



Designation: E1033-98 (Reapproved 2004)^{ε1} Designation: E 1033 - 09

Standard Practice for Electromagnetic (Eddy-Current) Examination of Type F-Continuously Welded (CW) Ferromagnetic Pipe and Tubing Above the Curie Temperature¹

This standard is issued under the fixed designation E 1033; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

^{ε1}Note—Referenced documents and editorial changes were made in January 2004.

1. Scope

1.1 This practice covers a procedure for in-line, eddy-current examination of continuously welded (CW) ferromagnetic pipe and tubing at temperatures above the Curie temperature (approximately 1400°F [~~760°C~~], (760°C), where the pipe is substantially nonmagnetic or austenitic.

1.2 This practice is intended for use on tubular products having nominal diameters of ½ in. [~~12.7 mm~~](12.7 mm) to 4 in. [~~101.6 mm~~](101.6 mm). These techniques may be used for larger- or smaller-diameter pipe and tubing as specified by the using parties.

1.3 This practice is specifically applicable to eddy-current examination using encircling coils, or probe coils.

1.4 This practice does not establish acceptance criteria. They must be established by the using parties.

~~1.5 The values stated in inch-pound units are to be regarded as standard. The SI units in brackets may be approximate.~~

1.5 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.6 *This standard does not purport to address the safety problems 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:*²

E 309 Practice for Eddy-Current Examination of Steel Tubular Products Using Magnetic Saturation

E 543 Practice Specification for Agencies Performing Nondestructive Testing

E 1316 Terminology for Nondestructive Examinations

2.2 *Other Documents:*

SNT-TC-1A Recommended Practice for Personnel Qualification and Certification in Nondestructive Testing³

ANSI/ASNT-CP-189 ASNT Standard for Qualification and Certification of Nondestructive Testing Personnel³

NAS-410 NAS Certification and Qualification of Nondestructive Personnel (Quality Assurance Committee)⁴

3. Terminology

3.1 Standard terminology relating to electromagnetic examination may be found in Terminology E 1316, Section C, Electromagnetic Testing.

4. Summary of Practice

4.1 In-line, automatic, eddy-current examination of CW pipe utilizes probes or encircling coils, or both, mounted in the pass line to monitor the quality of pipe during production at temperatures ranging from 1600 to 2200°F [~~870~~(870 to ~~1204°C~~], (1204°C).

¹ This practice is under the jurisdiction of ASTM Committee E07 on Nondestructive Testing and is the direct responsibility of Subcommittee E07.07 on Electromagnetic Methods.

Current edition approved January 1, 2004. Published February 2004. Originally approved in 1985. Last previous edition approved in 1998 as E1033-98 on Electromagnetic Method.

Current edition approved June 1, 2009. Published July 2009. Originally approved in 1985. Last previous edition approved in 2004 as E 1033 - 98(2004)^{ε1}.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For Annual Book of ASTM Standards volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from American Society for Nondestructive Testing, 1711 Arlingate Plaza, PO Box 28518, Columbus, OH 43228-0518.

³ Available from American Society for Nondestructive Testing (ASNT), P.O. Box 28518, 1711 Arlingate Ln., Columbus, OH 43228-0518, http://www.asnt.org.

⁴ Available from Aerospace Industries Association of America, Inc., 1250 Eye Street, N.W., Washington, DC 20005.

⁴ Available from Aerospace Industries Association of America, Inc. (AIA), 1000 Wilson Blvd., Suite 1700, Arlington, VA 22209-3928, http://www.aia-aerospace.org.