

DIN EN 17501:2022-08 (E)

Non-destructive testing - Thermographic testing - Active thermography with laser excitation

Contents		Page
European foreword		4
1	Scope	5
2	Normative references	5
3	Terms and definitions	5
4	Qualification and certification of personnel	6
5	Principle of laser thermography and experimental setup	6
5.1	General	6
5.2	Typical configurations of excitation	8
5.2.1	General	8
5.2.2	Laser thermography in static configuration (without relative movement)	8
5.2.3	Laser thermography in dynamic configuration (with relative movement)	8
5.2.4	Laser thermography with different temporal excitations	8
5.2.5	Laser thermography with different spatial excitations	8
5.3	Laser and laser optics requirements	8
5.3.1	Laser irradiance and wavelength	8
5.3.2	Spatial illumination shapes	9
5.3.3	Switchable laser for lock-in thermography and other temporal techniques	10
5.3.4	Safety	10
5.4	Scanning system requirement	11
5.4.1	General	11
5.4.2	Test object position and orientation	11
5.4.3	Movement of the test object	12
5.4.4	Movement of the whole measurement system	12
5.4.5	Movement of the laser beam through optics	12
5.4.6	Movement of the laser beam and IR camera through optics	12
5.4.7	Setup stability	12
5.5	Specifications of the IR camera	12
5.6	Data processing and analysis techniques	14
5.6.1	General	14
5.6.2	Spot with relative movement	14
5.6.3	Line with relative movement	17
5.7	Data processing for crack characterization	17
5.7.1	General	17
5.7.2	Static pulsed laser spot	17
5.7.3	Continuously scanned laser spot	19
5.7.4	Continuously scanned laser line	19
5.8	Data processing and analysis techniques for the determination of lateral thermal diffusivity	20
5.9	Data processing and analysis techniques for emissivity correction	20
5.10	Data processing and analysis techniques for coating thickness control	20
6	Reference test specimens	20
7	Calibration, validation and performance of testing	20
8	Evaluation, classification and registration of thermographic indications	21

9	Test report	21
	Annex A (informative) List of influential parameters for the NDT qualification of laser thermographic system	23
A.1	General	23
A.2	Input data group parameters	23
A.2.1	Component and his environment:	23
A.2.2	Discontinuities:	23
A.3	NDT laser TT System (procedure parameters)	24
A.3.1	IR Camera and optics	24
A.3.2	Laser	25
A.3.3	Scanning system and set-up	25
A.3.4	Calibration Blocks	25
A.3.5	Data processing and analysis	25
	Annex B (informative) Reference blocks	27
B.1	Test specimen containing an artificial surface breaking notch	27
B.2	Test specimen containing a natural crack	28
B.3	Test specimen containing natural cracks - reference block no. 1 for magnetic particle testing according to EN ISO 9934-2	29
B.4	Test specimen containing artificial subsurface notches	29
	Bibliography	31