ISO 16811:2012-04 (E)

Non-destructive testing - Ultrasonic testing - Sensitivity and range setting

Contents

Page

Foreword v

1 Scope 1

2 Normative references 1

3 General 1
3.1 Quantities and symbols 1
3.2 Test objects, reference blocks and reference reflectors 1
3.3 Categories of test objects 1
3.4 Contouring of probes 2
3.4.1 Longitudinally curved probes 3
3.4.2 Transversely curved probes 3
3.4.3 Concave scanning surface 4

4 Determination of probe index and beam angle 4
4.1 General 4
4.2 Flat probes 4
4.2.1 Calibration block technique 4
4.2.2 Reference block technique 4
4.3 Probes curved longitudinally 4
4.3.1 Mechanical determination 4
4.3.2 Reference Block Technique 6
4.4 Probes curved transversely 6
4.4.1 Mechanical determination 6
4.4.2 Reference block technique 7
4.5 Probes curved in two directions 8
4.6 Probes for use on materials other than non-alloy steel 9

5 Time base setting 9
5.1 General 9
5.2 Reference blocks and reference reflectors 9
5.3 Straight beam probes 10
5.3.1 Single reflector technique 10
5.3.2 Multiple reflector technique 10
5.4 Angle beam probes 10
5.4.1 Radius technique 10
5.4.2 Straight beam probe technique 10
5.4.3 Reference block technique 10
5.4.4 Contoured probes 10
5.5 Alternative range settings for angle beam probes 11
5.5.1 Flat surfaces 11
5.5.2 Curved surfaces 11

6 Sensitivity setting and echo height evaluation 13
6.1 General 13
6.2 Angle of impingement 13
6.3 Distance Amplitude Curve (DAC) technique 13
6.3.1 Reference blocks 13
6.3.2 Preparation of a Distance Amplitude Curve 14
6.3.3 Evaluation of signals using a Distance Amplitude Curve 15
6.3.4 Evaluation of signals using a reference height 15

6.4 Distance Gain Size (DGS) technique 16
6.4.1 General 16
6.4.2 Reference blocks 18
6.4.3 Use of DGS diagrams 18
6.4.4 Restrictions on use of the DGS technique due to geometry 20

Introduction vi
6.5 Transfer correction 20
6.5.1 General 20
6.5.2 Fixed path length technique 20
6.5.3 Comparative technique 21
6.5.4 Compensation for local variations in transfer correction 22

Annex A (normative) Quantities and symbols 23

Annex B (normative) Reference blocks and reference reflectors 26

Annex C (normative) Determination of sound path distance and impingement angle in concentrically curved objects 29

C.1 Impingement angle 29
C.2 Sound path when scanning from the outer (convex) surface: 29
C.2.1 Full skip 30
C.2.2 Half skip 30
C.3 Soundpath when scanning from the inner (concave) surface: 31
C.3.1 Full skip 31
C.3.2 Half skip 32

Annex D (informative) General DGS diagram 33

D.1 Distance 33
D.2 Gain 33
D.3 Size 34

Annex E (informative) Determination of contact transfer correction factors 35

E.1 General 35
E.2 Measurement 35
E.3 Evaluation 35

Bibliography 38