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

*Contrôle non destructif des assemblages soudés — Contrôle par
magnétoscopie des soudures — Niveaux d'acceptation*



PDF disclaimer

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

This document is a preview generated by EVS

© ISO 2006

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Published in Switzerland

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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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

ISO 23278 was prepared by the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding* (as EN 1291:1998 and its Amd.1:2002 and Amd.2:2003), and was adopted, under a special "fast-track procedure", by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 5, *Testing and inspection of welds*, in parallel with its approval by the ISO member bodies.

This document constitutes a consolidated version.

Requests for official interpretations of any aspect of this International Standard 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 <http://www.iso.org>.

This document is a preview generated by EVS

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