

# DIN EN ISO 17640:2011-04 (E)

## Non-destructive testing of welds - Ultrasonic testing - Techniques, testing levels, and assessment (ISO 17640:2010)

---

<b>Contents</b>		<b>Page</b>
Foreword .....		3
1	Scope .....	4
2	Normative references .....	4
3	Symbols and definitions .....	5
4	Principle .....	5
5	Information required prior to testing .....	6
5.1	Items to be specified .....	6
5.2	Specific information required before testing .....	6
5.3	Written test procedure .....	7
6	Requirements for personnel and equipment .....	7
6.1	Personnel qualifications .....	7
6.2	Equipment .....	7
6.3	Probe parameters .....	7
7	Testing volume .....	8
8	Preparation of scanning surfaces .....	8
9	Parent metal testing .....	9
10	Range and sensitivity setting .....	10
10.1	General .....	10
10.2	Reference for sensitivity setting .....	10
10.3	Evaluation levels .....	11
10.4	Transfer correction .....	11
10.5	Signal to noise ratio .....	11
11	Testing levels .....	12
12	Testing techniques .....	12
12.1	General .....	12
12.2	Manual scan path .....	12
12.3	Testing for imperfections perpendicular to the testing surface .....	12
12.4	Location of indications .....	12
12.5	Evaluation of indications .....	13
13	Test report .....	14
Annex A (normative) Testing levels for various types of welded joints .....		16