
**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 of ultrasonic
test frequency; change of acceptance
criteria**

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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 ultrasonore de l'essai;
changement des critères d'acceptation*



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Automated ultrasonic testing of the weld seam of welded steel tubes for the detection of longitudinal and/or transverse imperfections

AMENDMENT 1: Change of ultrasonic test frequency; 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."

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