This British Standard is the UK implementation of EN ISO 10863:2011. It supersedes DD CEN/TS 14751:2004 which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee WEE/46, Non-destructive testing.

A list of organizations represented on this committee can be obtained on request to its secretary.

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ISBN 978 0 580 64193 0

ICS 25.160.40

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This British Standard was published under the authority of the Standards Policy and Strategy Committee on 30 September 2011.

Amendments issued since publication

Date Text affected
Non-destructive testing of welds - Ultrasonic testing - Use of time-of-flight diffraction technique (TOFD) (ISO 10863:2011)

This European Standard was approved by CEN on 27 August 2011.

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Foreword

This document (ISO 10863:2011) has been prepared by Technical Committee CEN/TC 121 “Welding”, the secretariat of which is held by DIN, in collaboration with Technical Committee ISO/TC 44 "Welding and allied processes".

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of an identical text or by endorsement, at the latest by March 2012, and conflicting national standards shall be withdrawn at the latest by March 2012.

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Foreword

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The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75% of the member bodies casting a vote.

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ISO 10863 was prepared by the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, Welding, in collaboration with Technical Committee ISO/TC 44, Welding and allied processes, Subcommittee SC 5, Testing and inspection of welds, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

Requests for official interpretations of any aspect of this International Standard should be directed to the Secretariat of ISO/TC 44/SC 5 via your national standards body. A complete listing of these bodies can be found at www.iso.org.
Non-destructive testing of welds — Ultrasonic testing — Use of time-of-flight diffraction technique (TOFD)

1 Scope

This International Standard specifies the application of the time-of-flight diffraction (TOFD) technique to the semi- or fully automated ultrasonic testing of fusion-welded joints in metallic materials of minimum thickness 6 mm. It applies to full penetration welded joints of simple geometry in plates, pipes, and vessels, where both the weld and parent material are low-alloyed carbon steel. Where specified and appropriate, TOFD can also be used on other types of materials that exhibit low ultrasonic attenuation (especially that due to scatter).

Where material-dependent ultrasonic parameters are specified in this International Standard, they are based on steels having a sound velocity of \((5 \, 920 \pm 50)\) m/s for longitudinal waves, and \((3 \, 255 \pm 30)\) m/s for transverse waves. It is necessary to take this fact into account when examining materials with a different velocity.

This International Standard makes reference to the basic standard EN 583-6 and provides guidance on the specific capabilities and limitations of TOFD for the detection, location, sizing and characterization of discontinuities in fusion-welded joints. TOFD can be used as a stand-alone method or in combination with other non-destructive testing (NDT) methods or techniques, for manufacturing inspection, and for in-service inspection.

This International Standard specifies four testing levels (A, B, C, D) in accordance with ISO 17635 and corresponding to an increasing level of inspection reliability. Guidance on the selection of testing levels is provided.

This International Standard permits assessment of TOFD indications for acceptance purposes. This assessment is based on the evaluation of transmitted, reflected and diffracted ultrasonic signals within a generated TOFD image.

This International Standard does not include acceptance levels for discontinuities.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 9712, Non-destructive testing — Qualification and certification of NDT personnel — General principles

ISO 17635, Non-destructive testing of welds — General rules for metallic materials

ISO 17640:2010, Non-destructive testing of welds — Ultrasonic testing — Techniques, testing levels, and assessment

EN 473, Non-destructive testing — Qualification and certification of NDT personnel — General principles

EN 583-6, Non-destructive testing — Ultrasonic examination — Part 6: Time-of-flight diffraction technique as a method for detection and sizing of discontinuities