1. **FILLET THIN–THIN**
   - **Vertical**
   - Overlap halfway along length
   - **Visual:** 25–38 mm long
     - 3–8 mm wide
   - **Destructive:** Tearout from top coupon for the length of the weld

2. **OPEN BUTT THIN–THIN**
   - **Vertical**
   - Butt 2 coupons along length
   - **Visual:** 25–38 mm long
     - 3–8 mm wide
   - **Backside:** Evidence of complete fusion
   - **Destructive:** Fold faces onto each other, no cracking in weld backside along length

3. **PLUG THIN–THICK**
   - **Vertical**
   - Overlap coupons halfway to form a "T," 6 mm hole in top thin coupon
   - **Visual:** 8–10 mm nugget diameter / backside melt-through 5–8 mm diameter

4. **PLUG THIN–THIN**
   - **Vertical**
   - Overlap coupons on corner, 90°, 6 mm hole in top coupon
   - **Visual:** 8–10 mm nugget diameter
   - **Destructive:** 3–8 mm hole in bottom coupon

5. **PLUG THICK–THICK**
   - **Vertical**
   - Overlap coupons on corner, 90°, 8 mm hole in top coupon
   - **Visual:** 10–13 mm nugget diameter
   - **Destructive:** 5–10 mm hole in bottom coupon
6. **BUTT WITH BACKING THICK–THICK**  
**Vertical**  
Butt 2 coupons along length with backing of same thickness  
Visual: 25–38 mm long  
5–10 mm wide  
Destructive: Tearout from top coupons for the length of the weld

7. **FILLET THIN–THIN**  
**Overhead**  
Overlap 2 coupons halfway along length  
Visual: 25–38 mm long  
3–8 mm wide  
Destructive: Tearout from top coupon for the length of the weld

8. **OPEN BUTT THIN–THIN**  
**Overhead**  
Butt 2 coupons along length  
Visual: 25–38 mm long  
3–8 mm wide  
Backside: Evidence of complete fusion  
Destructive: Fold faces onto each other, no cracking in weld backside along length

9. **PLUG THIN–THICK**  
**Overhead**  
Overlap coupons halfway to form a "T," 6 mm hole in top thin coupon  
Visual: 8–10 mm nugget diameter / backside melt-through  
5–8 mm diameter

10. **BUTT WITH BACKING THIN–THIN**  
**Overhead**  
Butt 2 coupons along length with backing of same thickness  
Visual: 25–38 mm long  
3–8 mm wide  
Destructive: Tearout from top coupons for the length of the weld