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IRISH STANDARD

I.S. EN 10246-15:2000

ICS 23.040.10
77.040.20

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NON-DESTRUCTIVE TESTING OF STEEL TUBES - PART 15: AUTOMATIC ULTRASONIC TESTING OF STRIP/PLATE USED IN THE MANUFACTURE OF WELDED STEEL TUBES FOR THE DETECTION OF LAMINAR IMPERFECTIONS

This Irish Standard was published under the authority of the National Standards Authority of Ireland and comes into effect on: June 23, 2000

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 10246-15

February 2000

ICS 23.040.10; 77.040.20

English version

Non-destructive testing of steel tubes - Part 15: Automatic ultrasonic testing of strip/plate used in the manufacture of welded steel tubes for the detection of laminar imperfections

Essais non destructifs des tubes en acier - Partie 15: Contrôle automatique par ultrasons pour la détection des dédoublures dans les bandes/plaques utilisées pour la fabrication des tubes en acier soudés

Zerstörungsfreie Prüfung von Stahlrohren - Teil 15: Automatische Ultraschallprüfung von Band/Blech, das für die Herstellung geschweißter Stahlrohre eingesetzt wird, zum Nachweis von Dopplungen

This European Standard was approved by CEN on 25 December 1999.

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FOREWORD

This European Standard has been prepared by Technical Committee ECISS/TC 29 "Steel tubes and fittings for steel tubes", the secretariat of which is held by UNI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by August 2000, and conflicting national standards shall be withdrawn at the latest by August 2000.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

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1 SCOPE

This Part of EN 10246 specifies requirements for the ultrasonic testing of strip/plate used in the manufacture of welded tubes for the detection of laminar imperfections. The standard specifies acceptance levels and calibration procedures.

NOTE 1: In the case of welded tube, an alternative ultrasonic testing specification for the detection of laminar imperfections is available which may be applied at the manufacturer's option by ultrasonic testing of the tube subsequent to seam welding in accordance with EN 10246-14.

NOTE 2: At the discretion of the manufacturer, the requirements of this Part of EN 10246 may be applied to finished submerged arc welded (SAW) tubes.

This Part of EN 10246 is applicable to the inspection of strip/plate with a thickness greater than or equal to 4,0 mm.

European Standard EN 10246 "Non-destructive testing of steel tubes" comprises the parts shown in Annex A.

2 GENERAL REQUIREMENTS

2.1 This ultrasonic inspection of strip/plate shall be carried out before or during pipe production in the flat form.

2.2 The strip/plate to be tested shall be sufficiently free from surface irregularities and foreign matter as to ensure the validity of the test.

3 METHOD OF TEST

3.1 The strip/plate shall be tested using an ultrasonic pulse echo technique for the detection of laminar imperfections with ultrasound transmitted in the direction normal to the strip/plate surface or using the ultrasonic through-transmission technique at the discretion of the manufacturer.

3.2 During testing, the strip/plate and the transducer assembly shall be moved relative to each other so that the strip/plate surface is scanned along equidistant scan lines parallel or transverse to the principal rolling direction of the strip/plate, with a minimum coverage and maximum allowable gap between adjacent scanning tracks as given in table 1. For the oscillating technique, the minimum coverage shall be half the values given in table 1.

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