DIN EN ISO 16811:2025-06 (E)

Non-destructive testing - Ultrasonic testing - Sensitivity and range setting (ISO 16811:2025)

Contents

Page

Foreword ..... **v**

Introduction ..... **vi**

1 Scope **1**

2 Normative references **1**

3 Terms and definitions **1**

4 Quantities and symbols **1**

5 Qualification of personnel **3**

6 Test equipment **3**
6.1 Instrument 3
6.2 Probes 3
6.2.1 General 3
6.2.2 Probe selection 3
6.2.3 Frequency and dimensions of transducer 4
6.2.4 Dead zone 4
6.2.5 Damping 4
6.2.6 Focusing probes 4
6.3 Coupling media 4
6.4 Standard blocks 5
6.5 Reference blocks 5
6.6 Specific test blocks 6

7 Categories of test objects **6**

8 Test objects, reference blocks and reference reflectors **6**

9 Probes **9**
9.1 General 9
9.2 Longitudinally curved probes 10
9.2.1 Convex scanning surface 10
9.2.2 Concave scanning surface 10
9.3 Transversely curved probes 10
9.3.1 Convex scanning surface 10
9.3.2 Concave scanning surface 11

10 Determination of probe index point and beam angle **11**
10.1 General 11
10.2 Flat angle-beam probes 11
10.2.1 Calibration block technique 11
10.2.2 Reference block technique 11
10.3 Angle-beam probes curved longitudinally 11
10.3.1 Mechanical determination 11
10.3.2 Reference block technique 13
10.4 Angle-beam probes curved transversely 13
10.4.1 Mechanical determination 13
10.4.2 Reference block technique 14
10.5 Probes curved in two directions 15
10.6 Probes for use on materials other than non-alloy steel 15

11 Time base setting **15**
11.1 General 15

11.2 Reference blocks and reference reflectors ... 16
11.3 Straight-beam probes ... 16
11.3.1 Single-reflector technique ... 16
11.3.2 Multiple-reflector technique ... 16
11.4 Angle-beam probes ... 17
11.4.1 Radius technique ... 17
11.4.2 Straight-beam probe technique ... 17
11.4.3 Reference block technique ... 17
11.4.4 Contoured probes ... 17
11.5 Alternative range settings for angle-beam probes ... 17
11.5.1 Flat surfaces ... 17
11.5.2 Curved surfaces ... 18

12 Sensitivity setting and echo height evaluation ... 19
12.1 General ... 19
12.2 Angle of incidence ... 20
12.3 Distance-amplitude curve (DAC) technique ... 20
12.3.1 Reference blocks ... 20
12.3.2 Preparation of a distance-amplitude curve ... 21
12.3.3 Evaluation of signals using a distance-amplitude curve ... 22
12.3.4 Evaluation of signals using a reference height ... 22
12.4 Distance-gain-size (DGS) technique ... 23
12.4.1 General ... 23
12.4.2 Reference blocks ... 25
12.4.3 Use of DGS diagrams ... 26
12.4.4 Restrictions on use of the DGS technique due to geometry ... 28
12.5 Transfer correction ... 28
12.5.1 General ... 28
12.5.2 Fixed path length technique ... 29
12.5.3 Comparative technique ... 29
12.5.4 Compensation for local variations in transfer correction ... 30

Annex A (informative) **Determination of sound path distance and angle of incidence in category 2 test objects ... 31**

Annex B (informative) **General DGS diagram ... 36**

Annex C (informative) **Determination of contact transfer correction factors ... 38**

Bibliography ... 41