------|------------|--|---|------------|----------|---------------------------------------|--------|--------|--------|--------|------|
| | | | | | | | | | | | Size |
| Metoda 141 | Weld BW PF | Surface | Superelevation | 1~2 | 6 | >2~3 | 4 | >3~4 | 2 | <1, >4 | 0 |
| | | | Width-difference between the widest and the narrowest | to 0,5 | 6 | >0,5~1 | 4 | >1~1,5 | 2 | >2 | 0 |
| | | | Undercut | 0 | 6 | deduction of 1 point for 2mm undercut | | | | | |
| | | | Incompletely filled groove | 0 | 6 | deduction of 1 point for 5mm | | | | | |
| | | | Crater shrinkage cavity-incomplete filling | 0 (number) | 6 | 1 | 4 | 2 | 2 | >3 | 0 |
| | Root | Root penetration | 1~2 | 6 | >2~3 | 4 | >3~4 | 2 | <1, >4 | 0 | |
| | | Thin root - 515 | 0 | 6 | >0~3 | 4 | >3~7 | 2 | >7 | 0 | |
| | | Notch in root, crater shrinkage cavity | 0 (number) | 6 | 1 | 4 | 2 | 2 | >3 | 0 | |
| | Geometry | Linear misalignment | 0~0,4 | 6 | >0,4~0,6 | 4 | >0,6~1 | 2 | >1 | 0 | |
| | | Angular misalignment | 0~1° | 6 | >1°~2° | 4 | >2°~4° | 2 | 4° | 0 | |

| Metoda 311 | Weld | Item | Size | Points | Size | Points | Size | Points | Size | Points | |
|------------|------------|--|---|------------|----------|---------------------------------------|--------|--------|--------|--------|------|
| | | | | | | | | | | | Size |
| Metoda 311 | Weld BW PF | Surface | Superelevation | 1~2 | 6 | >2~3 | 4 | >3~4 | 2 | <1, >4 | 0 |
| | | | Width-difference between the widest and the narrowest | to 0,5 | 6 | >0,5~1 | 4 | >1~2 | 2 | >2 | 0 |
| | | | Undercut | 0 | 6 | deduction of 1 point for 2mm undercut | | | | | |
| | | | Incompletely filled groove | 0 | 6 | deduction of 1 point for 5mm | | | | | |
| | | | Crater shrinkage cavity-incomplete filling | 0 (number) | 6 | 1 | 4 | 2 | 2 | >3 | 0 |
| | Root | Root penetration | 1~2 | 6 | >2~3 | 4 | >3~4 | 2 | <1, >4 | 0 | |
| | | Thin root - 515 | 0 | 6 | >0~3 | 4 | >3~7 | 2 | >7 | 0 | |
| | | Notch in root, crater shrinkage cavity | 0 (number) | 6 | 1 | 4 | 2 | 2 | >3 | 0 | |
| | Geometry | Linear misalignment | 0~0,4 | 6 | >0,4~0,6 | 4 | >0,6~1 | 2 | >1 | 0 | |
| | | Angular misalignment | 0~1° | 6 | >1°~2° | 4 | >2°~4° | 2 | 4° | 0 | |