



SLOVENSKI STANDARD
SIST EN 12517:1999/A1:2003
01-maj-2003

Neporušitveno preskušanje zvarnih spojev - Radiografsko preskušanje zvarnih spojev - Stopnje sprejemljivosti - Dopnilo A1

Non-destructive testing of welds - Radiographic testing of welded joints - Acceptance levels

Zerstörungsfreie Prüfung von Schweißverbindungen - Durchstrahlungsprüfung von Schweißverbindungen - Zulässigkeitsgrenzen

Essais non destructifs des assemblages soudés - Contrôle par radiographie des assemblages soudés - Niveaux d'acceptation

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Ta slovenski standard je istoveten z: EN 12517:1998/A1:2002

ICS:

25.160.40 Varjeni spoji in vari Welded joints

SIST EN 12517:1999/A1:2003 en

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 12517:1998/A1

October 2002

ICS 25.160.40

English version

Non-destructive testing of welds - Radiographic testing of welded joints - Acceptance levels

Essais non destructifs des assemblages soudés - Contrôle par radiographie des assemblages soudés - Niveaux d'acceptation

Zerstörungsfreie Prüfung von Schweißverbindungen - Durchstrahlungsprüfung von Schweißverbindungen - Zulässigkeitsgrenzen

This amendment A1 modifies the European Standard EN 12517:1998; it was approved by CEN on 23 August 2002.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for inclusion of this amendment into the relevant national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Management Centre or to any CEN member.

This amendment exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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Foreword

This document (EN 12517:1998/A1:2002) has been prepared by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DS.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by April 2003 and conflicting national standards shall be withdrawn at the latest by April 2003.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

For relationship with EU Directive(s), see informative annex ZA, which is an integral part of this document.

Annex A is informative.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

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EN 12517:1998/A1:2002 (E)**General**

As agreed by CEN/TC 121/SC 5 resolution 134/2000, the term “examination” shall be replaced by “testing”.

1 Scope

The 1st paragraph will read now :

This standard specifies acceptance levels for indications from imperfections in steel butt welds detected by radiography. If defined by specification, the acceptance levels may be applied to other types of welds or materials.

2 Normative references

In the French version only, read the title of EN 970 as follows:

EN 970, Contrôle non destructif des assemblages soudés par fusion - Contrôle visuel

3 Radiographic technique

In the French version only, read the title of Table 1 : “Contrôle par radiographie”.

4 General

The 3rd paragraph will read now :

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When quantification of undercut and/or excessive penetration by radiography is required, specific procedures, according to the specification, using test exposures may be applied in order to establish a basis for approximate quantification in accordance with the requirements of EN 25817.

In the French version only, read the second paragraph as follows :

Les niveaux d'acceptation dans ce document sont fondamentalement valides pour l'évaluation des défauts qui ne peuvent pas être détectés et évalués par un contrôle visuel. Les défauts de surface (tels que caniveaux et pénétration excessive, dégradation de surface, projection de soudure, etc.) qui sont dus à la géométrie de l'objet ne peuvent pas être évalués, mais lorsque l'interpréteur pense que les niveaux de qualité de l'EN 25817 ne sont pas satisfaits, ils doivent faire l'objet d'un contrôle plus spécifique.

5 Acceptance levels

In the English version only, replace the first paragraph by:

The acceptance levels for indications are shown in Table 2. The imperfection types are those listed in EN 25817.

In the English version only, in the Table 2, modify the notes 1) and 2) by:

1) Acceptance levels 3 and 2 may be specified with prefix X which denotes that all indications over 25 mm are unacceptable.

2) Surface imperfections : The acceptance levels are those defined for visual testing. These imperfections are normally accepted or rejected for visual testing.

In Table 2, modify No 5 by:

No	Type of imperfections in accordance with EN 26520	Acceptance level 3 1)	Acceptance level 2 1)	Acceptance level 1
5	Solid and metallic inclusions (300) and elongated cavities (2015)	$l \leq 2s$ and $\Sigma l \leq L/10$ for $L = \min(12 s; 150 \text{ mm})$	$l \leq s$ and $\Sigma l \leq L/10$ for $L = \min(12 s; 150 \text{ mm})$	$l \leq \max(0,3 s; 6 \text{ mm})$ and $l \leq 25 \text{ mm}$ $\Sigma l \leq s$ for $L = \min(12 s; 150 \text{ mm})$

In the French version only, read :

l longueur du défaut, en millimètres ;

h hauteur du défaut, en millimètres ;

In the French version only, in Table 2:

Change "for" to "pour" and "and" to "et".

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Annex A (informative)

Guide to the limitations of radiography

A.1 Volumetric imperfections in butt welds

In the French version only, read the title as follows : "Défauts volumiques dans les soudures bout-à-bout".

In the French version only, for "piqûres ..." and "soufflures vermiculaires ..." change, under brackets, "and" to "et".

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