DIN EN ISO 16811:2014-06 (E)

Non-destructive testing - Ultrasonic testing - Sensitivity and range setting (ISO 16811:2012)

Contents

Page

Foreword 4

Introduction 5

1 Scope 6

2 Normative references 6

3 General 6
3.1 Quantities and symbols 6
3.2 Test objects, reference blocks and reference reflectors 6
3.3 Categories of test objects 6
3.4 Contouring of probes 7
3.4.1 Longitudinally curved probes 8
3.4.2 Transversely curved probes 8
3.4.3 Concave scanning surface 9

4 Determination of probe index and beam angle 9
4.1 General 9
4.2 Flat probes 9
4.2.1 Calibration block technique 9
4.2.2 Reference block technique 9
4.3 Probes curved longitudinally 9
4.3.1 Mechanical determination 9
4.3.2 Reference Block Technique 11
4.4 Probes curved transversely 11
4.4.1 Mechanical determination 6 4.4.2 Reference block technique 12
4.5 Probes curved in two directions 13
4.6 Probes for use on materials other than non-alloy steel 14

5 Time base setting 14
5.1 General 14
5.2 Reference blocks and reference reflectors 14
5.3 Straight beam probes 15
5.3.1 Single reflector technique 15
5.3.2 Multiple reflector technique 15
5.4 Angle beam probes 15
5.4.1 Radius technique 15
5.4.2 Straight beam probe technique 15
5.4.3 Reference block technique 15
5.4.4 Contoured probes 15
5.5 Alternative range settings for angle beam probes 16
5.5.1 Flat surfaces 16
5.5.2 Curved surfaces 16

6 Sensitivity setting and echo height evaluation 18
6.1 General 18
6.2 Angle of impingement 18
6.3 Distance Amplitude Curve (DAC) technique 18
6.3.1 Reference blocks 18
6.3.2 Preparation of a Distance Amplitude Curve 19

6.3.3 Evaluation of signals using a Distance Amplitude Curve 20
6.3.4 Evaluation of signals using a reference height 20
6.4 Distance Gain Size (DGS) technique 21
6.4.1 General 21
6.4.2 Reference blocks 23
6.4.3 Use of DGS diagrams 23
6.4.4 Restrictions on use of the DGS technique due to geometry 25
6.5 Transfer correction 25
6.5.1 General 25
6.5.2 Fixed path length technique 25
6.5.3 Comparative technique 26
6.5.4 Compensation for local variations in transfer correction 27

Annex A (normative) Quantities and symbols 28

Annex B (normative) Reference blocks and reference reflectors 31

Annex C (normative) Determination of sound path distance and impingement angle in concentrically curved objects 34

C.1 Impingement angle 34
C.2 Sound path when scanning from the outer (convex) surface: 34
C.2.1 Full skip 35
C.2.2 Half skip 35
C.3 Soundpath when scanning from the inner (concave) surface: 36
C.3.1 Full skip 36
C.3.2 Half skip 37

Annex D (informative) General DGS diagram 38

D.1 Distance 38
D.2 Gain 38
D.3 Size 39

Annex E (informative) Determination of contact transfer correction factors 40

E.1 General 40
E.2 Measurement 40
E.3 Evaluation 40

Bibliography 43