

ISO 22825:2012-05 (E)

Non-destructive testing of welds - Ultrasonic testing - Testing of welds in austenitic steels and nickel-based alloys

Contents		Page
Foreword		iv
Introduction		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	2
4	Information required prior to testing	2
4.1	Item to be defined by specification	2
4.2	Specific information required by the operator prior to testing	2
5	Personnel	3
6	Equipment	3
7	Range setting for compression waves	3
8	Sensitivity setting	4
8.1	General	4
8.2	Use of side-drilled holes	4
8.3	Use of other reference reflectors	5
9	Test procedure and ultrasonic techniques	5
9.1	Development of the test procedure	5
9.2	Content of the procedure	5
9.3	Selection of ultrasonic technique(s)	6
9.4	Optimization of technique and draft of procedure	7
9.5	Practical implications of the use of refracted compression waves	7
10	Classification and sizing of indications	8
11	Testing of welds	8
11.1	General	8
11.2	Surface condition and couplant fluid	8
11.3	Parent metal testing	8
11.4	Scanning	8
11.5	Evaluation of indications	9
12	Test report	9
12.1	General data	9
12.2	Information related to equipment	9
12.3	Information related to testing technique	9
12.4	Results of testing	10
Annex A (informative) Compression wave angle beam techniques		11
Annex B (informative) Stainless steel calibration blocks for range setting		17

Annex C (informative) Reference blocks for sensitivity setting	19
Bibliography	22