



Standard Specification for Ultrasonic Angle-Beam Examination of Steel Plates¹

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1. Scope

1.1 This specification² covers an ultrasonic angle-beam procedure and acceptance standards for the detection of internal discontinuities not laminar in nature and of surface imperfections in a steel plate. This specification is intended for use only as a supplement to specifications which provide straight-beam ultrasonic examination.

NOTE 1—An internal discontinuity that is laminar in nature is one whose principal plane is parallel to the principal plane of the plate.

1.2 Individuals performing examinations in accordance with this specification shall be qualified and certified in accordance with the requirements of the latest edition of ASNT SNT-TC-1A or an equivalent accepted standard. An equivalent standard is one which covers the qualification and certification of ultrasonic nondestructive examination candidates and which is acceptable to the purchaser.

1.3 The values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification.

2. Referenced Documents

2.1 *ASNT Standards:*³

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

3. Ordering Information

3.1 The inquiry and order shall indicate any additions to the provisions of this specification as prescribed in 11.1.

4. Examination Conditions

4.1 The examination shall be conducted in an area free of operations that interfere with proper performance of the examination.

4.2 The surface of the plate shall be conditioned as necessary to provide a clear, easily interpreted trace pattern on the screen.

Any specified identification which is removed to achieve proper surface smoothness shall be restored.

5. Apparatus

5.1 The amplitude linearity shall be checked by positioning the transducer over the depth resolution notch in the IIW or similar block so that the signal from the notch is approximately 30 % of the screen height, and the signal from one of the back surfaces is approximately 60 % of the screen height (two times the height of the signal from the notch). A curve is then plotted showing the deviations from the above established 2:1 ratio that occurs as the amplitude of the signal from the notch is raised in increments of one scale division until the back reflection signal reaches full scale, and then is lowered in increments of one scale division until the notch signal reaches one scale division. At each increment the ratio of the two signals is determined. The ratios are plotted on the graph at the position corresponding to the larger signal. Between the limits of 20 % and 80 % of the screen height the ratio shall be within 10 % of 2:1. Instrument settings used during inspection shall not cause variation outside the 10 % limits established above.

5.2 The search unit shall be a 45-deg (in steel) angle-beam type with active transducer length and width dimensions of a

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² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-577/SA-577M in Section II of that Code. Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

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