



Designation: ~~E1324 – 16~~ E1324 – 21

Standard Guide for Measuring Some Electronic Characteristics of Ultrasonic Testing Instruments¹

This standard is issued under the fixed designation E1324; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope*

1.1 This guide describes procedures for electronically measuring the following performance-related characteristics of some sections of ultrasonic instruments:

1.1.1 *Power Supply Section:*

line regulation,
battery discharge time, and
battery charge time.

1.1.2 *Pulser Section:*

pulse shape,
pulse amplitude,
pulse rise time, pulse length, and
pulse frequency spectrum.

1.1.3 *Receiver Section:*

vertical linearity,
frequency response,
noise and sensitivity, and
dB controls.

1.1.4 *Time Base Section:*

horizontal linearity, and
clock (pulse repetition rate).

1.1.5 *Gate/Alarm Section:*

delay and width,
resolution,
alarm level,
gain uniformity,
analog output, and
back echo gate.

¹ This guide is under the jurisdiction of ASTM Committee E07 on Nondestructive Testing and is the direct responsibility of Subcommittee E07.06 on Ultrasonic Method. Current edition approved June 1, 2016/June 1, 2021. Published June 2016/June 2021. Originally approved in 1990. Last previous edition approved in 2014/2016 as E1324 – 11/E1324 – 16. DOI: 10.1520/E1324-16-10.1520/E1324-21.

*A Summary of Changes section appears at the end of this standard

1.2 This guide complements Practice [E317](#); ~~[D2548](#)~~ and is not intended for evaluating the performance characteristics of ultrasonic testing instruments on the inspection/production line.

NOTE 1—No access to internal circuitry is required.

1.3 *Units*—The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate ~~safety~~ safety, health, and ~~health~~ environmental practices and determine the applicability of regulatory limitations prior to use.*

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

~~[D2548 Method of Test for Analysis of Oil Soluble Petroleum Sulfonates by Liquid Chromatography, Replaced by D 3712 \(Withdrawn 1979\)](#)~~³

[E317 Practice for Evaluating Performance Characteristics of Ultrasonic Pulse-Echo Testing Instruments and Systems without the Use of Electronic Measurement Instruments](#)

[E1316 Terminology for Nondestructive Examinations](#)

2.2 ISO Standards:³

[ISO 10012 Measurement Management Systems—Requirements for Measurement Processes and Measuring Equipment](#)

[ISO 17025 General Requirements for the Competence of Testing and Calibration Laboratories](#)

2.3 Other Standard:⁴

[IEEE Std. 100, IEEE Standard Dictionary of Electrical and Electronics Terms](#)

3. Summary of Guide

3.1 The electronic performance of each section is measured by identifying that portion of the electrical circuit of the instrument which comprises the section, applying the recommended stimulus or load, or both, and performing the required measurements using commercially available electronic test equipment. These data are then summarized in tabular or graphical form as performance-related values which can be compared with corresponding values of other ultrasonic testing instruments or of values for the same instrument obtained earlier (see Section 12 for a suggested reporting format).

3.2 The following describes the sections of the ultrasonic instrument and their interrelations during measurement:

3.2.1 *Power Supply Section*—The power supply section is that portion of the total instrument circuitry which supplies the regulated DC voltages required to power all other sections of the ultrasonic instrument, including the high voltage (that is, pulser and display voltage) circuitry.

3.2.2 *Pulser Section*—The pulser section is that portion of the total instrument circuitry which generates the electrical pulse used to energize the ultrasonic search unit. The pulser section may also include the pulse-shape modification controls such as pulse length, damping, or tuning controls.

3.2.3 *Receiver Section*—The receiver section is that portion of the total instrument circuitry which amplifies, or modifies, or both, the radio frequency (RF) pulses received from the ultrasonic search unit. This includes the RF amplifiers, detectors, video amplifiers, suppression and filtering, and the display vertical deflection circuits. Some instruments may not contain all of these circuits.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from International Organization for Standardization (ISO), 1, ch. de la Voie-Creuse, CP 56, CH-1211 Geneva 20, Switzerland, <http://www.iso.org>.

⁴ Available from Institute of Electrical and Electronics Engineers, Inc. (IEEE), 445 Hoes Ln., P.O. Box 1331, Piscataway, NJ 08854-1331

3.2.3.1 *Time Variable Gain (TVG)*, (alternatively referred to as Distance Amplitude Correction (DAC), Time Controlled Gain (TCG), etc.) and reject or threshold, while part of the receiver section, should be turned off while making measurements unless otherwise specified by the user.

3.2.4 *Gate/Alarm Section*—This section monitors the signals in the receiver section to detect the presence or absence of significant indications. The gate may include attenuation or gain controls. This section is considered separate from the receiver section for the purposes of this guide. The alarm signal may be audible, a voltage proportional to the indication amplitude, or a mark on voltage or current sensitive paper or some combination of these.

3.2.5 *Time Base Section*—The time base section provides the linear horizontal sweep, or baseline. It includes the horizontal deflection circuits and the clock and delay circuits that control repetition rate and positioning of signals on the baseline.

4. Significance and Use

4.1 The recommended measurement procedures described in this guide are intended to provide performance-related measurements that can be reproduced under the specified test conditions using commercially available test instrumentation. These measurements indicate capabilities of sections of the ultrasonic testing instrument independent of specific transducers or examination conditions. Measurements are made from normally available connectors or test points so that no access to internal circuitry is required. Further, this guide is not intended for service, calibration, or maintenance of circuitry for which the manufacturer's instructions are available. It is intended primarily for pulse echo flaw detection instruments operating in the nominal frequency range of 100 kHz to 25 MHz, but the procedures are applicable to measurements on instruments utilizing significantly higher frequency components.

4.2 These procedures can be applied to the evaluation of any pulse-echo ultrasonic testing instrument which can be described as a combination of the electronic sections discussed in this guide.

NOTE 2—These procedures are not intended to preclude the use or application of equipment for which some or all of the measurement techniques of this document are not applicable.

4.3 An ultrasonic testing instrument that cannot be completely described as a combination of the electronic sections discussed in this practice can be partially evaluated. Each portion of the ultrasonic testing instrument that is evaluated must fit the description for the corresponding section.

4.4 This guide is meant to be used by electronic personnel to evaluate the electronic system components and not the ultrasonic system characteristics.

5. Apparatus

5.1 *Ultrasonic Instrument*—Any electronic instrument comprised of a power supply, pulser, clock, receiver, and a sweep and display section to generate, receive, and display electrical signals related to ultrasonic waves for examination purposes.

NOTE 3—Some ultrasonic instruments do not include a cathode ray tube display. Some sections of this guide may not apply to these instruments, or may be applicable only with modifications. Such modifications should be made only by personnel competent in electronics.

5.2 *Voltmeter*—Any instrument(s) capable of measuring the AC line and DC battery voltages required for 7.1 or 7.2.

5.3 *Variable Transformer*—An autotransformer or other device capable of supplying variable AC power to the ultrasonic instrument over the full range of voltages and waveforms specified by the manufacturer.

5.4 *Pulser Load*—Unless otherwise requested by the using parties, the pulser load should be a 50 Ω noninductive resistor, preferably mounted in a shielded coaxial assembly. The resistor must be able to withstand the maximum peak pulser voltage. The impedance of the resistor should be checked at the anticipated operating frequency to ensure that it is noninductive. Other impedances may be used if specified.

5.5 *Spectrum Analyzer*—Any spectrum analyzer (and probe assembly, if required) that is capable of analyzing the electrical pulse from the pulser module and displaying the frequency components of the pulse as described in 8.3. A recording of the display (photograph or chart recorder) is desirable.

5.6 *Probe*—A wide band high input impedance ($\geq 10\text{ k}\Omega$) attenuating (100× or 50×) probe to reduce the pulse amplitude, as delivered to the oscilloscope and the spectrum analyzer, to a level that (a) will not harm the equipment and (b) will allow for frequency and time analysis without significantly altering the pulse shape. The probe output impedance should match the input impedance of the measurement instrument. (If the impedance is high, a terminating resistance may be required at the input to match the output impedance of the probe.) The frequency bandwidth should be at least as wide as that of the measuring instruments. The probe must be able to withstand the pulser output voltage.

NOTE 4—More than one probe may be needed to match the various test instruments used.

5.7 *Function Generator*—The function generator should be capable of producing a single-cycle sine wave or a five-cycle sine wave burst (as required in 9.1.3, 9.2.3, 9.3.1, 10.1.1, and 11.1), the frequency of which is variable over the range of the frequency capabilities of the ultrasonic instrument. The frequency read-out should be accurate to 1.0 %. It must be capable of being triggered from a signal derived from the instrument clock to provide wave trains coherent with the display. An adjustable delay of at least 10 μs is required.

5.7.1 A free-running (that is, non-triggered) single-cycle sine wave may not be used for receiver evaluation.

5.8 *Calibrated Oscilloscope*—The oscilloscope should be capable of displaying all portions of the pulser output with sufficient timebase expansion, triggering capability, and frequency response to enable measurement of the pulse rise time, amplitude, and duration, as well as fulfilling the requirements of other measurements.

5.9 *Calibrated Attenuator*—The attenuator should provide a measuring range of 60 dB in 1 dB steps with an accuracy within ± 0.5 dB and have a frequency bandwidth at least as wide as the highest frequency of interest. Most attenuators have a nominal input and output impedance of 50 Ω , but other impedances may be specified. Proper termination rules must be observed. An impedance matching probe should be used to protect the attenuator if it is to be used to reduce pulse output.

5.10 *Terminators*—Terminators are used to match the impedances of instruments and cables used (see 5.4.). They should be non-inductive, feed-through style.

5.11 *Cables*—Cables should be coaxial, with maximum length of 6 ft (2 m) and a 50 Ω characteristic impedance. Other lengths, or impedances, or both, may be used if authorized, but lengths should be kept as short as possible to minimize the effects of cable capacitance on measurements.

5.12 *Search Unit*—An ultrasonic search unit of the desired type, size, and frequency required for the procedures and test block selected for 5.14, 7.1.1, 7.2.1, 10.2, or 10.3.

5.13 *Immersion Tank (Optional)*—An ultrasonic immersion system that will enable continuous variation of the distance between the ultrasonic search unit and a reflector over a water path range that will provide a time range comparable to the end use of the ultrasonic instrument. A distance (position) scale of precision needed for the procedure in 10.2 must be incorporated.

5.14 *Test Block*—A block of any suitable material which can be used to provide ultrasonic echo signals.

5.15 *Camera or Recorder*—This is particularly helpful in measuring pulse characteristics, and is useful in making other measurements.

6. Precautions and Limitations

6.1 This guide describes procedures that are applicable to laboratory measurement conditions using, in most instances, commercially available electronic test equipment.

6.2 This guide is not intended, nor is it applicable, as a specification defining the performance of ultrasonic testing systems. If such performance criteria are required, they must be agreed upon by the using parties.

6.3 Implementation of this guide may require more detailed procedural instructions. Competence in the use of the electronic measurement instrumentation specified is a prerequisite for effective use of these procedures.

6.4 Careful selection of the specific measurements to be made is recommended. If the related parameter is not relevant to the intended application, its measurement may be unnecessary. For example, vertical linearity may be irrelevant for an application using a single-level flaw alarm, while horizontal linearity might be required only for accurate flaw-depth or thickness measurement from the instrument screen.

6.5 No minimum interval between instrument evaluations is recommended or implied.

6.6 The accuracy of each measurement is dependent upon the combined accuracies of each of the electronic measuring instruments (which should be described in the specifications and calibrations for these instruments), and the precisions associated with reading the values of each part of the measurement system. It is assumed that the precision of measuring the vertical and horizontal values from the ultrasonic instrument screen is ± 0.04 in. (± 1 mm).

6.7 All measuring instrumentation should have current calibration certificates. A calibration control system, such as that described in ISO 10012 or ISO 17025, is suggested.

7. Power-Supply Section Measurements

7.1 AC-Powered Instrument Line Regulation:

7.1.1 Connect the variable transformer, the voltmeter and a search unit which matches the nominal frequency of the instrument, to the ultrasonic instrument as shown in Fig. 1. While Fig. 1 shows an immersion set-up, the evaluation may be performed by either the contact or immersion method. The primary requirement is that the signal from the reference reflector does not vary due to coupling or position variations during the evaluation. Contact tests may require clamping of the search unit to the test piece. A block with permanently bonded search unit(s) is quite useful.

7.1.2 Adjust the variable transformer for 100 % nominal line voltage and obtain a 50 % full-scale indication from the reference block. Decrease the variable transformer output voltage until the reference reflector indication changes its amplitude, width, or horizontal position by 10 %.

NOTE 5—Damage may result from going beyond the manufacturer’s line voltage specifications in either direction.

7.1.3 The ultrasonic instrument display may turn off before any significant signal change is noted.

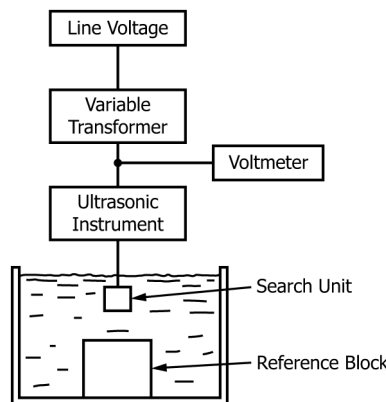


FIG. 1 Setup for Voltage Regulation Measurements

7.1.4 Record the variable transformer output voltage(s) at which the 10 % change or turn-off occurs. These are the input voltage limits.

NOTE 6—If a regulating transformer is always used to supply power to the instrument, the procedures in 7.1 may not be needed.

7.2 Battery-Powered Instruments

7.2.1 Discharge Time:

7.2.1.1 With the battery in the full charged condition, connect a search unit to the instrument and obtain a 50 % full-scale indication from a suitable reference block. This evaluation may be performed by either the contact or immersion method. The primary requirement is that the signal from the reference reflector does not vary due to coupling or position changes during the battery discharge time period.

7.2.1.2 Instrument controls that affect power drain, such as pulse repetition rate, display brightness, sweep range, etc., should be set to the maximum levels corresponding to good examination practices to provide the maximum practical power supply loading condition.

7.2.1.3 At time intervals ≤ 15 min, record the amplitude of the signal from the reference block and graph these values versus time as shown in Fig. 2 until the horizontal sweep length or position or amplitude of the indication changes 10 %, or until the instrument display turns off. The discharge time is the time required for a change of the stated amount or until the display turns off, whichever occurs first. Record this value.

7.2.1.4 The data recording may be minimized by making an initial reading and then beginning the periodic measurements at a later time near the anticipated discharge time.

7.2.2 Charge Time:

7.2.2.1 With the instrument battery discharged in accordance with 7.2.1, turn the instrument power switch to the OFF or CHARGE position, connect the battery charger to the battery, and begin charging the battery.

7.2.2.2 At time intervals ≤ 15 min, disconnect the charger, connect the DC voltmeter to the battery terminals, and record the battery voltage versus time as shown in Fig. 3. The battery charge curve shown in Fig. 3 is typical for NiCd and sealed lead batteries used in most ultrasonic instruments. The fully charged condition corresponds to the maximum voltage value shown in Fig. 3. Record this value in minutes.

7.2.2.3 The data recording may be minimized by making an initial reading and then beginning the periodic measurements at a later time near the anticipated charge time. Enough data should be acquired to reliably indicate the shape of the charge curve (see Fig. 3) in the region of full charge.

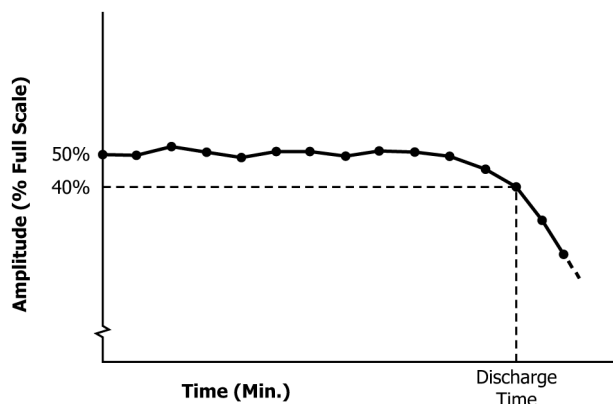


FIG. 2 Battery Discharge Characteristics—Typical

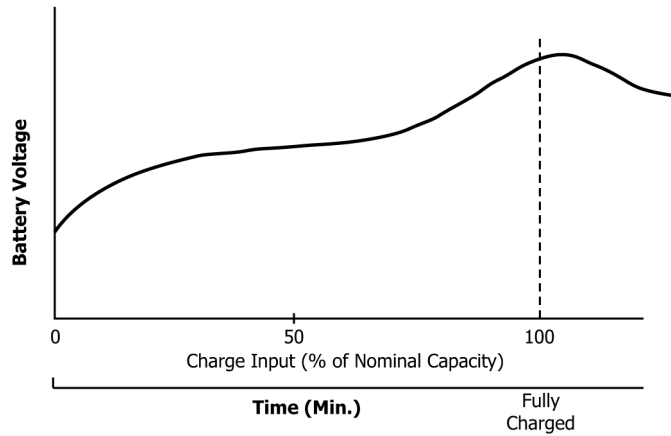


FIG. 3 NiCd and Lead Acid Battery Charge Characteristics—Typical

8. Pulsar Section Measurements

8.1 *Pulse Shape*—Pulses are generally classed in two types, Tuned and Untuned, or Narrow Band and Broad Band.

8.1.1 Tuned pulsers are tuned to match the frequency of the search unit to be used. The output of a tuned pulser (without search unit) will be a damped sinusoid as is shown in Fig. 4a. If the pulse is highly damped, only a half or one and a half cycle may appear. At minimum damping (Pulse Length maximum), there may be many cycles.

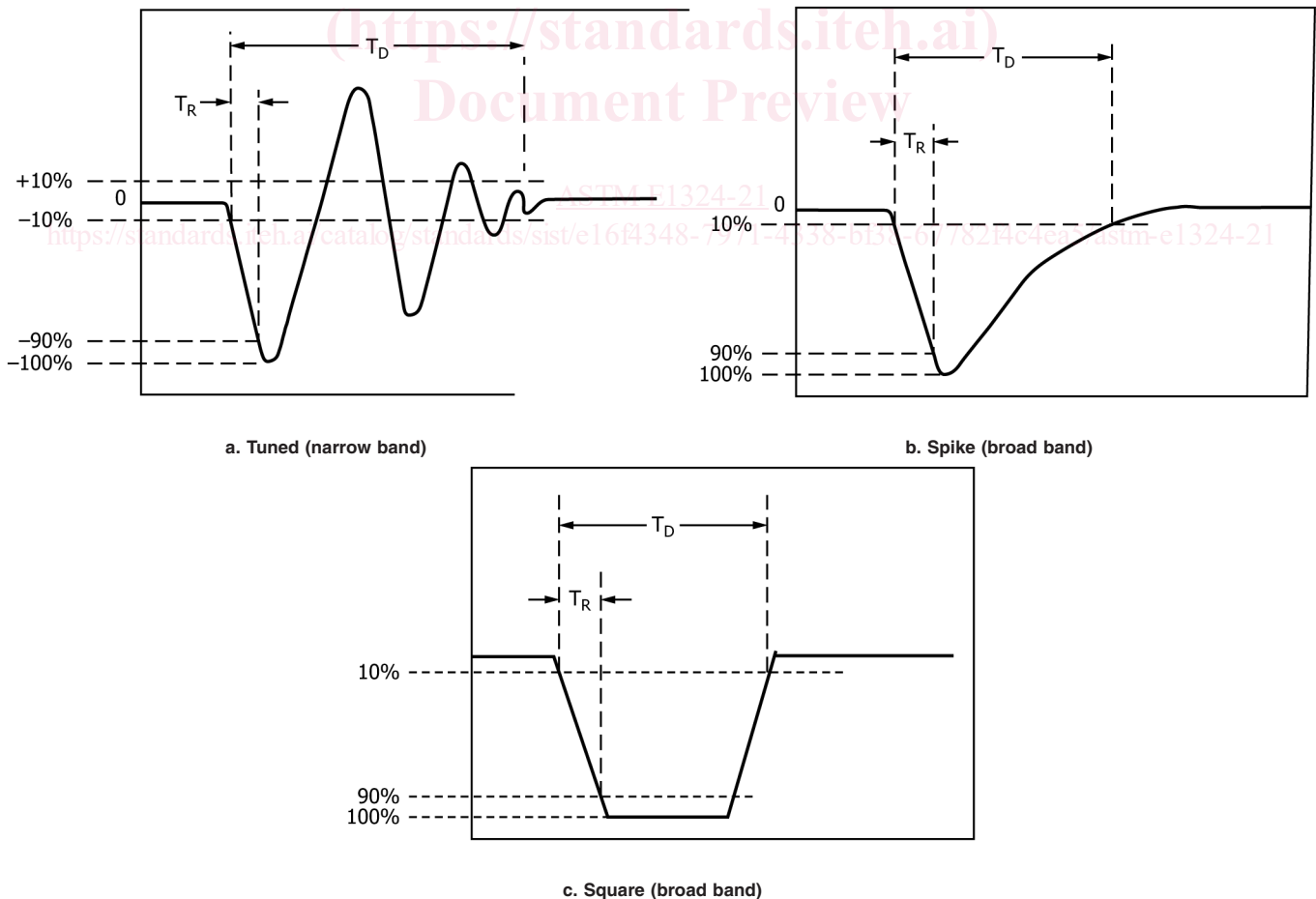


FIG. 4 Pulse Shapes (Slopes exaggerated) Exaggerated