
Non-destructive testing of 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**

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ISO AMENDMENT 1:2021
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**AMENDMENT 1: Change of ultrasonic
test frequency, change of acceptance
criteria**

Essais non destructifs des tubes en acier —

*Partie 10: Contrôle automatisé par ultrasons sur toute la
circonférence des tubes en acier sans soudure et soudés (sauf à l'arc
immergé sous flux en poudre) pour la détection des imperfections
longitudinales et/ou transversales*

*AMENDEMENT 1: Changement de la fréquence ultrasonore de l'essai;
changement des critères d'acceptation*



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

5.5, entire paragraph

Replace the sentence:

"The ultrasonic test frequency of transducers that shall be used shall be in the range 1 MHz to 15 MHz for shear wave technique and in the range 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 following:

"The ultrasonic test frequency that shall be used shall be in the range 1 MHz to 15 MHz for shear waves and in the range **0,3 MHz to 5 MHz** for Lamb waves, depending on the product condition and properties, the thickness and surface finishing of tubes to be tested."

8.2, second sentence

Replace the second 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 the following:

"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."

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