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AMENDMENT 1

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: Changement de la fréquence de contrôle par ultrasons des palpeurs, changement des critères d'acceptation

PROOF/ÉPREUVE

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This document was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 19, *Technical delivery conditions for steel tubes for pressure purposes*.

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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

5.5, entire paragraph

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 following:

"The ultrasonic test frequency shall be in the range 1 MHz to 15 MHz for shear waves and in the range of 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."

ICS 23.040.10; 77.040.20; 77.140.75

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