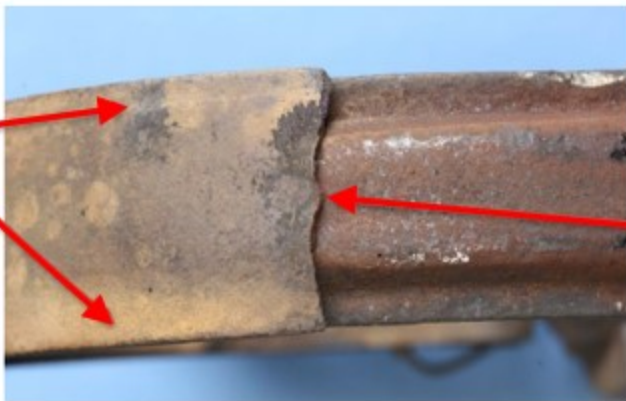


Note
deformation
of outer band
(cupping)



Crack
origination at
spot-weld.