



SLOVENSKI STANDARD SIST EN ISO 10863:2020

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Nadomešča:
SIST EN ISO 10863:2011

Neporušitveno preskušanje zvarov - Ultrazvočno preskušanje - Uporaba tehnike uklona valov v odvisnosti od časa (TOFD) (ISO 10863:2020)

Non-destructive testing of welds - Ultrasonic testing - Use of time-of-flight diffraction technique (TOFD) (ISO 10863:2020)

Zerstörungsfreie Prüfung von Schweißverbindungen - Ultraschallprüfung - Anwendung der Beugungslaufzeittechnik (TOFD) (ISO 10863:2020)

Essais non destructifs des assemblages soudés - Contrôle par ultrasons - Utilisation de la technique de diffraction des temps de vol (TOFD) (ISO 10863:2020)

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ICS:

25.160.40

Varjeni spoji in vari

Welded joints and welds

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN ISO 10863

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ICS 25.160.40

Supersedes EN ISO 10863:2011

English Version

**Non-destructive testing of welds - Ultrasonic testing - Use
of time-of-flight diffraction technique (TOFD) (ISO
10863:2020)**

Essais non destructifs des assemblages soudés -
Contrôle par ultrasons - Utilisation de la technique de
diffraction des temps de vol (TOFD) (ISO 10863:2020)

Zerstörungsfreie Prüfung von Schweißverbindungen -
Ultraschallprüfung - Anwendung der
Beugungslaufzeittechnik (TOFD) (ISO 10863:2020)

This European Standard was approved by CEN on 19 May 2020.

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COMITÉ EUROPÉEN DE NORMALISATION
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CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

Contents

Page

European foreword.....	3
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[SIST EN ISO 10863:2020](https://standards.iteh.ai/catalog/standards/sist/b4481450-1753-4d5a-b83f-587b66a8ced2/sist-en-iso-10863-2020)

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European foreword

This document (EN ISO 10863:2020) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding and allied processes" the secretariat of which is held by DIN.

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of an identical text or by endorsement, at the latest by December 2020, and conflicting national standards shall be withdrawn at the latest by December 2020.

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

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INTERNATIONAL STANDARD

**ISO
10863**

Second edition
2020-05

Non-destructive testing of welds — Ultrasonic testing — Use of time-of- flight diffraction technique (TOFD)

*Essais non destructifs des assemblages soudés — Contrôle par ultrasons
— Utilisation de la technique de diffraction des temps de vol (TOFD)*

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Contents

Page

Foreword	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 General remarks on the capabilities of the technique	2
5 Testing levels	3
6 Information required prior to testing	4
6.1 Items to be defined by specification	4
6.2 Specific information required by the operator before testing	4
6.3 Written test instruction or procedure	4
7 Requirements for test personnel and test equipment	5
7.1 Personnel qualifications	5
7.2 Test equipment	5
7.2.1 Ultrasonic instrument	5
7.2.2 Ultrasonic probes	5
7.2.3 Scanning mechanisms	5
8 Preparation for testing	5
8.1 Volume to be tested	5
8.2 Setup of probes	6
8.3 Scan increment setting	7
8.4 Geometry considerations	7
8.5 Preparation of scanning surfaces	7
8.6 Temperature	8
8.7 Couplant	8
8.8 Provision of datum points	8
9 Testing of base material	8
10 Range and sensitivity settings	8
10.1 Settings	8
10.1.1 General	8
10.1.2 Time window	8
10.1.3 Time-to-depth conversion	8
10.1.4 Sensitivity settings	9
10.2 Checking of the settings	9
10.3 Reference blocks	9
10.3.1 General	9
10.3.2 Material	9
10.3.3 Dimensions and shape	10
10.3.4 Reference reflectors	10
11 Weld testing	10
12 Interpretation and analysis of TOFD images	11
12.1 General	11
12.2 Assessing the quality of the TOFD image	11
12.3 Identification of relevant TOFD indications	11
12.4 Classification of relevant TOFD indications	11
12.4.1 General	11
12.4.2 TOFD indications from surface-breaking discontinuities	12
12.4.3 TOFD indications from embedded discontinuities	12
12.4.4 Unclassified TOFD indications	13
12.5 Determination of location	13
12.6 Definition and determination of length and height	13

ISO 10863:2020(E)

12.6.1	General.....	13
12.6.2	Determination of length	14
12.6.3	Determination of height	16
12.7	Evaluation against acceptance criteria.....	17
13	Test report.....	17
Annex A (informative)	Reference blocks.....	19
Annex B (informative)	Examples of TOFD scans	24
Bibliography		37

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SIST EN ISO 10863:2020

<https://standards.iteh.ai/catalog/standards/sist/b4481450-1753-4d5a-b83f-587b66a8ced2/sist-en-iso-10863-2020>

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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 5, *Testing and inspection of welds*.

This second edition cancels and replaces the first edition (ISO 10863:2011), which has been technically revised.

The main changes compared to the previous edition are as follows:

- the whole document has been updated to the state of the art; ISO 22232 series has been taken into account;
- [Clause 3](#) has been updated;
- [Figure 1](#) to [Figure 6](#) have been added;
- [Figure B.1](#) to [Figure B.18](#) have been updated.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Official interpretations of ISO/TC 44 documents, where they exist, are available from this page: <https://committee.iso.org/sites/tc44/home/interpretation.html>.

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<https://standards.iteh.ai/catalog/standards/sist/b4481450-1753-4d5a-b83f-587b66a8ced2/sist-en-iso-10863-2020>

Non-destructive testing of welds — Ultrasonic testing — Use of time-of-flight diffraction technique (TOFD)

1 Scope

This document specifies the application of the time-of-flight diffraction (TOFD) technique to the semi- or fully automated ultrasonic testing of fusion-welded joints in metallic materials of minimum thickness 6 mm.

It applies to full penetration welded joints of simple geometry in plates, pipes, and vessels, where both the weld and the parent material are low-alloyed carbon steel. Where specified and appropriate, TOFD can also be used on other types of materials that exhibit low ultrasonic attenuation (especially that due to scatter).

Where material-dependent ultrasonic parameters are specified in this document, they are based on steels having a sound velocity of $(5\,920 \pm 50)$ m/s for longitudinal waves and $(3\,255 \pm 30)$ m/s for transverse waves. It is necessary to take this fact into account when testing materials with a different velocity.

This document makes reference to ISO 16828 and provides guidance on the specific capabilities and limitations of TOFD for the detection, location, sizing and characterization of discontinuities in fusion-welded joints. TOFD can be used as a stand-alone method or in combination with other non-destructive testing (NDT) methods or techniques, for manufacturing inspection, and for in-service inspection.

This document specifies four testing levels (A, B, C, D) in accordance with ISO 17635 and corresponding to an increasing level of testing reliability. Guidance on the selection of testing levels is provided.

This document permits assessment of TOFD indications for acceptance purposes. This assessment is based on the evaluation of transmitted, reflected and diffracted ultrasonic signals within a generated TOFD image.

This document does not include acceptance levels for discontinuities.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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 testing — Vocabulary*

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

ISO 16828, *Non-destructive testing — Ultrasonic testing — Time-of-flight diffraction technique as a method for detection and sizing of discontinuities*

ISO 17640, *Non-destructive testing of welds — Ultrasonic testing — Techniques, testing levels, and assessment*

ISO 22232-1¹⁾, *Non-destructive testing — Characterization and verification of ultrasonic test equipment — Part 1: Instruments*

1) Under preparation. (Preparation at the time of publication: ISO/FDIS 22232-1.)