

**Non-destructive testing of welds - Time-of-flight
diffraction technique (TOFD) - Acceptance levels (ISO
15626:2011)**

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN ISO 15626:2013 sisaldab Euroopa standardi EN ISO 15626:2013 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 15626:2013 consists of the English text of the European standard EN ISO 15626:2013.
Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation.
Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 14.08.2013.	Date of Availability of the European standard is 14.08.2013.
Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

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English Version

Non-destructive testing of welds - Time-of-flight diffraction
technique (TOFD) - Acceptance levels (ISO 15626:2011)

Contrôle non destructif des assemblages soudés -
Technique de diffraction des temps de vol (TOFD) -
Niveaux d'acceptation (ISO 15626:2011)

Zerstörungsfreie Prüfung von Schweißverbindungen -
Beugungslaufzeittechnik (TOFD) - Zulässigkeitsgrenzen
(ISO 15626:2011)

This European Standard was approved by CEN on 8 August 2013.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
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Foreword

The text of ISO 15626:2011 has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" of the International Organization for Standardization (ISO) and has been taken over as EN ISO 15626:2013 by Technical Committee CEN/TC 121 "Welding" 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of an identical text or by endorsement, at the latest by February 2014, and conflicting national standards shall be withdrawn at the latest by February 2014.

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 15617:2009.

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Endorsement notice

The text of ISO 15626:2011 has been approved by CEN as EN ISO 15626:2013 without any modification.

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

1 Scope

This International Standard specifies acceptance levels for the time-of-flight diffraction technique (TOFD) of full penetration welds in ferritic steels from 6 mm up to 300 mm thickness which correspond to the quality levels of ISO 5817.

These acceptance levels are applicable to indications classified in accordance with ISO 10863.

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 5817, *Welding — Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) — Quality levels for imperfections (ISO 5817:2003, corrected version:2005, including Technical Corrigendum 1:2006)*

ISO 10863, *Non-destructive testing of welds — Ultrasonic testing — Use of time-of-flight diffraction technique (TOFD)*¹⁾

3 Symbols, terms and definitions

3.1 Symbols

- h height of an indication (see Figures 1, 2 and 3)
- l length of an indication (see Figures 1, 2 and 3)
- t nominal wall thickness in accordance with construction drawing or dimension table (see Figures 1, 2 and 3)

3.2 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.2.1

embedded discontinuity

discontinuity within the volume of the material, separated from the surfaces

3.2.2

surface-breaking discontinuity

discontinuity connected to the near (contact) surface or far (reflecting) surface

1) To be published.