
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

AMENDMENT 1: Change the ultrasonic test frequency of transducers; 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 de contrôle par ultrasons des palpeurs, changement des critères d'acceptation

PROOF / ÉPREUVE



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CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Fax: +41 22 749 09 47
Email: copyright@iso.org
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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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