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English Version

**Non-destructive testing of steel forgings - Part 4:
Ultrasonic testing of austenitic and austenitic-ferritic
stainless steel forgings**

Essais non destructifs des pièces forgées en acier -
Partie 4: Contrôle par ultrasons des pièces forgées en
aciers inoxydables austénitiques et austéno-ferritiques

Zerstörungsfreie Prüfung von Schmiedestücken aus
Stahl - Teil 4: Ultraschallprüfung von Schmiedestücken
aus austenitischem und austenitisch-ferritischem
nichtrostendem Stahl

This European Standard was approved by CEN on 3 October 2015.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION
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Contents

Page

European foreword.....	4
1 Scope	5
2 Normative references	5
3 Terms and definitions	5
4 Mandatory information	6
5 Test procedure	6
5.1 General.....	6
5.2 Form.....	6
5.3 Content.....	7
6 Personnel qualification.....	7
7 Equipment and accessories	7
7.1 Instrument.....	7
7.2 Probes.....	7
7.2.1 General.....	7
7.2.2 Contouring	8
7.2.3 Nominal frequency	8
7.2.4 Normal-beam probes	8
7.2.5 Angle-beam probes.....	8
7.2.6 Dual-element probes	8
7.3 Calibration blocks	8
7.4 Reference blocks	8
7.5 Couplant.....	8
8 Routine calibration and checking	9
9 Stage of manufacture	9
10 Surface condition	9
10.1 General.....	9
10.2 Surface finish related to quality class.....	9
10.3 As-forged surface condition	9
11 Test sensitivity	10
11.1 General.....	10
11.2 Normal-beam probes	10
11.3 Angle-beam probes.....	10
11.4 Repeat testing.....	10
12 Scanning	10
12.1 General.....	10
12.2 Complex forgings.....	11
12.3 Grid scanning coverage.....	11
12.4 100 % scanning coverage.....	11
12.5 Scanning speed.....	11
13 Classification.....	14
13.1 Classification of indications	14
13.2 Classification of discontinuities	16

14	Recording levels and acceptance criteria	19
15	Sizing	20
16	Test report	21
Annex A (informative) Maximum testable depth for corresponding beam path range for circumferential angle-beam scans		22
Annex B (informative) Amplitude of indication in dB relative to % DAC.....		24
Annex C (informative) Significant technical changes to the version EN 10228-4:1999		25

European foreword

This document (EN 10228-4:2016) has been prepared by Technical Committee ECISS/TC 111 “Steel castings and forgings”, the secretariat of which is held by AFNOR.

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 December 2016 and conflicting national standards shall be withdrawn at the latest by December 2016.

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

This document supersedes EN 10228-4:1999.

Annex C provides the significant technical changes to the previous version EN 10228-4:1999.

EN 10228 consists of the following parts under the general title *Non-destructive testing of steel forgings*:

- *Part 1: Magnetic particle inspection;*
- *Part 2: Penetrant testing;*
- *Part 3: Ultrasonic testing of ferritic or martensitic steel forgings;*
- *Part 4: Ultrasonic testing of austenitic and austenitic-ferritic stainless steel forgings.*

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

1 Scope

This European Standard describes techniques for the manual, pulse-echo, ultrasonic testing of forgings manufactured from austenitic and austenitic-ferritic stainless steels. Mechanized scanning techniques, such as immersion testing, may be used but should be agreed between the purchaser and supplier (see Clause 4).

This part of EN 10228 applies to four types of forgings, classified according to their shape and method of production. Types 1, 2 and 3 are essentially simple shapes. Type 4 covers complex shapes.

This part of EN 10228 does not apply to:

- closed die forgings;
- turbine rotor and generator forgings.

Ultrasonic testing of ferritic and martensitic steel forgings is the subject of Part 3 of this European Standard.

2 Normative references

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

EN 1330-1, *Non destructive testing - Terminology - Part 1: List of general terms*

EN 1330-4, *Non-destructive testing - Terminology - Part 4: Terms used in ultrasonic testing*

EN 12668-1, *Non-destructive testing - Characterization and verification of ultrasonic examination equipment - Part 1: Instruments*

EN 12668-2, *Non-destructive testing - Characterization and verification of ultrasonic examination equipment - Part 2: Probes*

EN 12668-3, *Non-destructive testing - Characterization and verification of ultrasonic examination equipment - Part 3: Combined equipment*

EN ISO 2400, *Non-destructive testing - Ultrasonic testing - Specification for calibration block No. 1 (ISO 2400)*

EN ISO 9712, *Non-destructive testing - Qualification and certification of NDT personnel (ISO 9712)*

EN ISO 16811, *Non-destructive testing - Ultrasonic testing - Sensitivity and range setting (ISO 16811)*

EN ISO 16827, *Non-destructive testing - Ultrasonic testing - Characterization and sizing of discontinuities (ISO 16827)*

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