

ISO 16826:2025-03 (E)

Non-destructive testing - Ultrasonic testing - Testing for discontinuities perpendicular to the surface

| Contents | | Page |
|---|--|-------------|
| Foreword | | iv |
| Introduction | | v |
| 1 Scope | | 1 |
| 2 Normative references | | 1 |
| 3 Terms and definitions | | 1 |
| 4 Test equipment and test personnel | | 1 |
| 5 Tandem technique | | 2 |
| 5.1 General..... | | 2 |
| 5.2 Probe movement..... | | 3 |
| 5.3 Time base setting..... | | 3 |
| 5.4 Sensitivity setting..... | | 3 |
| 5.5 Determination of test zones..... | | 4 |
| 5.6 Depth-gain diagram for tandem technique..... | | 5 |
| 5.7 Corrections of sensitivity..... | | 6 |
| 5.8 Test objects with concentric surfaces..... | | 6 |
| 5.8.1 General..... | | 6 |
| 5.8.2 Scanning on a concave surface..... | | 7 |
| 5.8.3 Scanning on a convex surface..... | | 7 |
| 6 Longitudinal-longitudinal-transverse wave technique | | 8 |
| 6.1 General..... | | 8 |
| 6.2 Time base setting and determination of depth of a discontinuity..... | | 9 |
| 6.3 Sensitivity setting..... | | 10 |
| 6.4 Determination of the depth of the intersection of the beam axes..... | | 10 |
| 6.5 Sensitivity diagram for LLT technique..... | | 11 |
| 6.6 Correction of sensitivity..... | | 11 |
| Annex A (informative) Nomograms for tandem distances for convex and concave surfaces | | 12 |
| Bibliography | | 15 |