



Designation: E1211/E1211M – 17

Standard Practice for Leak Detection and Location Using Surface-Mounted Acoustic Emission Sensors¹

This standard is issued under the fixed designation E1211/E1211M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This practice describes a passive method for detecting and locating the steady state source of gas and liquid leaking out of a pressurized system. The method employs surface-mounted acoustic emission sensors (for non-contact sensors see Test Method E1002), or sensors attached to the system via acoustic waveguides (for additional information, see Terminology E1316), and may be used for continuous in-service monitoring and hydrotest monitoring of piping and pressure vessel systems. High sensitivities may be achieved, although the values obtainable depend on sensor spacing, background noise level, system pressure, and type of leak.

1.2 *Units*—The values stated in either SI units or inch-pound units are to be regarded as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standards.

1.3 *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.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

¹ This practice is under the jurisdiction of ASTM Committee E07 on Nondestructive Testing and is the direct responsibility of Subcommittee E07.04 on Acoustic Emission Method.

Current edition approved June 1, 2017. Published June 2017. Originally approved in 1987. Last previous edition approved in 2012 as E1211 - 12. DOI: 10.1520/E1211_E1211M-17.

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.

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

[E650 Guide for Mounting Piezoelectric Acoustic Emission Sensors](#)

[E750 Practice for Characterizing Acoustic Emission Instrumentation](#)

[E976 Guide for Determining the Reproducibility of Acoustic Emission Sensor Response](#)

[E1002 Practice for Leaks Using Ultrasonics](#)

[E1316 Terminology for Nondestructive Examinations](#)

[E2374 Guide for Acoustic Emission System Performance Verification](#)

2.2 ASNT Documents:³

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

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

2.3 AIA Document:

[NAS 410 Certification and Qualification of Nondestructive Testing Personnel⁴](#)

2.4 ISO Standard:⁵

[ISO 9712 Non-Destructive Testing: Qualification and Certification of NDT Personnel](#)

3. Summary of Practice

3.1 This practice requires the use of contact sensors, amplifier electronics, and equipment to measure their output signal levels. The sensors may be mounted before or during the examination period and are normally left in place once mounted rather than being moved from point to point.

3.2 Detection of a steady-state leak is based on detection of the continuous, broadband signal generated by the leak flow. Signal detection is accomplished through measurement of some input signal level, such as its root-mean-square (RMS) amplitude or average signal level.

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

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

⁵ Available from International Organization for Standardization (ISO), ISO Central Secretariat, BIBC II, Chemin de Blandonnet 8, CP 401, 1214 Vernier, Geneva, Switzerland, <http://www.iso.org>.

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

3.3 The simplest leak test procedure involves *only* detection of leaks, treating each sensor channel individually. A more complex examination requires processing the signal levels from two or more sensors together to allow computation of the approximate leak location, based on the principle that the leak signal amplitude decreases as a function of distance from the source.

4. Significance and Use

4.1 Leakage of gas or liquid from a pressurized system, whether through a crack, orifice, seal break, or other opening, may involve turbulent or cavitation flow, which generates acoustic energy in both the external atmosphere and the system pressure boundary. Acoustic energy transmitted through the pressure boundary can be detected at a distance by using a suitable acoustic emission sensor.

4.2 With proper selection of frequency passband, sensitivity to leak signals can be maximized by eliminating background noise. At low frequencies, generally below 100 kHz, it is possible for a leak to excite mechanical resonances within the structure that may enhance the acoustic signals used to detect leakage.

4.3 This practice is not intended to provide a quantitative measure of leak rates.

5. Basis of Application

5.1 The following items are subject to contractual agreement between parties using or referencing this practice.

5.2 Personnel Qualification

5.2.1 If specified in the contractual agreement, personnel performing examinations to this practice shall be qualified in accordance with a nationally or internationally recognized 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.

5.3 *Qualification of Nondestructive 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.

5.4 *Timing of Examination*—The timing of examination shall be in accordance with 7.1.7 unless otherwise specified.

5.5 *Extent of Examination*—The extent of examination shall be in accordance with 7.1.4 and 10.1.1.1 unless otherwise specified.

5.6 *Reporting Criteria/Acceptance Criteria*—Reporting criteria for the examination results shall be in accordance with 10.2.2 and Section 11 unless otherwise specified. Since acceptance criteria are not specified in this practice, they shall be specified in the contractual agreement.

5.7 *Reexamination of Repaired/Reworked Items*—Reexamination of repaired/reworked items is not addressed in this practice and if required shall be specified in the contractual agreement.

6. Interferences

6.1 External or internal noise sources can affect the sensitivity of an acoustic emission leak detection system. Examples of interfering noise sources are:

- 6.1.1 Turbulent flow or cavitation of the internal fluid,
- 6.1.2 Noise from grinding or machining on the system,
- 6.1.3 Airborne acoustic noise, in the frequency range of the measuring system,
- 6.1.4 Metal impacts against, or loose parts frequently striking the pressure boundary, and
- 6.1.5 Electrical noise pick-up by the sensor channels.

6.2 Stability or constancy of background noise can also affect the maximum allowable sensitivity, since fluctuation in background noise determines the smallest change in level that can be detected.

6.3 The acoustic emission sensors must have stable characteristics over time and as a function of both the monitoring structure and the instrumentation system examination parameters, such as temperature.

6.4 Improper sensor mounting, electronic signal conditioner noise, or improper amplifier gain levels can decrease sensitivity.

7. Basic Information

7.1 The following items must be considered in preparation and planning for monitoring:

7.1.1 Known existing leaks and their distance from the areas to be monitored should be noted so that their influence on the capabilities of the method can be evaluated.

7.1.2 Type of vessel, pipeline, or installation to be examined, together with assembly, or layout drawings, or both, giving sufficient detail to establish dimensions, changes of shape likely to affect flow characteristics, positions of welds, and the location of components such as valves or flanges, and attachments to the vessel or pipe such as pipe hangers where leaks are most likely to arise. Regions with restricted accessibility due to walls, the existence or location of cladding, insulation, or below surface components must be specified.

7.1.3 When location of the peak is of primary interest, quantitative information regarding the leakage rates of interest and whenever possible the type of leak is necessary.

7.1.4 Extent of monitoring, for example, entire volume of pressure boundary, weld areas only, etc.

7.1.5 Material specifications and type of surface covering (for example paint or other coating) to allow the acoustic propagation characteristics of the structure to be evaluated.

7.1.6 Proposed program of pressure application or process-pressure schedule, specifying the pressurization schedule together with a layout or sketch of the pressure-application system and specifying the type of fluid used during the examination, for example, gas, water, or oil.

7.1.7 Time of monitoring, that is, the point(s) in the manufacturing process, or service life at which the system will be monitored, or both.

7.1.8 Frequency range to be used in the monitoring equipment.