

**Terastorude mittepurustav katsetamine.
Osa 1: Ferromagnetilisest terasest
õmbluseta ja keevitatud (välja arvatud
vee all kaarkeevitatud) torude
automaatne elektromagnetiline
katsetamine lekkekindluse
kontrollimiseks vedeliku suhtes**

Non-destructive testing of steel tubes - Part 1:
Automatic eletromagnetic testing of seamless and
welded (except submerged arc welded)
ferromagnetic steel tubes for verification of hydraulic
leak-tightness

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN 10246-1:1999 sisaldab Euroopa standardi EN 10246-1:1996 ingliskeelset teksti. Käesolev dokument on jõustatud 23.11.1999 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes. Standard on kättesaadav Eesti standardiorganisatsioonist.	This Estonian standard EVS-EN 10246-1:1999 consists of the English text of the European standard EN 10246-1:1996. This document is endorsed on 23.11.1999 with the notification being published in the official publication of the Estonian national standardisation organisation. The standard is available from Estonian standardisation organisation.
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Käsitlusala: Standard määrab kindlaks nõuded ferromagnetilisest terasest õmbluseta ja keevitatud torude (välja arvatud vee all keevitatud) vedeliku suhtes lekkekindluse kontrollimiseks läbiviidava elektromagnetilise teimimise kohta.	Scope:
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ICS 23.040.10, 77.040.20

Võtmesõnad: elektromagnetilised teimid, keevitatud torud, kontrollimine, lekkekindlus, metalltorud, mittepurustavad teimid, terastorud, õmblusteta torud

Hinnagrupp J

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Descriptors: Steel, tubes, testing, non-destructive testing.

English version

Non-destructive testing of steel tubes

Part 1: Automatic electromagnetic testing of seamless and welded
(except submerged arc welded) ferromagnetic steel tubes
for verification of hydraulic leak-tightness

Essais non destructifs des tubes en acier.
Partie 1: Contrôle automatique électromagnétique pour vérification de l'étanchéité hydraulique des tubes en acier sans soudure et soudés ferromagnétiques (sauf à l'arc immergé sous flux en poudre)

Zerstörungsfreie Prüfung von Stahlrohren.
Teil 1: Automatische elektromagnetische Prüfung nahtloser und geschweißter (ausgenommen unterpulvergeschweißter) ferromagnetischer Stahlrohre zum Nachweis der Dichtheit

This European Standard was approved by CEN on 1995-12-28.

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 Central Secretariat 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 Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

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Foreword

This European Standard has been prepared by ECISS/TC 29 'Steel tubes and fittings for steel tubes', the Secretariat of which is held by UNI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, and conflicting national standards withdrawn, by September 1996 at the latest.

In accordance with the CEN/CENELEC Internal Regulations, the following countries are bound to implement this European Standard:

Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

1 Scope

This Part of EN 10 246 specifies the requirements for automatic electromagnetic testing of seamless and welded ferromagnetic steel tubes, with the exception of submerged arc - welded (SAW) tubes, for verification of hydraulic leak-tightness.

This Part of EN 10 246 is applicable to the inspection of tubes with an outside diameter greater than or equal to 4mm.

For automatic eddy current testing of seamless and welded austenitic and austenitic-ferritic steel tubes (excluding SAW tubes), for verification of hydraulic leak-tightness, EN 10 246-2 applies.

European Standard EN 10 246 "Non-destructive testing of steel tubes" comprises the Parts shown in Annex A.

2 Normative references

This Part of EN 10 246 incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of those publications apply to this Part of EN 10 246, only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 20286-2 ISO system of limits and fits - Part 2 : Tables of standard tolerance grades and limit deviations for holes and shafts.

ENV 10 220 Plain end steel tubes, welded and seamless - General tables of dimensions and masses per unit length

ISO 235 Parallel shank jobber and stub series drills and Morse taper shank drills

3 General requirements

3.1 The electromagnetic inspection covered by this Part of EN 10 246 is usually carried out on tubes after completion of all the primary production process operations.

This inspection shall be carried out by suitably, trained, qualified and competent NDT personnel approved by the manufacturer.

3.2 The tubes to be tested shall be sufficiently straight to ensure the validity of the test. The surfaces shall be sufficiently free from foreign matter which would interfere with the validity of the test.