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**Neporušitveno preskušanje jeklenih cevi - 11. del: Avtomatizirano ultrazvočno preskušanje varjenega šiva varjenih jeklenih cevi za odkrivanje vzdolžnih in/ali prečnih nepopolnosti - Dopolnilo A1: Sprememba ultrazvočnih preskusnih frekvenc pretvornikov - sprememba meril sprejemljivosti (ISO 10893-11:2011/DAM 1:2019)**

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 - Amendment 1: Change the ultrasonic test frequency of transducers - change of acceptance criteria (ISO 10893-11:2011/DAM 1:2019)

Zerstörungsfreie Prüfung von Stahlrohren - Teil 11: Automatisierte Ultraschallprüfung der Schweißnaht geschweißter Stahlrohre zum Nachweis von Unvollkommenheiten in Längs- und/oder Querrichtung - Änderung 1 (ISO 10893-11:2011/DAM 1:2019)

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 - Amendement 1: Changement de la fréquence de contrôle par ultrasons des palpeurs, changement des critères d'acceptation (ISO 10893-11:2011/DAM 1:2019)

**Ta slovenski standard je istoveten z: EN ISO 10893-11:2011/prA1**

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**ICS:**

23.040.10	Železne in jeklene cevi	Iron and steel pipes
25.160.40	Varjeni spoji in vari	Welded joints and welds
77.040.20	Neporušitveno preskušanje kovin	Non-destructive testing of metals

**SIST EN ISO 10893-11:2011/oprA1:2019 en,fr,de**

**iTeh STANDARD PREVIEW**  
**(standards.iteh.ai)**

Full standard:  
<https://standards.iteh.ai/catalog/standards/sist/ea60736e-c2bb-44cb-8e8b-363a1cf9271b/sist-en-iso-10893-11-2011-oprA1-2019>

# DRAFT AMENDMENT

## ISO 10893-11:2011/DAM 1

ISO/TC 17/SC 19

Secretariat: UNI

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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

AMENDMENT 1: Change the ultrasonic test frequency of transducers; change of acceptance criteria

*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*

AMENDEMENT 1: .

ICS: 23.040.10; 77.040.20; 77.140.75

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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

### AMENDMENT 1: Change the ultrasonic test frequency of transducers; change of acceptance criteria

#### Part 11:

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#### Change the ultrasonic test frequency of transducers

##### Clause 5 Test method

##### Subclause 5.5

Replace the sentence " 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." with " 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 5 MHz for Lamb wave technique, depending on the product condition and properties, the thickness and surface finishing of tubes under examination."

#### Change of acceptance criteria

##### Clause 8 Acceptance

##### Subclause 8.2

Replace the 2nd sentence " If after two consecutive retests all signals are lower than the trigger/ alarm level,

the tube shall be deemed to have passed this test otherwise the tube shall be designated as suspect " with " If

after one retest all signals are lower than the trigger/alarm level, the tube shall be deemed to have passed this test otherwise the tube shall be designated as suspect."