

<b>STN</b>	<b>Nedeštruktívne skúšky zvarov Technika fázových polí (Phased Array technique) Kritériá prijateľnosti (ISO 19285: 2017)</b>	<b>STN EN ISO 19285</b>  05 1159
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Non-destructive testing of welds - Phased array ultrasonic testing (PAUT) - Acceptance levels (ISO 19285:2017)

Táto norma obsahuje anglickú verziu európskej normy.  
This standard includes the English version of the European Standard.

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**Non-destructive testing of welds - Phased array ultrasonic testing (PAUT) - Acceptance levels (ISO 19285:2017)**

Essais non destructifs des assemblages soudés -  
Technique ultrasons multi-éléments (PAUT) - Niveaux  
d'acceptation (ISO 19285:2017)

Zerstörungsfreie Prüfung von Schweißverbindungen -  
Ultraschallprüfungen mit Phased-Arrays (PAUT) -  
Zulässigkeitsgrenzen (ISO 19285:2017)

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**EN ISO 19285:2017 (E)**

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## **European foreword**

This document (EN ISO 19285:2017) has been prepared by Technical Committee ISO/TC 44 “Welding and allied processes” in collaboration with Technical Committee CEN/TC 121 “Welding and allied processes” the secretariat of which is held by DIN.

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# INTERNATIONAL STANDARD

# ISO 19285

First edition  
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## **Non-destructive testing of welds — Phased array ultrasonic testing (PAUT) — Acceptance levels**

*Essais non destructifs des assemblages soudés — Technique ultrasons  
multi-éléments (PAUT) — Niveaux d'acceptation*



Reference number  
ISO 19285:2017(E)

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## ISO 19285:2017(E)



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ISO copyright office  
Ch. de Blandonnet 8 • CP 401  
CH-1214 Vernier, Geneva, Switzerland  
Tel. +41 22 749 01 11  
Fax +41 22 749 09 47  
copyright@iso.org  
www.iso.org

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## ISO 19285:2017(E)

### Foreword

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The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

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This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 5, *Testing and inspection of welds*.

Requests for official interpretations of any aspect of this document 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](http://www.iso.org).



# Non-destructive testing of welds — Phased array ultrasonic testing (PAUT) — Acceptance levels

## 1 Scope

This document specifies acceptance levels for the phased array ultrasonic testing technique (PAUT) of full penetration welds in ferritic steels of minimum thickness of 6 mm which correspond to the quality levels of ISO 5817.

These acceptance levels are applicable to indications classified in accordance with ISO 13588.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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 testing — Vocabulary*

ISO 5817, *Welding — Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) — Quality levels for imperfections*

ISO 11666, *Non-destructive testing of welds — Ultrasonic testing — Acceptance levels*

ISO 13588, *Non-destructive testing of welds — Ultrasonic testing — Use of automated phased array technology*

ISO 15626, *Non-destructive testing of welds — Time-of-flight diffraction technique (TOFD) — Acceptance levels*

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

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