
**Non-destructive testing of steel tubes —
Part 11:
Automated ultrasonic testing of the weld
seam of welded steel tubes for the
detection of longitudinal and/or
transverse imperfections**

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Essais non destructifs des tubes en acier —

*Partie 11: Contrôle automatisé par ultrasons du cordon de soudure des
tubes en acier soudés pour la détection des imperfections
longitudinales et/ou transversales*

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ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 10893-11 was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 19, *Technical delivery conditions for steel tubes for pressure purposes*.

This first edition cancels and replaces ISO 9764:1989 and ISO 9765:1990, which have been technically revised.

ISO 10893 consists of the following parts, under the general title *Non-destructive testing of steel tubes*:

- *Part 1: Automated electromagnetic testing of seamless and welded (except submerged arc-welded) steel tubes for the verification of leaktightness*
- *Part 2: Automated eddy current testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of imperfections*
- *Part 3: Automated full peripheral flux leakage testing of seamless and welded (except submerged arc-welded) ferromagnetic steel tubes for the detection of longitudinal and/or transverse imperfections*
- *Part 4: Liquid penetrant inspection of seamless and welded steel tubes for the detection of surface imperfections*
- *Part 5: Magnetic particle inspection of seamless and welded ferromagnetic steel tubes for the detection of surface imperfections*
- *Part 6: Radiographic testing of the weld seam of welded steel tubes for the detection of imperfections*
- *Part 7: Digital radiographic testing of the weld seam of welded steel tubes for the detection of imperfections*
- *Part 8: Automated ultrasonic testing of seamless and welded steel tubes for the detection of laminar imperfections*
- *Part 9: Automated ultrasonic testing for the detection of laminar imperfections in strip/plate used for the manufacture of welded steel tubes*
- *Part 10: Automated full peripheral ultrasonic testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of longitudinal and/or transverse imperfections*

- *Part 11: Automated ultrasonic testing of the weld seam of welded steel tubes for the detection of longitudinal and/or transverse imperfections*
- *Part 12: Automated full peripheral ultrasonic thickness testing of seamless and welded (except submerged arc-welded) steel tubes*

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Non-destructive testing of steel tubes —

Part 11:

Automated ultrasonic testing of the weld seam of welded steel tubes for the detection of longitudinal and/or transverse imperfections

1 Scope

This part of ISO 10893 specifies requirements for the automated ultrasonic shear wave (generated by conventional or phased array technique) testing of the weld seam of submerged arc-welded (SAW) or electric resistance and induction-welded (EW) steel tubes.

For SAW tubes, the test covers the detection of imperfections oriented predominantly parallel to or, by agreement, perpendicular to the weld seam or both.

For EW tubes, the test covers the detection of imperfections oriented predominantly parallel to the weld seam. In the case of testing on longitudinal imperfections, Lamb wave testing can be applied at the discretion of the manufacturer.

For the detection of imperfections at the weld seam of EW tubes, full peripheral ultrasonic testing is possible.

This part of ISO 10893 can also be applicable to the testing of circular hollow sections.

NOTE For full peripheral ultrasonic testing of seamless and welded (except SAW) tubes, see ISO 10893-10.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 5577, *Non-destructive testing — Ultrasonic inspection — Vocabulary*

ISO 9712, *Non-destructive testing — Qualification and certification of personnel*

ISO 10893-6, *Non-destructive testing of steel tubes — Part 6: Radiographic testing of the weld seam of welded steel tubes for the detection of imperfections*

ISO 10893-7, *Non-destructive testing of steel tubes — Part 7: Digital radiographic testing of the weld seam of welded steel tubes for the detection of imperfections*

ISO 11484, *Steel products — Employer's qualification system for non-destructive testing (NDT) personnel*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 5577 and ISO 11484 and the following apply.

3.1

reference standard

standard for the calibration of non-destructive testing equipment (e.g. drill holes, notches, recesses)

3.2

reference tube

tube or length of tube containing the reference standard(s)

3.3

reference sample

sample (e.g. segment of tube, plate or strip) containing the reference standard(s)

NOTE Only the term “reference tube” is used in this part of ISO 10893, also covering the term “reference sample”.

3.4

tube

hollow long product open at both ends, of any cross-sectional shape

3.5

welded tube

tube made by forming a hollow profile from a flat product and welding adjacent edges together. After welding the tube may be further processed, either hot or cold, into its final dimensions

3.6

electric welded tube

tube made by pressure welding, in a continuous or non-continuous process, in which strip is formed cold into a hollow profile and the seam weld made by heating the adjacent edges through the resistance to the passage of high- or low-frequency current, and pressing the edges together

NOTE The electric current can be applied either by direct electrode contact or by induction.

3.7

manufacturer

organization that manufactures products in accordance with the relevant standard(s) and declares the compliance of the delivered products with all applicable provisions of the relevant standard(s)

3.8

agreement

contractual arrangement between the manufacturer and purchaser at the time of enquiry and order

4 General requirements

4.1 Unless otherwise specified by the product standards or agreed on by the purchaser and manufacturer, an ultrasonic test shall be carried out on tubes after completion of all the primary production process operations (rolling, heat treating, cold and hot working, sizing and primary straightening, etc.).

For cold-expanded tubes, the ultrasonic testing of the weld shall be carried out after expansion. In case of spirally welded tubes, where the tube is not subsequently subjected to a hydrostatic test at the tube mill, the acceptance test may be carried out online.

4.2 The tubes under test shall be sufficiently straight to ensure the validity of the test. The surface shall be sufficiently free of foreign matter which can interfere with the validity of the test.

4.3 This test shall be carried out by suitably trained operators, qualified in accordance with ISO 9712, ISO 11484 or equivalent and supervised by competent personnel nominated by the manufacturer. In the case of third-party inspection, this shall be agreed on by the purchaser and manufacturer.

The operating authorization issued by the employer shall be according to a written procedure. Non-destructive testing (NDT) operations shall be authorized by a level 3 NDT individual approved by the employer.

NOTE The definition of levels 1, 2 and 3 can be found in appropriate International Standards, e.g. ISO 9712 and ISO 11484.

5 Test method

5.1 The weld seam of the tube shall be tested using an ultrasonic shear wave technique for the detection of longitudinal and/or transverse imperfections. Lamb wave technique may be applied for the detection of longitudinal imperfections of EW tubes.

Unless otherwise agreed on by the purchaser and manufacturer, testing shall be carried out in two opposite directions of sound propagation for the requested type of inspection, clockwise and anticlockwise for the detection of longitudinal imperfections and forward and backward for the detection of transverse imperfections.

5.2 During testing, the tubes and the probe assembly shall be moved relative to each other such that the whole area under inspection is scanned with coverage calculated on the dimension of the transducer(s).

The relative speed of movement during testing shall not vary by more than 10 %.

5.3 There can be a short length at both tube ends which cannot be tested. Any untested ends shall be dealt with in accordance with the requirements of the appropriate product standard.

In the case of SAW tubes, the untested ends may, at the manufacturer's discretion, be checked either by a manual ultrasonic test in accordance with this part of ISO 10893 or by a radiographic test in accordance with ISO 10893-6 or ISO 10893-7.

In the case of EW tube, the untested ends may be tested in accordance with Annex A.

5.4 For the detection of longitudinal imperfections, the maximum width of each individual transducer, measured parallel to the major axis of the tube, shall be 25 mm. For the detection of transverse imperfections, the maximum width of each individual transducer, measured perpendicular to the major axis of the tube, shall be 25 mm.

In case of the use of Lamb wave technique or phased array technique, the maximum length of transducer or active aperture shall be limited to 35 mm.

5.5 The ultrasonic test frequency of transducers shall be in the range 1 MHz to 15 MHz for shear wave technique and in the range of 0,3 MHz to 1 MHz for Lamb wave technique, depending on the product condition and properties, the thickness and surface finishing of tubes under examination.

5.6 The equipment shall be capable of classifying tubes as either acceptable or suspect, by means of an automated trigger/alarm level, combined with a marking or sorting system (or both).

5.7 Where manual ultrasonic testing of untested tube ends and/or local suspect areas is required (see 5.3), use Annex A.