



Standard Practice for Ultrasonic Examination of Turbine-Generator Steel Retaining Rings¹

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1. Scope

1.1 This practice covers the procedures to be followed when performing ultrasonic shear and longitudinal wave tests on turbine-generator retaining rings with an inside diameter to wall thickness ratio equal to or greater than 5:1 and with wall thicknesses from 1 to 4 in. (25 to 102 mm).

1.2 Although this practice describes methods of ultrasonically testing retaining rings by either the contact or immersion method, it shall not restrict the use of improved inspection methods as they are developed. It is recognized that techniques for examination and evaluation may be chosen in order to enhance or improve the results or to accommodate variations in procedures, equipment, or capabilities. Considering these characteristics, forgings may be inspected by a combination of both the contact and the immersion methods, as mutually agreed upon between the manufacturer and the purchaser.

1.3 This practice and the applicable material specifications are expressed in both inch-pound units and SI units. However, unless the order specifies the applicable "M" specification designation SI units, the material shall be furnished to inch-pound units.

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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

E 127 Practice for Fabricating and Checking Aluminum Alloy Ultrasonic Standard Reference Blocks²

2.2 Other Document:

Recommended Practice for Nondestructive Personnel Qualification and Certification SNT-TC-1A, Supplement C-Ultrasonic Testing³

¹ This practice is under the jurisdiction of ASTM Committee A-1 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.06 on Steel Forgings and Billets.

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² *Annual Book of ASTM Standards*, Vol 03.03.

³ Available from the American Society for Nondestructive Testing, 914 Chicago Ave., Evanston, IL 60202.

3. Personnel Requirements

3.1 The manufacturer shall be responsible for assigning qualified personnel to perform ultrasonic examination in conformance with the requirements of this practice.

3.2 Personnel performing ultrasonic examinations in accordance with this practice shall be familiar with the following:

3.2.1 Ultrasonic terminology,

3.2.2 Instrument calibration,

3.2.3 Effect of transducer material, size, frequency, and mode on test results,

3.2.4 Effect of material structure (grain size, cleanliness, etc.) on test results,

3.2.5 Effect of test distance on test results,

3.2.6 Effect of nonlinearity on test results,

3.2.7 Effect of thickness and orientation of discontinuities on test results, and

3.2.8 Effect of surface roughness on test results.

3.3 A qualification record (see Note 1) of personnel considered suitable by the manufacturer to perform examination in accordance with this practice shall be available upon request.

NOTE 1—SNT-TC-1 A, Ultrasonic Testing Method, provides a recommended procedure for qualifying personnel. Other personnel qualification requirement documents may be used when agreed upon between the purchaser and supplier.

4. Ordering Information

4.1 When this practice is to be applied to an inquiry, contract, or order, the purchaser shall so state and shall also furnish the following information:

4.1.1 The method or combination of methods to be used for inspection.

4.1.2 The frequency to be used for conducting each inspection.

4.1.3 Report requirements including C-scan plot, if applicable.

5. General Requirements

5.1 As far as possible the entire volume of the retaining rings shall be subject to ultrasonic inspection. Circumferential and axial faces shall be machined flat and parallel to one another.

5.2 The ultrasonic inspection shall be performed after final processing and heat treatment for properties, unless otherwise specified in the order or contract.

5.3 Rings may be tested either stationary (contact) or while

rotating (immersion). If not specified by the purchaser, a combination of methods may be used at the manufacturer's option. Scanning speed shall not exceed 6 in./s (152 mm/s), unless automatic recording (C-scan) equipment is employed.

5.4 To ensure complete coverage, (during contact testing) the search unit shall be indexed approximately 75 % of the transducer width with each pass of the search unit. During immersion testing establish a transducer index adjustment which will ensure complete coverage with sufficient overlap.

5.5 During the testing, a combination of methods and frequencies of 1 MHz, 2¼ MHz, and 5 MHz may be used for accurately locating, determining orientation, and defining specific discontinuities detected during overall scanning.

5.6 For reporting purpose, location of indications shall be circumferentially defined by clock position. The test notch or a similar locator, such as a reference line bisecting the serial number, shall be used to define and identify the 12 o'clock position.

6. Apparatus

6.1 *Ultrasonic, Pulsed, Reflection Type of Instrument*, shall be used for the examination. The system shall have a minimum capability for examining at frequencies from 1 to 5 MHz.

6.1.1 The amplifier and the cathode ray tube shall provide linear response (within 5 %) for at least 75 % of the screen height (sweep line to top of screen).

6.1.2 The instrument shall contain a calibrated gain control or signal attenuator (in each case, accurate within ± 5 %) that will allow indications beyond the linear range of the instrument to be measured.

6.1.3 When the immersion method of inspection is employed, suitable equipment must be available so that the retaining rings can be immersed in a liquid coupling agent or can be subject to inspection by the use of a column or stream of the couplant through an appropriate container attached to the part or transducer. Equipment must also include fixturing for smooth mechanical rotation of the part or the transducer during scanning.

6.2 Search Units:

6.2.1 Contact Method:

6.2.1.1 A 2.25 or 1.0-MHz, 45° angle beam shear wave search unit shall be employed for shear wave testing. (2.25 MHz shall be used unless acoustic attenuation of the material is such that 1 MHz must be employed to obtain adequate penetration of the ring section.) Adequate penetration is the ability to clearly resolve the calibration notch above resultant noise level.

6.2.1.2 A 5, 2.25, or 1-MHz, ¾ to 1⅛-in. (19.0 to 28.6-mm) diameter, longitudinal wave transducer shall be used for performing the longitudinal wave test.

6.2.1.3 Acrylic resin shoes ground to the curvature of the retaining ring may be used to maintain the optimum contact angle between the transducer and outside diameter of the ring.

6.2.1.4 When agreed upon between the purchaser and supplier, alternative test frequencies may be used to perform the required tests.

6.2.2 Immersion Method:

6.2.2.1 A 5, 2.25, or 1-MHz transducer, ¾ to 1 in. (19.0 to 25.4 mm) in diameter, suitable for water immersion, shall be

used for performing the required test.

6.2.2.2 The manipulator (holder) for the search tube or transducer, or both, shall provide for angular manipulation of the transducer for optimum response from the internal discontinuities. The tolerance or play present in the manipulation and in the traversing unit should not be excessive so as to prevent ultrasonic examination at the required sensitivity level.

6.2.2.3 When agreed upon between the purchaser and supplier, alternative test frequencies may be used to perform the required tests.

6.2.2.4 *Accessory Equipment*—Coaxial cables and search tubes used in conjunction with the electronic apparatus capable of conducting the electrical pulses while immersed in a liquid, and collimators for shaping the sound beam may be used.

6.3 Recording instruments or alarm systems, or both, may be used, provided sufficient range and sensitivity are available to properly monitor the test.

7. Preparation of the Forging for Ultrasonic Examination

7.1 Surface roughness on the outside and inside diameter and radical face surfaces of the ring shall not exceed 125 µin. (3.18 µm) and waviness shall not exceed 0.001 in. (0.02 mm) measured in both the axial and circumferential directions. The radical faces of the ring shall be sufficiently perpendicular to the axis of the forging to permit axial tests.

7.2 All surfaces of the ring to be examined shall be free of extraneous material such as surface tears, loose scale, machining or grinding particles, paint, and other foreign matter.

8. Ultrasonic Couplants

8.1 For contact testing, a suitable couplant, such as clean SAE 20 motor oil, shall be used to couple the transducer to test surfaces.

8.2 For immersion testing, a liquid such as water, oil, glycerin, etc., capable of conducting ultrasonic vibrations from the transducer to the material being tested shall be used. Rust inhibitors, softeners, and wetting agents may be added to the couplant. The couplant liquid with all additives should not be detrimental to the surface condition of the test specimen or the container, and it should wet the surface of the material to provide an intimate contact. Couplant may be heated to a comfortable working temperature and must be free of air bubbles.

9. Method for Shear Wave Testing

9.1 Calibration Reference:

9.1.1 Place a calibration V-shaped notch, with an included angle of 60 to 90° and ¼in. (6.35 mm) long, in the outside diameter surface of the ring at a sufficient distance from the end of the ring to eliminate side wall interference. Determine the location of the notch by scanning the ring at a sensitivity high enough to show the material structure and with the shear wave beam directed circumferentially. Using this procedure, then locate the notch in an area representative of the ring material.

9.1.2 Place the notch axially in the ring to a depth of 1 % of the wall thickness or 0.020 in. (0.51 mm), whichever is greater. Make the depth measurement after removal of the upset material adjacent to the notch.

9.1.3 For the inspection of finish machined rings, an outside