

ISO 23864:2021 (E)

Non-destructive testing of welds — Ultrasonic testing — Use of automated total focusing technique (TFM) and related technologies

Contents

	Foreword
1	Scope
2	Normative references
3	Terms and definitions
4	Testing levels
5	Information required before testing
5.1	Items to be defined before procedure development
5.2	Specific information required by the operator before testing
5.3	Written test procedure
6	Requirements for personnel and equipment
6.1	Personnel qualifications
6.2	Test equipment
6.2.1	General
6.2.2	Instrument
6.2.3	Probes
6.2.4	Scanning mechanisms
7	Preparation for testing
7.1	Volume to be tested
7.2	Imaging typical weld discontinuities
7.2.1	Discontinuity orientation
7.2.2	Discontinuity location
7.2.3	Suitable imaging paths for specific discontinuity types
7.3	Verification of test setup
7.4	Scan increment setting
7.5	Geometry considerations
7.6	Preparation of scanning surfaces
7.7	Temperature
7.8	Couplant
8	Testing of parent material
9	Range and sensitivity
9.1	General
9.2	Range and sensitivity settings
9.2.1	General
9.2.2	Setting range and sensitivity on the test object itself
9.2.3	Gain corrections
9.3	Checking of the settings
10	Reference blocks and test blocks
10.1	General
10.2	Material
10.3	Dimensions and shape
10.4	Reference reflectors
11	Equipment checks

- 12 Procedure verification
 - 13 Weld testing
 - 14 Data storage
 - 15 Interpretation and analysis of TFM images
 - 15.1 General
 - 15.2 Assessing the quality of TFM images
 - 15.3 Identification of relevant indications
 - 15.4 Classification of relevant indications
 - 15.5 Determination of location and length of an indication
 - 15.5.1 Location
 - 15.5.2 Length
 - 15.6 Determination of amplitude or height of an indication
 - 15.6.1 General
 - 15.6.2 Based on amplitude
 - 15.6.3 Based on height
 - 15.7 Evaluation against acceptance criteria
 - 16 Test report
 - 17 Austenitic welds
- Annex A (informative) Typical reference blocks and reference reflectors**
- A.1 Reference reflectors
 - A.2 Typical reference blocks
 - A.2.1 Testing level A
 - A.2.2 Testing level B
 - A.2.3 Testing level C
 - A.2.4 Testing level D
 - A.2.5 Objects with thickness 3,2 mm to 8 mm
- Annex B (informative) TFM images of typical discontinuities**
- B.1 General
 - B.2 Examples of images

Page count: 32