



SLOVENSKI STANDARD

oSIST prEN ISO 11666:2026

01-oktober-2026

Neporušitveno preskušanje zvarnih spojev - Ultrazvočno preskušanje - Stopnje sprejemljivosti (ISO/DIS 11666:2026)

Non-destructive testing of welds - Ultrasonic testing - Acceptance levels (ISO/DIS 11666:2026)

Zerstörungsfreie Prüfung von Schweißverbindungen - Ultraschallprüfung - Zulässigkeitsgrenzen (ISO/DIS 11666:2026)

Essais non destructifs des assemblages soudés - Contrôle par ultrasons - Niveaux d'acceptation (ISO/DIS 11666:2026)

Ta slovenski standard je istoveten z: prEN ISO 11666

ICS:

25.160.40	Varjeni spoji in vari	Welded joints and welds
-----------	-----------------------	-------------------------

oSIST prEN ISO 11666:2026

en,fr,de

Sample Document

get full document from standards.iteh.ai



DRAFT International Standard

ISO/DIS 11666

Non-destructive testing of welds — Ultrasonic testing — Acceptance levels

*Essais non destructifs des assemblages soudés — Contrôle par
ultrasons — Niveaux d'acceptation*

ICS: 25.160.40

ISO/TC 44/SC 5

Secretariat: **AFNOR**

Voting begins on:
2026-09-07

Voting terminates on:
2026-11-30

This document has not been edited by the ISO Central Secretariat.

ISO/CEN PARALLEL PROCESSING

Reference number
ISO/DIS 11666:2026(en)

THIS DOCUMENT IS A DRAFT CIRCULATED FOR COMMENTS AND APPROVAL. IT IS THEREFORE SUBJECT TO CHANGE AND MAY NOT BE REFERRED TO AS AN INTERNATIONAL STANDARD UNTIL PUBLISHED AS SUCH.

IN ADDITION TO THEIR EVALUATION AS BEING ACCEPTABLE FOR INDUSTRIAL, TECHNOLOGICAL, COMMERCIAL AND USER PURPOSES, DRAFT INTERNATIONAL STANDARDS MAY ON OCCASION HAVE TO BE CONSIDERED IN THE LIGHT OF THEIR POTENTIAL TO BECOME STANDARDS TO WHICH REFERENCE MAY BE MADE IN NATIONAL REGULATIONS.

RECIPIENTS OF THIS DRAFT ARE INVITED TO SUBMIT, WITH THEIR COMMENTS, NOTIFICATION OF ANY RELEVANT PATENT RIGHTS OF WHICH THEY ARE AWARE AND TO PROVIDE SUPPORTING DOCUMENTATION.

© ISO 2026

Sample Document

get full document from standards.iteh.ai



COPYRIGHT PROTECTED DOCUMENT

© ISO 2026

All rights reserved. Unless otherwise specified, or required in the context of its implementation, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Email: copyright@iso.org
Website: www.iso.org

Published in Switzerland

© ISO 2026 – All rights reserved

ISO/DIS 11666:2026(en)

Contents

	Page
Foreword.....	iv
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Determination of discontinuity length	1
5 Sensitivity levels	2
6 Acceptance levels	2
6.1 General.....	2
6.2 Indications from longitudinal discontinuities.....	3
6.3 Indications from transverse discontinuities.....	3
6.4 Grouping of discontinuities.....	3
6.5 Cumulated length of acceptable discontinuities.....	4
Annex A (normative) Levels	6
Annex B (normative) Fixed-amplitude level technique	18
Bibliography	21

Sample Document

get full document from standards.iteh.ai

ISO/DIS 11666:2026(en)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 5, *Testing and inspection of welds*.

This third edition cancels and replaces the second edition (ISO 11666:2018), which has been technically revised.

The main changes compared to the previous edition are as follows:

- this document has been editorially revised;
- the normative reference ISO 5817 has been dated;
- [Clause 5](#) and [6.5](#) have been described in more detail.

Requests for official interpretations of any aspect of this document should be directed to the Secretariat of ISO/TC 44/SC 5 via your national standards body. A complete listing of these bodies can be found at www.iso.org.

Non-destructive testing of welds — Ultrasonic testing — Acceptance levels

1 Scope

This document specifies two ultrasonic acceptance levels known as acceptance level 2 (AL 2) and acceptance level 3 (AL 3) for full penetration welded joints in ferritic steels, in accordance with the quality levels of ISO 5817.

These acceptance levels are applicable to testing carried out in accordance with ISO 17640.

This document applies to the testing of fusion-welded joints in metallic materials with low sound attenuation (especially that due to scatter) with thicknesses from 8 mm to 100 mm. It is primarily intended for use on full penetration welded joints where both the welded and parent materials are ferritic. It can also be used for other types of welds, materials and thicknesses, provided the tests have been performed with necessary consideration of the geometry and acoustic properties of the component, and an adequate sensitivity can be employed to enable the acceptance levels of this document to be applied.

The nominal frequency of probes used in this document is between 2 MHz and 5 MHz, unless attenuation or requirements for higher resolution call for other frequencies. It is important to consider the use of these acceptance levels in conjunction with frequencies outside this range carefully.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 5817, *Welding — Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) — Quality levels for imperfections*

ISO 17640, *Non-destructive testing of welds — Ultrasonic testing — Techniques, testing levels, and assessment*

ISO 23279, *Non-destructive testing of welds — Ultrasonic testing — Characterization of discontinuities in welds*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 5577 apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

4 Determination of discontinuity length

The length of a discontinuity shall be determined by measuring the distance along the length over which the echo amplitude is above the evaluation level, using the fixed-amplitude level technique specified in [Annex B](#).