

---

---

**Non-destructive testing of steel tubes —  
Part 11:  
Automated ultrasonic testing of the weld  
seam of welded steel tubes for the  
detection of longitudinal and/or  
transverse imperfections**

*Essais non destructifs des tubes en acier —*

*Partie 11: Contrôle automatisé par ultrasons du cordon de soudure des  
tubes en acier soudés pour la détection des imperfections  
longitudinales et/ou transversales*



**PDF disclaimer**

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

STANDARDSISO.COM : Click to view the full PDF of ISO 10893-11:2011



**COPYRIGHT PROTECTED DOCUMENT**

© ISO 2011

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office  
Case postale 56 • CH-1211 Geneva 20  
Tel. + 41 22 749 01 11  
Fax + 41 22 749 09 47  
E-mail [copyright@iso.org](mailto:copyright@iso.org)  
Web [www.iso.org](http://www.iso.org)

Published in Switzerland

## Contents

Page

Foreword .....	iv
<b>1 Scope .....</b>	<b>1</b>
<b>2 Normative references .....</b>	<b>1</b>
<b>3 Terms and definitions .....</b>	<b>2</b>
<b>4 General requirements .....</b>	<b>2</b>
<b>5 Test method .....</b>	<b>3</b>
<b>6 Reference tube.....</b>	<b>4</b>
<b>6.1 General .....</b>	<b>4</b>
<b>6.2 Reference notches .....</b>	<b>5</b>
<b>6.3 Reference hole.....</b>	<b>6</b>
<b>7 Equipment calibration and checking.....</b>	<b>7</b>
<b>7.1 General .....</b>	<b>7</b>
<b>7.2 Adjustment of the trigger/alarm level.....</b>	<b>7</b>
<b>7.3 Calibration check and recalibration .....</b>	<b>7</b>
<b>8 Acceptance .....</b>	<b>8</b>
<b>9 Test report.....</b>	<b>8</b>
<b>Annex A (normative) Manual/semi-automated testing of untested ends and suspect areas .....</b>	<b>9</b>

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

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.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 10893-11 was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 19, *Technical delivery conditions for steel tubes for pressure purposes*.

This first edition cancels and replaces ISO 9764:1989 and ISO 9765:1990, which have been technically revised.

ISO 10893 consists of the following parts, under the general title *Non-destructive testing of steel tubes*:

- *Part 1: Automated electromagnetic testing of seamless and welded (except submerged arc-welded) steel tubes for the verification of leaktightness*
- *Part 2: Automated eddy current testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of imperfections*
- *Part 3: Automated full peripheral flux leakage testing of seamless and welded (except submerged arc-welded) ferromagnetic steel tubes for the detection of longitudinal and/or transverse imperfections*
- *Part 4: Liquid penetrant inspection of seamless and welded steel tubes for the detection of surface imperfections*
- *Part 5: Magnetic particle inspection of seamless and welded ferromagnetic steel tubes for the detection of surface imperfections*
- *Part 6: Radiographic testing of the weld seam of welded steel tubes for the detection of imperfections*
- *Part 7: Digital radiographic testing of the weld seam of welded steel tubes for the detection of imperfections*
- *Part 8: Automated ultrasonic testing of seamless and welded steel tubes for the detection of laminar imperfections*
- *Part 9: Automated ultrasonic testing for the detection of laminar imperfections in strip/plate used for the manufacture of welded steel tubes*
- *Part 10: Automated full peripheral ultrasonic testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of longitudinal and/or transverse imperfections*

- *Part 11: Automated ultrasonic testing of the weld seam of welded steel tubes for the detection of longitudinal and/or transverse imperfections*
- *Part 12: Automated full peripheral ultrasonic thickness testing of seamless and welded (except submerged arc-welded) steel tubes*

STANDARDSISO.COM : Click to view the full PDF of ISO 10893-11:2011

[STANDARDSISO.COM](https://standardsiso.com) : Click to view the full PDF of ISO 10893-11:2017

# Non-destructive testing of steel tubes —

## Part 11:

# Automated ultrasonic testing of the weld seam of welded steel tubes for the detection of longitudinal and/or transverse imperfections

## 1 Scope

This part of ISO 10893 specifies requirements for the automated ultrasonic shear wave (generated by conventional or phased array technique) testing of the weld seam of submerged arc-welded (SAW) or electric resistance and induction-welded (EW) steel tubes.

For SAW tubes, the test covers the detection of imperfections oriented predominantly parallel to or, by agreement, perpendicular to the weld seam or both.

For EW tubes, the test covers the detection of imperfections oriented predominantly parallel to the weld seam. In the case of testing on longitudinal imperfections, Lamb wave testing can be applied at the discretion of the manufacturer.

For the detection of imperfections at the weld seam of EW tubes, full peripheral ultrasonic testing is possible.

This part of ISO 10893 can also be applicable to the testing of circular hollow sections.

NOTE For full peripheral ultrasonic testing of seamless and welded (except SAW) tubes, see ISO 10893-10.

## 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 5577, *Non-destructive testing — Ultrasonic inspection — Vocabulary*

ISO 9712, *Non-destructive testing — Qualification and certification of personnel*

ISO 10893-6, *Non-destructive testing of steel tubes — Part 6: Radiographic testing of the weld seam of welded steel tubes for the detection of imperfections*

ISO 10893-7, *Non-destructive testing of steel tubes — Part 7: Digital radiographic testing of the weld seam of welded steel tubes for the detection of imperfections*

ISO 11484, *Steel products — Employer's qualification system for non-destructive testing (NDT) personnel*

### 3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 5577 and ISO 11484 and the following apply.

#### 3.1

##### **reference standard**

standard for the calibration of non-destructive testing equipment (e.g. drill holes, notches, recesses)

#### 3.2

##### **reference tube**

tube or length of tube containing the reference standard(s)

#### 3.3

##### **reference sample**

sample (e.g. segment of tube, plate or strip) containing the reference standard(s)

NOTE Only the term "reference tube" is used in this part of ISO 10893, also covering the term "reference sample".

#### 3.4

##### **tube**

hollow long product open at both ends, of any cross-sectional shape

#### 3.5

##### **welded tube**

ttube made by forming a hollow profile from a flat product and welding adjacent edges together. After welding the tube may be further processed, either hot or cold, into its final dimensions

#### 3.6

##### **electric welded tube**

tube made by pressure welding, in a continuous or non-continuous process, in which strip is formed cold into a hollow profile and the seam weld made by heating the adjacent edges through the resistance to the passage of high- or low-frequency current, and pressing the edges together

NOTE The electric current can be applied either by direct electrode contact or by induction.

#### 3.7

##### **manufacturer**

organization that manufactures products in accordance with the relevant standard(s) and declares the compliance of the delivered products with all applicable provisions of the relevant standard(s)

#### 3.8

##### **agreement**

contractual arrangement between the manufacturer and purchaser at the time of enquiry and order

### 4 General requirements

4.1 Unless otherwise specified by the product standards or agreed on by the purchaser and manufacturer, an ultrasonic test shall be carried out on tubes after completion of all the primary production process operations (rolling, heat treating, cold and hot working, sizing and primary straightening, etc.).

For cold-expanded tubes, the ultrasonic testing of the weld shall be carried out after expansion. In case of spirally welded tubes, where the tube is not subsequently subjected to a hydrostatic test at the tube mill, the acceptance test may be carried out online.

4.2 The tubes under test shall be sufficiently straight to ensure the validity of the test. The surface shall be sufficiently free of foreign matter which can interfere with the validity of the test.

**4.3** This test shall be carried out by suitably trained operators, qualified in accordance with ISO 9712, ISO 11484 or equivalent and supervised by competent personnel nominated by the manufacturer. In the case of third-party inspection, this shall be agreed on by the purchaser and manufacturer.

The operating authorization issued by the employer shall be according to a written procedure. Non-destructive testing (NDT) operations shall be authorized by a level 3 NDT individual approved by the employer.

NOTE The definition of levels 1, 2 and 3 can be found in appropriate International Standards, e.g. ISO 9712 and ISO 11484.

## 5 Test method

**5.1** The weld seam of the tube shall be tested using an ultrasonic shear wave technique for the detection of longitudinal and/or transverse imperfections. Lamb wave technique may be applied for the detection of longitudinal imperfections of EW tubes.

Unless otherwise agreed on by the purchaser and manufacturer, testing shall be carried out in two opposite directions of sound propagation for the requested type of inspection, clockwise and anticlockwise for the detection of longitudinal imperfections and forward and backward for the detection of transverse imperfections.

**5.2** During testing, the tubes and the probe assembly shall be moved relative to each other such that the whole area under inspection is scanned with coverage calculated on the dimension of the transducer(s).

The relative speed of movement during testing shall not vary by more than 10 %.

**5.3** There can be a short length at both tube ends which cannot be tested. Any untested ends shall be dealt with in accordance with the requirements of the appropriate product standard.

In the case of SAW tubes, the untested ends may, at the manufacturer's discretion, be checked either by a manual ultrasonic test in accordance with this part of ISO 10893 or by a radiographic test in accordance with ISO 10893-6 or ISO 10893-7.

In the case of EW tube, the untested ends may be tested in accordance with Annex A.

**5.4** For the detection of longitudinal imperfections, the maximum width of each individual transducer, measured parallel to the major axis of the tube, shall be 25 mm. For the detection of transverse imperfections, the maximum width of each individual transducer, measured perpendicular to the major axis of the tube, shall be 25 mm.

In case of the use of Lamb wave technique or phased array technique, the maximum length of transducer or active aperture shall be limited to 35 mm.

**5.5** The ultrasonic test frequency of transducers shall be in the range 1 MHz to 15 MHz for shear wave technique and in the range of 0,3 MHz to 1 MHz for Lamb wave technique, depending on the product condition and properties, the thickness and surface finishing of tubes under examination.

**5.6** The equipment shall be capable of classifying tubes as either acceptable or suspect, by means of an automated trigger/alarm level, combined with a marking or sorting system (or both).

**5.7** Where manual ultrasonic testing of untested tube ends and/or local suspect areas is required (see 5.3), use Annex A.

## 6 Reference tube

### 6.1 General

**6.1.1** The reference standards defined in this part of ISO 10893 are convenient standards for establishing the sensitivity of non-destructive testing equipment. The dimensions of these standards should not be construed as the minimum size of imperfection detectable by such equipment.

**6.1.2** For SAW tubes, for the detection of longitudinal imperfections, the equipment shall be calibrated using four longitudinal reference notches, two on the outside surface and two on the inside surface, in the parent material close to the weld seam of a reference tube, and/or a reference hole located in the centre of the weld (see Figure 1).

Alternatively, by agreement between the purchaser and manufacturer, the equipment may be calibrated using internal and external notches located on the centre of the weld seam. In this case, the depth of the notches shall be agreed on by the purchaser and manufacturer, and the manufacturer shall demonstrate that the sensitivity is equivalent to that obtained from the edge notches.

For the detection of transverse imperfections, if requested, the equipment shall be calibrated using two transverse notches in the weld seam, one on the external and one on the internal surface of reference tube, and/or a reference hole located in the centre of the weld.

The selection of the notches or the hole is left to the discretion of the manufacturer.

**6.1.3** For EW tubes, the ultrasonic equipment shall be calibrated using a longitudinal reference notch on the outside and inside surfaces of a reference tube.

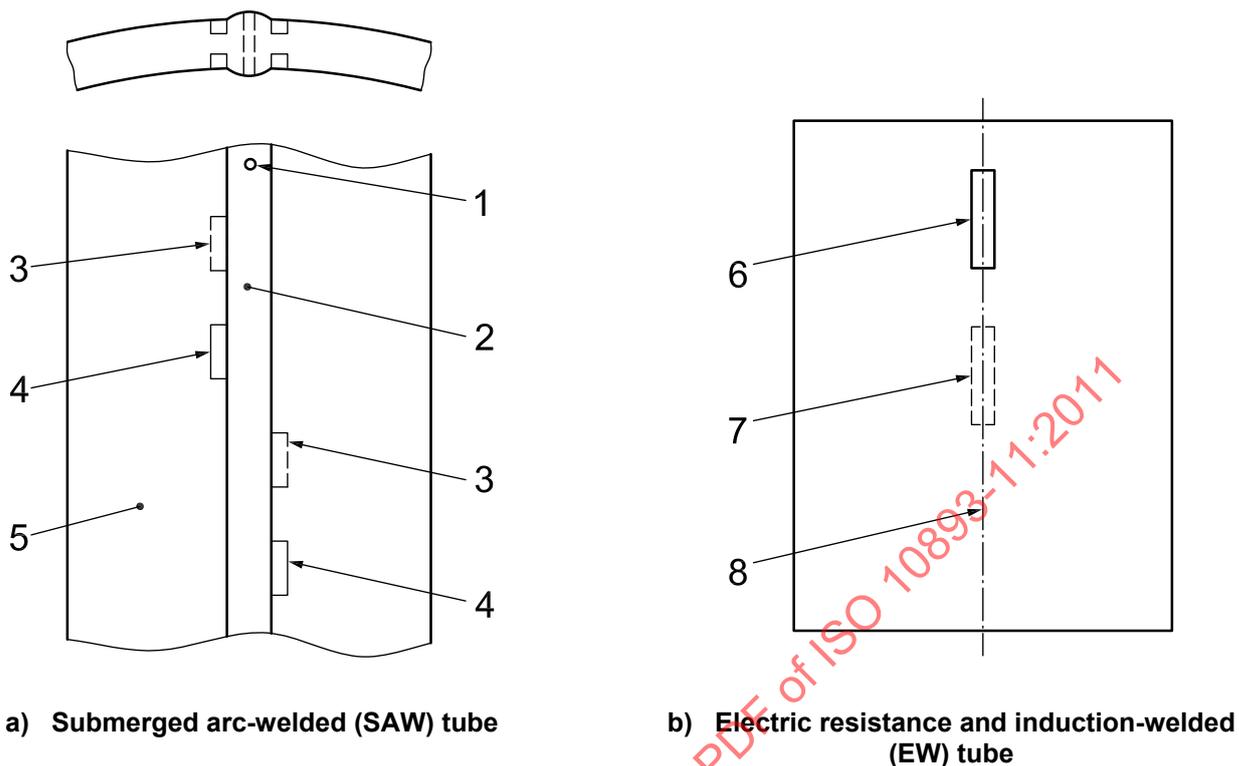
When the tube internal diameter is less than 15 mm, the manufacturer and purchaser may agree to waive the internal notch.

Alternatively, a reference hole drilled through the wall of the reference tube may be used for equipment calibration, by agreement between the purchaser and manufacturer. In this case, the diameter of the drill required to produce the reference hole for a specific acceptance level shall also be agreed on and the manufacturer shall demonstrate to the satisfaction of the purchaser that the test sensitivity achieved using the reference hole is essentially equivalent to that obtained when using the specified reference notch(es).

Such notches and drill holes shall be located in the centre of the weld line, unless otherwise agreed on by the purchaser and manufacturer.

**6.1.4** The reference tubes shall have the same nominal diameter and thickness, same surface finish and same heat treatment delivery condition (e.g. as-rolled, normalized, quenched and tempered) as the tubes under test, and shall have similar acoustic properties (e.g. sound velocity and attenuation coefficient). The manufacturer shall have the option of removing the weld bead of SAW tubes inside and outside such that it is in alignment with the curvature of the tube body.

**6.1.5** In order to obtain clearly distinguishable signals, the external and internal notches and the hole shall be sufficiently separated from the ends of the reference tube/sample and from each other.



**Key**

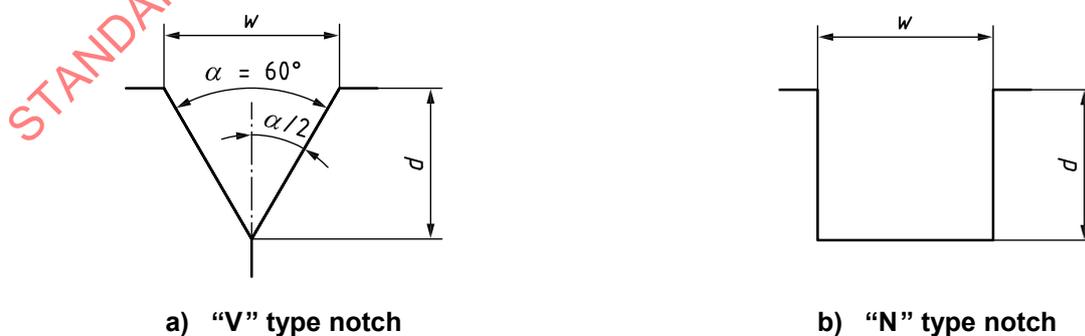
- |                           |                                       |                      |
|---------------------------|---------------------------------------|----------------------|
| 1 through hole            | 3 and 7 longitudinal internal notches | 5 reference tube     |
| 2 submerged arc-weld seam | 4 and 6 longitudinal external notches | 8 centreline of weld |

**Figure 1 — Simplified representation of reference tube**

**6.2 Reference notches**

**6.2.1 Types and preparation of notch**

**6.2.1.1** The reference notches shall be of the “N” type (N-notch) (see Figure 2); for EW tubes the “V” type notch (V-notch) may be used at the discretion of the manufacturer, if specified notch depth is less than or equal to 0,5 mm (see Figure 2). In the case of the “N” type notch, the sides shall be nominally parallel and the bottom shall be nominally square to the sides.



**Key**

- w width                      d depth

**Figure 2 — Types “V” and “N” reference notch**

**6.2.1.2** For SAW tubes, the reference notches shall be located in the parent material close to the weld edges and shall lie parallel to the weld seam (see Figure 1).

**6.2.1.3** The reference notch shall be formed by machining, spark erosion, etc.

NOTE The bottom or the bottom corners of the notch can be rounded.

**6.2.2 Dimension of reference notches**

**6.2.2.1 Width and depth**

**6.2.2.1.1** For width,  $w$ , see Figure 2. The width of the “N” type reference notch shall be not greater than 1,0 mm except for spirally welded tubes having the diameter equal to or greater than 406 mm where the width shall not exceed 1,5 mm. In any case, the width should not exceed twice the depth.

**6.2.2.1.2** For depth,  $d$ , see Figure 2. The depth of the reference notch shall be as given in Table 1.

The values of notch depth specified in Table 1 are the same, for the corresponding categories, in all International Standards concerning non-destructive testing of steel tubes where reference is made to different acceptance levels. Although the reference standards are identical, the various test methods involved may give different test results. Accordingly, the acceptance level designation prefix U (ultrasonic) has been adopted to avoid any inferred direct equivalence with other test methods.

The minimum notch depth shall be 0,3 mm for U2 and U3 category tubes and 0,5 mm for U4 category tubes.

The maximum notch depth shall be 1,5 mm for U2 and U3 category tubes and 3 mm for U4 category tubes.

**Table 1 — Acceptance levels and corresponding reference notch depth**

Acceptance level	Notch depth of the specified thickness %
U2	5
U3	10
U4	12,5
U5	15

The tolerance of notch depth shall be  $\pm 15\%$  of requested notch depth or  $\pm 0,05$  mm, whichever is the greater, with the exception that when the notch depth is less than 0,3 mm, the tolerance on the depth shall be  $\pm 0,03$  mm.

**6.2.2.2 Notch length**

Unless otherwise specified by the product standard or agreed on by the purchaser and manufacturer, the length of the reference notch(es) shall be greater than the width of the single transducer or active aperture. In any case, the length of reference notch shall not exceed 50 mm.

**6.2.2.3 Verification**

The reference notch dimensions and shape shall be verified by a suitable technique.

**6.3 Reference hole**

**6.3.1** The reference hole shall be drilled through the wall at the centre of the weld, perpendicular to the surface of the reference tube (see Figure 1).