

MATHEY DEARMAN

Q.C. WELDER'S GAUGE



D253E
(English)

D253M
(Metric)

MATHEY DEARMAN

Q.C. WELDER'S GAUGE

The Mathey Dearman's Q.C. Welder's Gauge measures inside "Hi-Lo" and welding gap. This tool helps the user to avoid Q.C. rejections. Read directions inside.

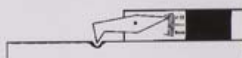
Also Available:

Pit-Depth Gauge (Cat No. D254)

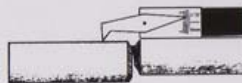
The Pit-Depth Gauge mounts on the end of the Q.C. Welder's Gauge housing. It can be used to measure pit-depth, weld height, and "Hi-Lo". This product is not included and is sold separately.



Measuring
Weld Height



Measuring
Pit Depth



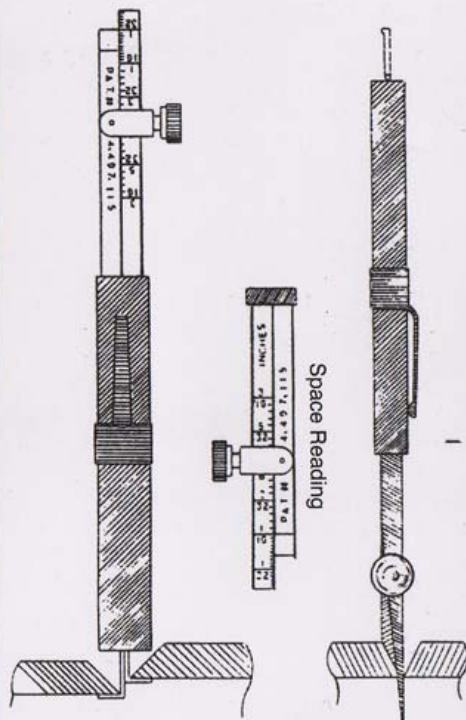
Measuring
Outside Hi-Lo

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Cat No. D253E (English)
or
Cat No. D253M (Metric)



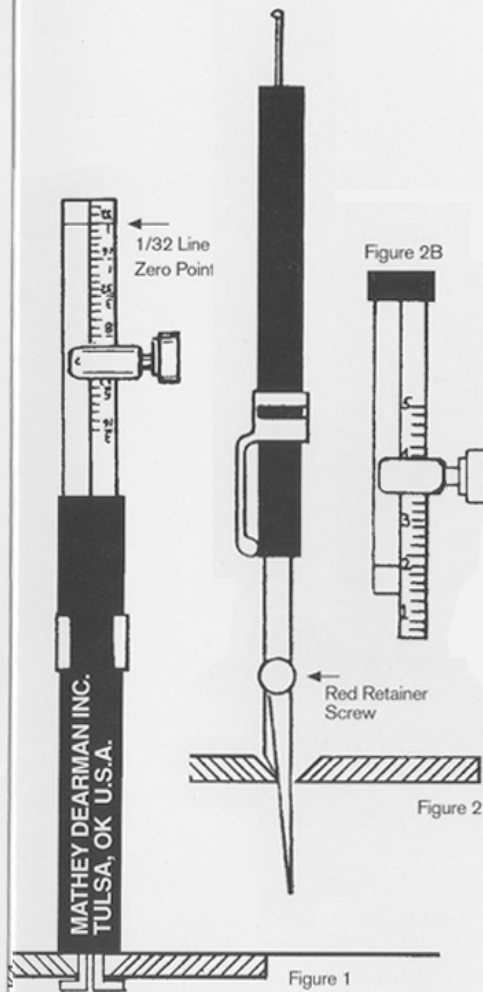
Q.C. WELDER'S GAUGE

The Mathey Dearman's Q.C. Welder's Gauge measures inside "Hi-Lo" and welding gap. This tool helps the user to avoid Q.C. rejections.

Inside Hi-Lo Gauge – Figure 1:

Step A – To check the Hi-Lo of your fit-up with the inside Hi-Lo Gauge, loosen the retaining screw. Press the legs beyond the housing of the Gauge and insert them into the space between the two pieces to be fit-up. Rotate the Gauge one-quarter turn, apply a pulling pressure to the housing. Hold as square with the pipe as possible. Tighten the retaining screw. Reverse quarter turn to remove Gauge.

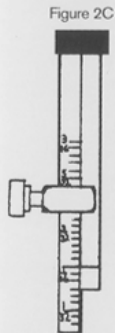
Step B – Read the fractional (metric) Gauge across the red line. When the red line and one-thirty-second (0 mm) line match up, you have a perfect fit-up. This is the zero point. Each mark on the Gauge from the 1/16 (metric: 1 mm) mark represents 1/32 (metric: 1 mm) of high-low. The other markings are only used when the Gauge is used for checking spacing between materials.



Spacing Gauge – Figure 2:

Step A – Loosen the retaining screw. Insert the Gauge between the pipe and fitting or two pieces of pipe. The leg with the short angle will rest on the bevel of the pipe. The leg with the long angle is extended until it makes contact

with both sides of the space to be checked. Tighten retaining screw and remove gauge and read.



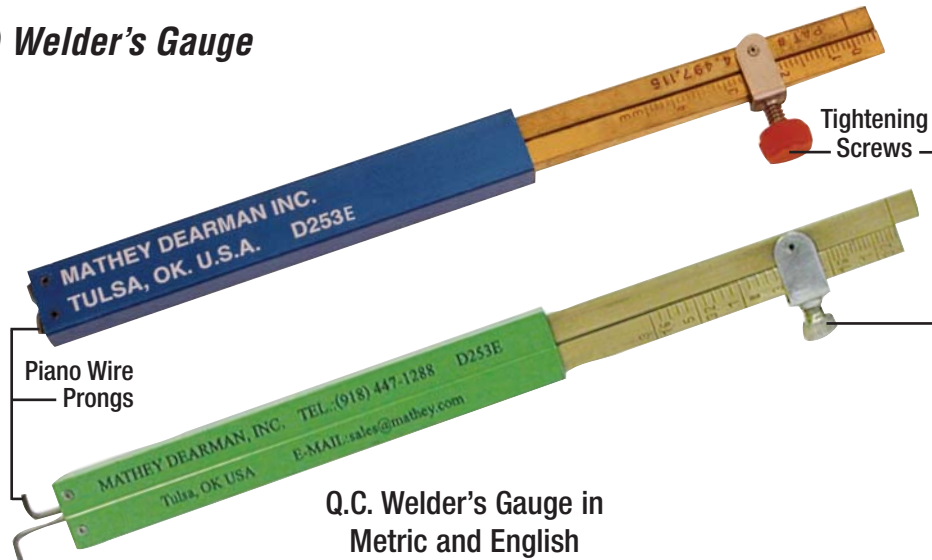
Step B – The space dimension between the pieces being fitted can be read in Millimeters (Fig. 2B) or fractions of an inch (Fig. 2C). When reading the Gauge for spacing the numbered fractional (metric) are one-thirty-second of an inch (1 mm) increments, each mark represents .0062 of an inch (.2 mm).

Quality Control (Q.C.) Welder's Gauge



D253E and D253M

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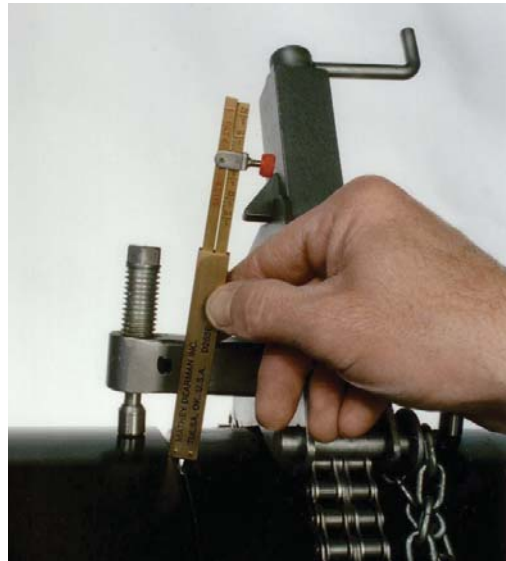


Q.C. Welder's Gauge in Metric and English

The Q.C. Welder's Gauge rapidly and accurately measures pipe "Hi-Lo"[™] and plate mismatch before and after weld tack up to minimize weld rejections. The Brass Wedge shaped end is placed between the two adjoining pipe or plate surfaces to measure "weld gap".

The square end with the piano wire is placed parallel over the weld gap. The brass legs are pushed downward enough for the bent end of the wire to clear the OD of the pipe. The frame of the Q.C. Welder's Gauge is turned 90° to the weld gap and the legs are released to measure inside "Hi-Lo"[™]. The gauge is available in both English and Metric Models.

- **ACCURTE** – measurement of pipe and plate "Hi-Lo"[™].
- **RAPID** measurements of pipe or plate "Hi-Lo"[™] is obtained by placing the spring steel wire through the weld gap and releasing the screw of the gauge.
- **PRECISE** – Precisely measures weld gap of the pipe or plate.
- **WELD REJECTION** – Reduces welding rejection due to poor alignment.



Pipe to pipe, pipe to flange or pipe to elbow "Hi-Lo"[™] and weld gap can be accurately checked and adjusted to avoid rejection of the weld joint.

Description	Part Number	Shipping Weight (lbs./kg)
English Q.C. Welder's Gauge	D253E	.15 / .1
Metric Q.C. Welder's Gauge	D235M	.15 / .68