# ISO 18211:2016-07 (E)

## Non-destructive testing - Long-range inspection of above-ground pipelines and plant piping using guided wave testing with axial propagation

## Contents

Page


Foreword ..... iv

1 Scope ..... 1

2 Normative references ..... 1

3 Termsanddefinitions ..... 1

4 Test personnel ..... 3

5 General ..... 3

6 FactorsinfluencingGWTperformance ..... 4
6.1 External diameter ..... 4
6.2 Pipeline geometry ..... 4
6.3 Test range ..... 4
6.4 Road crossing ..... 5

7 Test equipment ..... 5
7.1 General ..... 5
7.2 Probe ring ..... 5
7.3 Signal processing and analysis system ..... 5
7.4 Periodic verification of equipment performance ..... 5
7.5 Instrument settings ..... 6

8 Test procedure ..... 6

9 Requirements for test data quality ..... 6

10 Testing ..... 7
10.1 Preparation of the test object ..... 7
10.1.1 Surface temperature ..... 7
10.1.2 Removal of insulation ..... 7
10.1.3 Wall thickness assessment ..... 7
10.1.4 Surface preparation ..... 7
10.2 Probe ring test position ..... 8
10.3 Data collection ..... 8
10.4 Reporting sensitivity ..... 8
10.5 Data interpretation ..... 8
10.6 Detection sensitivity ..... 9
10.7 Visual confirmation ..... 9

11 ComplementaryNDTtosupporttheGWT ..... 9

12 Test report ..... 9

Annex A (informative) Selection of guided wave modes ..... 11

Bibliography ..... 15