



Designation: E703 – 14

Standard Practice for Electromagnetic (Eddy Current) Sorting of Nonferrous Metals¹

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1. Scope*

1.1 This practice describes a procedure for sorting nonferrous metals using the electromagnetic (eddy current) method. The procedure is intended for use with instruments using absolute or comparator-type coils for distinguishing variations in mass, shape, conductivity, and other variables such as alloy, heat treatment, or hardness that may be closely correlated with the electrical properties of the material. Selection of samples to evaluate sorting feasibility and to establish standards is also described.

1.2 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

[E105 Practice for Probability Sampling of Materials](#)

[E122 Practice for Calculating Sample Size to Estimate, With Specified Precision, the Average for a Characteristic of a Lot or Process](#)

[E543 Specification for Agencies Performing Nondestructive Testing](#)

[E1316 Terminology for Nondestructive Examinations](#)

2.2 ASNT Documents:³

[SNT-TC-1A Recommended Practice for Personnel Qualification and Certification in Nondestructive Testing](#)

[ANSI/ASNT CP-189 Standard for Qualification and Certification of Nondestructive Testing Personnel](#)

¹ This practice is under the jurisdiction of ASTM Committee E07 on Nondestructive Testing and is the direct responsibility of Subcommittee E07.07 on Electromagnetic Method.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

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

2.3 AIA Standard:⁴

[NAS-410 Qualification and Certification of Nondestructive Testing Personnel](#)

3. Terminology

3.1 Standard terminology relating to electromagnetic examination may be found in Terminology E1316, Section C: Electromagnetic Testing.

4. Summary of Practice

4.1 The techniques that are primarily used in electromagnetic sorting employ the absolute (single-) and comparative (two-) coil methods using either encircling or probe coils. The decision of whether to use single-coil or two-coil operation is usually based on empirical data. In the absolute-coil method (encircling or probe), the equipment is standardized by placing standards of known properties in the test coil. The value of the examined electrical parameter, which may be correlated with alloy, heat treatment temper, or hardness, is read on the display of an indicator. In the comparative coil method (encircling or probe coils), the test specimen in one coil is compared with a reference standard in a second coil to determine whether the test specimen is within or outside of the required limits.

4.1.1 Absolute Coil Method:

4.1.1.1 *Encircling Coil*—Various reference standards are inserted consecutively in the test coil, and the controls of the instrument are adjusted to obtain an appropriate response. Typically, three samples would be used representing the upper, lower, and mid-range for which standardization is required. The examination is then conducted by inserting the specimens to be sorted into the test coil, and observing the instrument response.

4.1.1.2 *Probe Coil*—The probe coil is placed consecutively on the reference standards and the controls of the instrument are adjusted for appropriate response (see 4.1.1.1). The examination is then conducted by placing the probe on the specimens to be sorted and observing the instrument response.

4.1.2 Comparative Coil Method:

⁴ Available from Aerospace Industries Association of America, Inc. (AIA), 1000 Wilson Blvd., Suite 1700, Arlington, VA 22209-3928, <http://www.aia-aerospace.org>.

*A Summary of Changes section appears at the end of this standard

4.1.2.1 *Encircling Coil*—Reference standards representing the minimum or maximum limits, or both, of acceptance or sorting category are inserted in the reference and test coil. The instrument controls are adjusted for appropriate responses. The examination is then conducted by inserting specimens to be sorted in the test coil, leaving the known reference in the reference coil and observing the instrument response.

4.1.2.2 *Probe Coil*—Both probe coils are placed on the reference standard representing the minimum or maximum limits, or both, of acceptance or sorting category. The instrument controls are adjusted for appropriate responses. The examination is then conducted by placing the test probe on the specimens to be sorted (the other probe is left on the reference standard) and observing the instrument response.

4.2 The range of instrument response must be so adjusted in the initial step that the anticipated deviations will be within the range of readout.

4.3 Both absolute and comparative methods using encircling coil(s) require comparing the specimens to be examined with the reference standards. Two or more samples representing the limits of acceptance may be required. In the absolute method, the electrical reference signal from the instrument is adjusted with the reference standard in the coil. In the comparative method, any electromagnetic condition, that is not common to the test specimen and the reference standard, will produce an imbalance in the system. The comparative method is usually more stable since it suppresses most of the interferences.

4.4 The examination process may consist of manual insertion of one specimen after another into the test coil or an automated feeding and classifying mechanism may be employed. In automated setups, it is sometimes necessary to establish empirically the time required for the test specimen to remain in the test coil while the reading is being taken, especially if low frequencies are employed.

5. Significance and Use

5.1 Absolute and comparative methods provide a measure for sorting large quantities of nonferrous parts or stock with regard to composition or condition, or both.

5.2 The comparative or two-coil method is used when high-sensitivity examination is required. The advantage of this method is that it almost completely suppresses interferences.

5.3 The ability to accomplish these types of separations satisfactorily is dependent upon the relation of the electric characteristics of the nonferrous parts to their physical condition.

5.4 These methods may be used for high-speed sorting in a fully automated setup where the speed of examination may approach many specimens per second depending on their size and shape.

5.5 Successful sorting of nonferrous material depends mainly on the variables present in the sample and the proper selection of frequency and fill factor.

5.6 The accuracy of a sort will be affected greatly by the coupling between the test coil field and the examined part during the measuring period.

6. Basis of Application

6.1 *Personnel Qualification*—If specified in the contractual agreement, personnel performing examinations to this practice shall be qualified in accordance with a nationally recognized nondestructive testing (NDT) personnel qualification practice or standard, such as ANSI/ASNT-CP-189, SNT-TC-1A, NAS-410, ISO 9712, or a similar document and certified by the employer or certifying agency, as applicable. The practice or standard used and its applicable revision shall be identified in the contractual agreement between the using parties.

6.2 *Qualification of Nondestructive Testing Agencies*—If specified in the contractual agreement, NDT agencies shall be qualified and evaluated as described in Practice E543. The applicable edition of Practice E543 shall be specified in the contractual agreement.

6.3 *Acceptance Criteria*—Since acceptance criteria are not specified in this practice, they shall be specified in the contractual agreement.

7. Interferences

7.1 The influence of the following variables must be considered for proper interpretation of the results:

7.1.1 The correlation shall be established so that electrical properties of various groups do not overlap and are well defined in the standardization procedure used.

7.1.2 The examination frequency must be selected to provide a well-defined separation of variables.

7.1.3 The temperature of the reference standard and test specimen shall be controlled within limits that will permit a well-defined range of conductivity or permeability, or both, for which the correlation of the group or groups is valid. Cooling of the reference standard when high field strengths are used or allowing test specimens to cool or heat to an established ambient range, or both, may be required.

7.1.4 The geometry, mass, and thickness of the reference standard and test specimen shall be controlled within limits that will permit sorting.

7.1.5 Magnetic permeability variations can interfere when sorting paramagnetic materials.

7.1.6 Signal response can result from a change in relative motion between the test specimen and the test coil, such as the length of time the specimen is in a test coil (see 4.4).

7.1.7 Conductivity has an unambiguous relationship to hardness for certain alloys. However, when alloys are mixed, identical conductivity does not necessarily indicate the same hardness.

7.1.8 Care must also be exercised in using conductivity to sort overheated parts quenched at a high temperature as the conductivity reading for acceptable parts may repeat at a large increase in temperature.

7.1.9 Lift-off can result in a change in the test system output with probe coils. This effect is a change in the magnetic coupling between the test specimen and probe coil. Care must