

STN	Nedeštruktívne skúšanie zvarov Skúšanie ultrazvukom Použitie automatizovanej techniky úplnej fokusácie (TFM) a súvisiacich technológií (ISO 23864: 2021)	STN EN ISO 23864 05 1157
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Nondestructive testing of welds - Ultrasonic testing - Use of automated total focusing technique (TFM) and related technologies (ISO 23864:2021)

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

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 02/22

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English Version

Non-destructive testing of welds - Ultrasonic testing - Use of automated total focusing technique (TFM) and related technologies (ISO 23864:2021)

Essais non destructifs des assemblages soudés -
Contrôle par ultrasons - Utilisation de la technique
d'acquisition automatisée de focalisation en tout point
(FTP) et de techniques associées (ISO 23864:2021)

Zerstörungsfreie Prüfung von Schweißverbindungen -
Ultraschallprüfung - Verwendung der automatisierten
Totalfokussierungsmethode (TFM) und verwandte
Technologien (ISO 23864:2021)

This European Standard was approved by CEN on 5 December 2021.

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CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

EN ISO 23864:2021 (E)

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European foreword

The text of ISO 23864:2021 has been prepared by Technical Committee IIW "International Institute of Welding" of the International Organization for Standardization (ISO) and has been taken over as EN ISO 23864:2021 by Technical Committee CEN/TC 121 "Welding and allied processes" the secretariat of which is held by DIN.

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of an identical text or by endorsement, at the latest by June 2022, and conflicting national standards shall be withdrawn at the latest by June 2022.

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

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INTERNATIONAL STANDARD

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Non-destructive testing of welds — Ultrasonic testing — Use of automated total focusing technique (TFM) and related technologies

*Essais non destructifs des assemblages soudés — Contrôle par
ultrasons — Utilisation de la technique d'acquisition automatisée de
focalisation en tout point (FTP) et de techniques associées*



Reference number
ISO 23864:2021(E)

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ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Email: copyright@iso.org
Website: www.iso.org

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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.

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).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by the IIW, *International Institute of Welding*, Commission V, *NDT and Quality Assurance of Welded Products*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

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Non-destructive testing of welds — Ultrasonic testing — Use of automated total focusing technique (TFM) and related technologies

IMPORTANT — The electronic file of this document contains colours which are considered to be useful for the correct understanding of the document. Users should therefore consider printing this document using a colour printer.

1 Scope

This document specifies the application of the TFM technique and related technologies for semi- or fully automated ultrasonic testing of fusion-welded joints in metallic materials of minimum thickness 3,2 mm.

NOTE Unless stated otherwise, in this document “TFM” and “TFM technique” refer to the TFM technique as defined in ISO 23243, and to all related technologies, see for example ISO 23865 and ISO 23243.

This document is applicable to components with welds fabricated using metals which have isotropic (constant properties in all directions) and homogeneous conditions. This includes welds in low carbon alloy steels and common aerospace grade aluminium and titanium alloys, provided they are homogeneous and isotropic.

This document applies to full penetration welded joints of simple geometry in plates, pipes and vessels.

This document specifies four testing levels (A, B, C, D), each corresponding to a different probability of detection of imperfections. Guidance on the selection of testing levels is provided. Coarse-grained metals and austenitic welds can be tested when the provisions of this document have been taken into account.

This document gives provisions on the specific capabilities and limitations of the TFM technique for the detection, locating, sizing and characterization of discontinuities in fusion-welded joints. The TFM technique can be used as a stand-alone approach or in combination with other non-destructive testing (NDT) methods for manufacturing, in-service and post-repair tests.

This document includes assessment of indications for acceptance purposes based on either amplitude (equivalent reflector size) and length or height and length.

This document does not include acceptance levels for discontinuities.

The following two typical testing techniques for welded joints are referred to in this document:

- a) side scanning, where the probe(s) is (are) positioned adjacent to the weld cap, typically using wedges. Side scanning can be performed from one side or both sides of the weld;
- b) top scanning where the probe is positioned on top of weld cap with a flexible, conformable delay line or using immersion technique, or using contact technique after removing the weld cap.

Semi-automated testing encompasses a controlled movement of one or more probes along a fixture (guidance strip, ruler, etc.), whereby the probe position is measured with a position sensor. The scan is performed manually.

In addition, fully automated testing includes mechanized propulsion.

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

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

ISO 18563-1, *Non-destructive testing — Characterization and verification of ultrasonic phased array equipment — Part 1: Instruments*

ISO 18563-2, *Non-destructive testing — Characterization and verification of ultrasonic phased array equipment — Part 2: Probes*

ISO 23865:2021, *Non-destructive testing — Ultrasonic testing — General use of full matrix capture/ total focusing method technique*

ISO 23243, *Non-destructive testing — Ultrasonic testing with arrays - Vocabulary*

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