

**Keevisõmbluste mittepurustav kontrollimine.  
Keevisõmbluste katsetamine kapillaarmeetodil  
(immutusvedelikega). Tehnilistele tingimustele  
vastavuse tasemed**

Non-destructive examination of welds - Penetrant testing of  
welds - Acceptance levels

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

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| <p>Käesolev Eesti standard EVS-EN ISO 23277:2010 sisaldab Euroopa standardi EN ISO 23277:2009 ingliskeelset teksti.</p> <p>Standard on kinnitatud Eesti Standardikeskuse 28.02.2010 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.</p> <p>Euroopa standardimisorganisatsioonide poolt rahvuslikele liikmetele Euroopa standardi teksti kättesaadavaks tegemise kuupäev on 11.11.2009.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p> | <p>This Estonian standard EVS-EN ISO 23277:2010 consists of the English text of the European standard EN ISO 23277:2009.</p> <p>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.</p> <p>Date of Availability of the European standard text 11.11.2009.</p> <p>The standard is available from Estonian standardisation organisation.</p> |
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English Version

## Non-destructive testing of welds - Penetrant testing of welds - Acceptance levels (ISO 23277:2006)

Contrôle non destructif des assemblages soudés - Contrôle  
par ressuage des soudures - Niveaux d'acceptation (ISO  
23277:2006)

Zerstörungsfreie Prüfung von Schweißverbindungen -  
Eindringprüfung von Schweißverbindungen -  
Zulässigkeitsgrenzen (ISO 23277:2006)

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## Foreword

The text of ISO 23277:2006 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 23277:2009 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of an identical text or by endorsement, at the latest by May 2010, and conflicting national standards shall be withdrawn at the latest by May 2010.

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### Endorsement notice

The text of ISO 23277:2006 has been approved by CEN as a EN ISO 23277:2009 without any modification.

# Non-destructive testing of welds — Penetrant testing of welds — Acceptance levels

## 1 Scope

This International Standard specifies acceptance levels for indications from surface breaking imperfections in metallic welds detected by penetrant 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 3452 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 and ISO 10042.

## 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 3452, *Non-destructive testing — Penetrant inspection — General principles*

ISO 3452-2, *Non-destructive testing — Penetrant testing — Part 2: Testing of penetrant materials*

ISO 5817, *Welding — Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) — Quality levels for imperfections*

ISO 10042, *Welding — Arc-welded joints in aluminium and its alloys — Quality levels for imperfections*

ISO 12706, *Non-destructive testing — Terminology — Terms used in penetrant testing*

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

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*

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO/TS 18173, EN 1330-2 and ISO 12706 and the following apply.

### 3.1

#### **linear indication**

indication having a length greater than three times its width