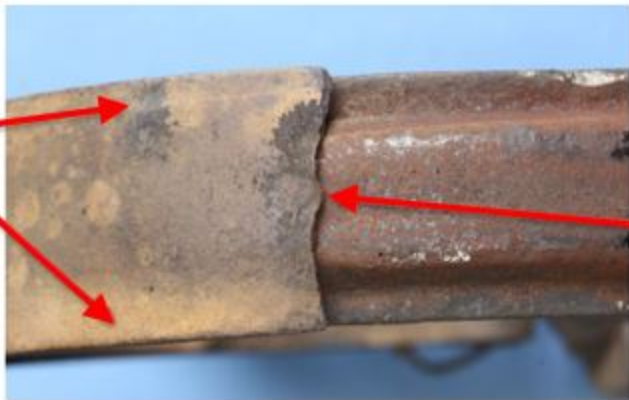


Note  
deformation  
of outer band  
(cupping)



Crack  
origination at  
spot-weld.