

**Non-destructive testing of welds - Magnetic particle
testing of welds - Acceptance levels**

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EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN ISO 23278:2010 sisaldab Euroopa standardi EN ISO 23278:2009 ingliskeelset teksti.

Standard on kinnitatud Eesti Standardikeskuse 28.02.2010 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.

Euroopa standardimisorganisatsioonide poolt rahvuslikele liikmetele Euroopa standardi teksti kättesaadavaks tegemise kuupäev on 11.11.2009.

Standard on kättesaadav Eesti standardiorganisatsioonist.

This Estonian standard EVS-EN ISO 23278:2010 consists of the English text of the European standard EN ISO 23278:2009.

This standard is ratified with the order of Estonian Centre for Standardisation dated 28.02.2010 and is endorsed with the notification published in the official bulletin of the Estonian national standardisation organisation.

Date of Availability of the European standard text 11.11.2009.

The standard is available from Estonian standardisation organisation.

ICS 25.160.40

Standardite reprodutseerimis- ja levitamiseõigus kuulub Eesti Standardikeskusele

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English Version

**Non-destructive testing of welds - Magnetic particle testing of
welds - Acceptance levels (ISO 23278:2006)**

Contrôle non destructif des assemblages soudés - Contrôle
par magnétoscopie des soudures - Niveaux d'acceptation
(ISO 23278:2006)

Zerstörungsfreie Prüfung von Schweißverbindungen -
Magnetpulverprüfung von Schweißverbindungen -
Zulässigkeitsgrenzen (ISO 23278:2006)

This European Standard was approved by CEN on 24 October 2009.

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 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 Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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Foreword

The text of ISO 23278:2006 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 23278:2009 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 May 2010, and conflicting national standards shall be withdrawn at the latest by May 2010.

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 1291:1998.

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, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

Endorsement notice

The text of ISO 23278:2006 has been approved by CEN as a EN ISO 23278:2009 without any modification.

Non-destructive testing of welds — Magnetic particle testing of welds — Acceptance levels

1 Scope

This International Standard specifies acceptance levels for indications from imperfections in ferromagnetic steel welds detected by magnetic particle testing.

The acceptance levels are primarily intended for use during manufacture examination, but where appropriate they can be used for in-service inspection.

The acceptance levels in this International Standard are based on detection capabilities that can be expected when using techniques specified in ISO 17638 and parameters recommended in Annex A. The acceptance levels can be related to welding standards, application standards, specifications or codes. Such a relationship is shown in ISO 17635 for ISO 5817.

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

ISO 17638, *Non-destructive testing of welds — Magnetic particle testing*

ISO/TS 18173, *Non-destructive testing — General terms and definitions*

EN 1330-2, *Non-destructive testing — Terminology — Part 2: Terms common to the non-destructive testing methods*

EN 1330-7, *Non-destructive testing — Terminology — Part 7: Terms used in magnetic particle testing*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO/TS 18173, EN 1330-2 and EN 1330-7 and the following apply.

3.1

linear indication

indication having a length greater than three times its width

3.2

non-linear indication

indication having a length less than or equal to three times its width