PIT vs. TIG dressing on a steering arm for agricultural machinery



This project clearly shows the better effect of a PIT treatment compared to TIG post-treatment (TIG dressing)

without PIT the crack occurs directly at the weld toe.



OCAS N.V.



R&D Projekt Durimprove



after the PIT treatment, a significantly later transition of WEZ



	900000						
	800000						
S	700000						
# cycles	600000						
	500000						
Average	400000						
Ave	300000						
	200000						
	100000						
	0						
		S355 as welded	S355 + PIT	S355 + TIG dressing	S690QL as welded	S690QL+ PIT	S690QL+ TIG dressing

Condition	Average # cycles
S355 as welded	120.104
S355 + PIT	464.844
S355 + TIG dressing	169.276
S690QL as welded	270.663
S690QL + PIT	776.133
S690QL + TIG dressing	163.648