Oxidation colours have many different variations. We have assembled a few here as guidelines.

**Legend:**
- **1a:** Excellent gas coverage (Norsok).
- **1b:** Acceptable gas protection (Norsok).
- **1c:** Acceptable providing that blue areas are intermittent (Norsok).
- **1d:** Acceptable providing brown areas close to the weld are narrow and light coloured (Norsok).
- **1e, 1f and 1g:** Poor back purge not acceptable.

**Oxidation colours need to be eliminated for most applications today.**

Use a **Weld Purge Monitor®** to eliminate oxygen to prevent oxides from forming and save the additional work load involved in removing the oxide film.

Use **Argweld® PurgEye® Weld Purge Monitors®** to detect oxygen levels down to 10 ppm to eliminate oxidation, weld reject and potential weld failure.

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**Heat Tint Recognition Chart For Stainless Steel Welding**

**Pictures 1a to 1g provided by Norsok for the Norsok Standard M-601 Welding and Inspection of Piping (Edition 5 April 2008) (Annex B).**

**2018: These are the results of HFT® research using Argweld® Weld Purge Monitors®.**

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**Heat Tint AWS-D18.2_1999 Guide for weld discolouration levels inside Austenitic Stainless Steel Tube**

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Huntingdon Fusion Techniques HFT® with over 40 years of high integrity, totally ethical business practices.

The only innovators and developers of Weld Purging Products.

The owners of the Weld Purge Monitor® Registered Trade Mark.

For more information, please contact hft@huntingdonfusion.com