



BSI Standards Publication

# Non-destructive testing of steel forgings

Part 4: Ultrasonic testing of austenitic and austenitic-ferritic stainless steel forgings

**National foreword**

This British Standard is the UK implementation of EN 10228-4:2016. It supersedes BS EN 10228-4:1999 which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee ISE/111, Steel Castings and Forgings.

A list of organizations represented on this committee can be obtained on request to its secretary.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

© The British Standards Institution 2016.  
Published by BSI Standards Limited 2016

ISBN 978 0 580 80532 5

ICS 77.040.20; 77.140.85

**Compliance with a British Standard cannot confer immunity from legal obligations.**

This British Standard was published under the authority of the Standards Policy and Strategy Committee on 30 June 2016.

**Amendments/corrigenda issued since publication**

Date	Text affected
------	---------------

---

EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 10228-4**

June 2016

ICS 77.040.20; 77.140.85

Supersedes EN 10228-4:1999

English Version

**Non-destructive testing of steel forgings - Part 4:  
Ultrasonic testing of austenitic and austenitic-ferritic  
stainless steel forgings**

Essais non destructifs des pièces forgées en acier -  
Partie 4: Contrôle par ultrasons des pièces forgées en  
aciers inoxydables austénitiques et austéno-ferritiques

Zerstörungsfreie Prüfung von Schmiedestücken aus  
Stahl - Teil 4: Ultraschallprüfung von Schmiedestücken  
aus austenitischem und austenitisch-ferritischem  
nichtrostendem Stahl

This European Standard was approved by CEN on 3 October 2015.

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-CENELEC 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-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



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

**CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels**

<b>Contents</b>		<b>Page</b>
<b>European foreword.....</b>		<b>4</b>
<b>1</b>	<b>Scope .....</b>	<b>5</b>
<b>2</b>	<b>Normative references.....</b>	<b>5</b>
<b>3</b>	<b>Terms and definitions .....</b>	<b>5</b>
<b>4</b>	<b>Mandatory information .....</b>	<b>6</b>
<b>5</b>	<b>Test procedure .....</b>	<b>6</b>
<b>5.1</b>	<b>General.....</b>	<b>6</b>
<b>5.2</b>	<b>Form.....</b>	<b>6</b>
<b>5.3</b>	<b>Content.....</b>	<b>7</b>
<b>6</b>	<b>Personnel qualification.....</b>	<b>7</b>
<b>7</b>	<b>Equipment and accessories .....</b>	<b>7</b>
<b>7.1</b>	<b>Instrument.....</b>	<b>7</b>
<b>7.2</b>	<b>Probes.....</b>	<b>7</b>
<b>7.2.1</b>	<b>General.....</b>	<b>7</b>
<b>7.2.2</b>	<b>Contouring .....</b>	<b>8</b>
<b>7.2.3</b>	<b>Nominal frequency .....</b>	<b>8</b>
<b>7.2.4</b>	<b>Normal-beam probes .....</b>	<b>8</b>
<b>7.2.5</b>	<b>Angle-beam probes.....</b>	<b>8</b>
<b>7.2.6</b>	<b>Dual-element probes .....</b>	<b>8</b>
<b>7.3</b>	<b>Calibration blocks.....</b>	<b>8</b>
<b>7.4</b>	<b>Reference blocks .....</b>	<b>8</b>
<b>7.5</b>	<b>Couplant.....</b>	<b>8</b>
<b>8</b>	<b>Routine calibration and checking .....</b>	<b>9</b>
<b>9</b>	<b>Stage of manufacture .....</b>	<b>9</b>
<b>10</b>	<b>Surface condition .....</b>	<b>9</b>
<b>10.1</b>	<b>General.....</b>	<b>9</b>
<b>10.2</b>	<b>Surface finish related to quality class .....</b>	<b>9</b>
<b>10.3</b>	<b>As-forged surface condition .....</b>	<b>9</b>
<b>11</b>	<b>Test sensitivity .....</b>	<b>10</b>
<b>11.1</b>	<b>General.....</b>	<b>10</b>
<b>11.2</b>	<b>Normal-beam probes .....</b>	<b>10</b>
<b>11.3</b>	<b>Angle-beam probes.....</b>	<b>10</b>
<b>11.4</b>	<b>Repeat testing.....</b>	<b>10</b>
<b>12</b>	<b>Scanning .....</b>	<b>10</b>
<b>12.1</b>	<b>General.....</b>	<b>10</b>
<b>12.2</b>	<b>Complex forgings.....</b>	<b>11</b>
<b>12.3</b>	<b>Grid scanning coverage.....</b>	<b>11</b>
<b>12.4</b>	<b>100 % scanning coverage.....</b>	<b>11</b>
<b>12.5</b>	<b>Scanning speed.....</b>	<b>11</b>
<b>13</b>	<b>Classification.....</b>	<b>14</b>
<b>13.1</b>	<b>Classification of indications .....</b>	<b>14</b>
<b>13.2</b>	<b>Classification of discontinuities.....</b>	<b>16</b>

14	Recording levels and acceptance criteria .....	19
15	Sizing .....	20
16	Test report .....	21
Annex A (informative) Maximum testable depth for corresponding beam path range for circumferential angle-beam scans .....		22
Annex B (informative) Amplitude of indication in dB relative to % DAC.....		24
Annex C (informative) Significant technical changes to the version EN 10228-4:1999.....		25

## European foreword

This document (EN 10228-4:2016) has been prepared by Technical Committee ECISS/TC 111 “Steel castings and forgings”, the secretariat of which is held by AFNOR.

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 December 2016 and conflicting national standards shall be withdrawn at the latest by December 2016.

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 10228-4:1999.

Annex C provides the significant technical changes to the previous version EN 10228-4:1999.

EN 10228 consists of the following parts under the general title *Non-destructive testing of steel forgings*:

- *Part 1: Magnetic particle inspection;*
- *Part 2: Penetrant testing;*
- *Part 3: Ultrasonic testing of ferritic or martensitic steel forgings;*
- *Part 4: Ultrasonic testing of austenitic and austenitic-ferritic stainless steel forgings.*

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

## 1 Scope

This European Standard describes techniques for the manual, pulse-echo, ultrasonic testing of forgings manufactured from austenitic and austenitic-ferritic stainless steels. Mechanized scanning techniques, such as immersion testing, may be used but should be agreed between the purchaser and supplier (see Clause 4).

This part of EN 10228 applies to four types of forgings, classified according to their shape and method of production. Types 1, 2 and 3 are essentially simple shapes. Type 4 covers complex shapes.

This part of EN 10228 does not apply to:

- closed die forgings;
- turbine rotor and generator forgings.

Ultrasonic testing of ferritic and martensitic steel forgings is the subject of Part 3 of this European Standard.

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 1330-1, *Non destructive testing - Terminology - Part 1: List of general terms*

EN 1330-4, *Non-destructive testing - Terminology - Part 4: Terms used in ultrasonic testing*

EN 12668-1, *Non-destructive testing - Characterization and verification of ultrasonic examination equipment - Part 1: Instruments*

EN 12668-2, *Non-destructive testing - Characterization and verification of ultrasonic examination equipment - Part 2: Probes*

EN 12668-3, *Non-destructive testing - Characterization and verification of ultrasonic examination equipment - Part 3: Combined equipment*

EN ISO 2400, *Non-destructive testing - Ultrasonic testing - Specification for calibration block No. 1 (ISO 2400)*

EN ISO 9712, *Non-destructive testing - Qualification and certification of NDT personnel (ISO 9712)*

EN ISO 16811, *Non-destructive testing - Ultrasonic testing - Sensitivity and range setting (ISO 16811)*

EN ISO 16827, *Non-destructive testing - Ultrasonic testing - Characterization and sizing of discontinuities (ISO 16827)*

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 1330-1 and EN 1330-4 apply.

## 4 Mandatory information

The following aspects concerning ultrasonic testing shall be agreed between the purchaser and supplier at the time of the enquiry or order:

- a) the manufacturing stage(s) at which ultrasonic testing shall be performed (see Clause 9);
- b) the volume(s) to be tested and whether grid scanning coverage or 100 % scanning coverage is required (see Clause 12);
- c) whether near surface testing is required (see 7.2.6);
- d) the quality class required, or the quality classes and the zones to which they apply (see Clause 14);
- e) the applicable recording/acceptance criteria if different from those detailed in Table 5, Table 6 or Table 7;
- f) whether any special scanning coverage, equipment or couplant is required in addition to that detailed in Clauses 7 and 12;
- g) the scanning technique to be used if not manual (see Clause 1);
- h) the sizing techniques to be used for extended discontinuities (see Clause 15);
- i) the technique(s) to be used for setting sensitivity (see Clause 11);
- j) whether the test shall be conducted in the presence of the purchaser or his representative;
- k) whether a written procedure shall be submitted for approval by the purchaser (see Clause 5);
- l) whether testing by angle-beam probes is required (see 11.3);
- m) the remaining test requirements for complex forgings (type 4) (see 12.2).

## 5 Test procedure

### 5.1 General

Ultrasonic testing shall be performed in accordance with a written test procedure. Where specified in the enquiry or order, the written test procedure shall be submitted to the purchaser for approval prior to the test.

### 5.2 Form

The written test procedure shall be one of the following:

- a) a product specification;
- b) a test procedure written specifically for the application;
- c) this part of EN 10228 may be used if it is accompanied by examination details specific to the application.

### 5.3 Content

The written test procedure shall contain the following details as minimum requirements:

- a) description of the forgings to be tested;
- b) reference documents;
- c) qualification of testing operator;
- d) stage of manufacture at which the test is carried out;
- e) testing zones specified in terms of the applicable quality classes;
- f) preparation of scanning surfaces;
- g) couplant;
- h) description of the test equipment;
- i) calibration and checking of the test equipment;
- j) scanning plan;
- k) description and sequence of testing operations;
- l) recording levels;
- m) characterization of discontinuities;
- n) acceptance criteria;
- o) test report.

## 6 Personnel qualification

Personnel shall be qualified in accordance with the requirements detailed in EN ISO 9712.

## 7 Equipment and accessories

### 7.1 Instrument

The ultrasonic instrument shall feature A-scan presentation and shall conform to EN 12668-1.

### 7.2 Probes

#### 7.2.1 General

Probes used for the initial detection of discontinuities shall conform to EN 12668-2. Where supplementary probes are used for purposes other than the initial detection of discontinuities, they need not conform to EN 12668-2.

### 7.2.2 Contouring

When required, probes shall be contoured in accordance with EN ISO 16811.

### 7.2.3 Nominal frequency

Probes shall have a nominal frequency in the range from 0,5 MHz to 6 MHz.

### 7.2.4 Normal-beam probes

Effective transducer diameter shall be in the range from 10 mm to 40 mm.

### 7.2.5 Angle-beam probes

For the transverse waves, the angle-beam probes shall be in the range from 35° to 70°.

Effective transducer area shall be in the range from 20 mm<sup>2</sup> to 625 mm<sup>2</sup>.

### 7.2.6 Dual-element probes

If near-surface testing is required, then dual-element probes shall be used.

## 7.3 Calibration blocks

Calibration blocks shall conform to the requirements detailed in EN ISO 2400.

## 7.4 Reference blocks

Reference blocks shall be used when sensitivity shall be established by the distance-amplitude curve (DAC) technique and/or when discontinuities shall be sized in terms of amplitude relative to reference reflectors by the DAC technique. The surface condition of the reference block shall be representative of the surface condition of the object to be tested. Unless otherwise specified the reference block shall contain at least three reflectors covering the entire depth range being tested.

The reference block shall be manufactured from one of the following:

- a) an excess length of the object to be tested;
- b) a part of the same material and with the same heat treatment condition as the object to be tested;
- c) a part having similar acoustic properties to the object to be tested.

The choice of a test block with similar acoustic properties should be to the appreciation of a Level 2 qualified person.

Reference blocks shall not be used for the distance-gain-size (DGS) technique other than for checking the accuracy of a particular DGS diagram.

Reflector sizes different from those detailed in Tables 5 and 6 may be used as long as the test sensitivity is corrected accordingly.

## 7.5 Couplant

The same type of couplant shall be used for the setting of range and sensitivity, for scanning and for the assessment of discontinuities.

NOTE Examples of suitable couplants are: water (with or without corrosion inhibitor or softener), grease, oil, glycerol and water cellulose paste.

After the test, couplant shall be removed if its presence could adversely affect later manufacturing or testing operations or the integrity of the test object.

8 Routine calibration and checking

The combined equipment (instrument and probes) shall be calibrated and checked in accordance with the requirements detailed in EN 12668-3.

9 Stage of manufacture

Ultrasonic testing shall be performed after the final heat treatment unless otherwise agreed at the time of enquiry or order (see Clause 4), e.g. at the latest possible stage of manufacture for areas of the forging which are not practicable to test after the final heat treatment.

For both cylindrical and rectangular forgings, which shall be bored, it is recommended to carry out ultrasonic testing before boring.

10 Surface condition

10.1 General

Surfaces to be scanned shall be free from paint, non-adhering scale, dry couplant, surface irregularities or any other substance which could reduce coupling efficiency, hinder the free movement of the probe or cause errors in interpretation.

10.2 Surface finish related to quality class

In the machined condition, for testing to quality classes 1 and 2, a surface finish corresponding to a roughness  $R_a \leq 12,5 \mu\text{m}$  shall be produced and for testing of quality class 3, a surface finish corresponding to a roughness  $R_a \leq 6,3 \mu\text{m}$  shall be produced.

Table 1 — Surface finish related to quality class<sup>a</sup>

Surface finish	Quality class and roughness $R_a$		
	1	2	3
	$\leq 12,5 \mu\text{m}$		$\leq 6,3 \mu\text{m}$
Machined	X		X
<sup>a</sup> "X" signifies the quality class that can be achieved in machined conditions.			

10.3 As-forged surface condition

Where forgings are supplied in the as-forged surface condition they shall be considered acceptable providing the specified quality class can be achieved. When it is not practical to perform a comprehensive test on as-forged surfaces, shot blasting, sand blasting or surface grinding shall be used to ensure that acoustic coupling can be maintained.

NOTE Only quality class 1 is normally applicable.

## 11 Test sensitivity

### 11.1 General

Test sensitivity shall be sufficient to ensure the detection of the smallest discontinuities required by the recording levels (see Table 5 and when required, Tables 6 or 7). If the required sensitivity cannot be achieved due to coarse grain size, acceptance of the forging shall be subject to agreement between the purchaser and supplier.

### 11.2 Normal-beam probes

For normal-beam probes, one of the following techniques shall be used to establish the sensitivity for scanning:

- a) Distance-amplitude curve (DAC) technique, based upon the use of side-drilled holes (flat-bottomed holes possible);
- b) Distance-gain-size (DGS) technique (disc-shaped reflectors).

The procedure to be used in each case shall be in accordance with EN ISO 16811.

### 11.3 Angle-beam probes

For angle-beam probes one of the following techniques shall be used to establish the sensitivity for scanning:

- a) DAC technique using 3 mm diameter side-drilled holes;
- b) DGS technique (disc-shaped reflectors).

The procedure to be used in each case shall be as detailed in EN ISO 16811.

The DAC and DGS techniques shall not be compared for angle-beam probes.

### 11.4 Repeat testing

Where repeat testing is performed the same method of establishing sensitivity (DAC or DGS) shall be used as was initially used.

## 12 Scanning

### 12.1 General

Scanning shall be performed using the manual contact pulse-echo technique.

The minimum scanning coverage required is dictated by the type of forging and whether grid scanning coverage or 100 % scanning coverage has been specified in the enquiry or order (see Clause 4).

Table 2 classifies four types of forging according to their shapes and method of production.

Table 3 specifies the requirements for normal-beam probes for forging types 1, 2 and 3.

Table 4 specifies the requirements for angle-beam probes for forging types 3a, 3b and 3c which have an outside diameter to inside diameter ratio less than 1,6:1. The effective depth of circumferentially oriented angle-beam scans is limited by the beam angle and the forging diameter (see Annex A).

## **12.2 Complex forgings**

For complex shaped forgings or complex shaped parts of forgings (type 4) and small diameter forgings, test requirements shall include, as a minimum, the required beam angles, scanning directions and extent of scanning coverage (grid or 100 %). The remaining test requirements shall be agreed between purchaser and supplier (see Clause 4, m)).

## **12.3 Grid scanning coverage**

Grid scanning shall be performed with the probe or probes traversed along the grid lines defined in Tables 3 and 4.

Where recordable indications are revealed by grid scanning, additional scanning shall be performed to determine the extent of the indications.

## **12.4 100 % scanning coverage**

100 % scanning coverage shall be performed over the surfaces specified in Tables 3 and 4. Consecutive probe traverses shall overlap by at least 10 % of the effective beam diameter.

## **12.5 Scanning speed**

Manual scanning speed shall not exceed 150 mm/s.

Table 2 — Classification of forgings according to their shape and method of production

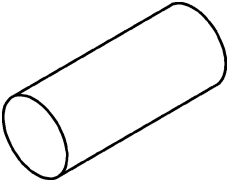
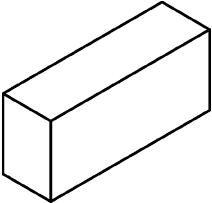
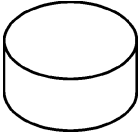
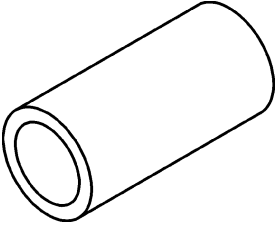
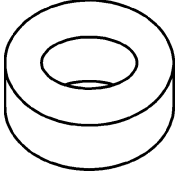
Type	Shape	Method of production
1a <sup>a</sup>	Elongated with round or approximately round section, e.g. bars, rods, cylinders, shafts, journals, discs cut from bars 	Direct forged
1b <sup>a</sup>	Elongated with rectangular or approximately rectangular section, e.g. bars, rods, blocks, sections cut from bars 	
2 <sup>b</sup>	Flattened, e.g. discs, plate, flywheels 	Upset
3a	Hollow cylindrical shapes, e.g. bottles, compressed gas tanks 	Mandrel forged
3b	Hollow cylindrical shapes, e.g. rings, flanges, rims 	Expanded
3c		Ring rolling
4	All forgings or parts of forgings with complex shape	At the manufacturer's discretion
<sup>a</sup> Type 1 forgings may incorporate bores of small diameter relative to the major dimensions. <sup>b</sup> Type 2 forgings may eventually be drilled (e.g. binding discs).		

Table 3 — Scanning coverage with normal-beam probes

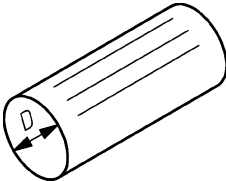
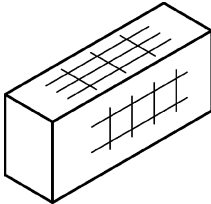
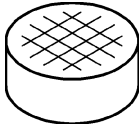
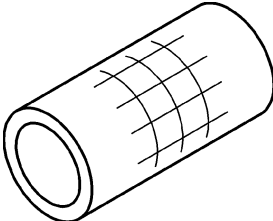
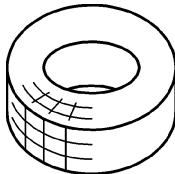
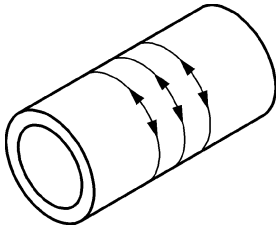
Type		Grid scanning <sup>a</sup>		100 % Scanning <sup>a, b</sup>
1	1a	 Diameter, $D$ , (mm) $D \leq 200$ $200 < D \leq 500$ $500 < D \leq 1\,000$ $1\,000 < D$	Scan lines <sup>c</sup> 2 at 90° 3 at 60° 4 at 45° 6 at 30°	Scan 100 % around at least 180° of cylindrical surface
	1b	 Scan along the lines of a square-link grid on two perpendicular surfaces <sup>c, d</sup>		
2		Scan along the lines of a square-link grid around 360° on the cylindrical surface and one lateral surface <sup>d</sup>		Scan 100 % around at least 180° on the cylindrical surface and 100 % of one lateral surface
3	3a	 Scan along the lines of a square-link grid around 360° on the outer cylindrical surface <sup>d</sup>		Scan 100 % around 360° on the outer cylindrical surface
	3b and 3c	 Scan along the lines of a square-link grid around 360° on the outer cylindrical surface and one lateral surface <sup>d</sup>		Scan 100 % around 360° on the outer cylindrical surface and one lateral surface
4	Scanning coverage shall be specified in the enquiry or order			
<sup>a</sup> Additional scanning (for example in both axial directions for type 3a) may be carried out if specified in the enquiry or order. <sup>b</sup> 100 % means at least 10 % beam overlap between consecutive probe traverses. <sup>c</sup> For types 1a or 1b, if the presence of a bore prevents the opposite surface being reached, the number of scan lines shall be doubled symmetrically. <sup>d</sup> The grid line separation shall be equal to the part thickness, up to a maximum of 200 mm.				

Table 4 — Scanning coverage with angle-beam probes

Type		Grid scanning <sup>a</sup>	100 % scanning <sup>a, b</sup>
3 <sup>c</sup>	3a	 Scan in both directions along 360° circumferential grid lines, the separation of which is equal to the radial thickness up to a maximum of 200 mm	Scan in both circumferential directions over 100 % on the outer cylindrical surface
	3b		
4	Scanning coverage shall be specified in the enquiry or order		
<sup>a</sup> Additional scanning coverage may be carried out if specified in the enquiry or order.			
<sup>b</sup> 100 % means at least 10 % beam overlap between consecutive probe traverses.			
<sup>c</sup> For forgings type 3c this test procedure is normally not used, but it may be agreed at time of enquiry.			

13 Classification

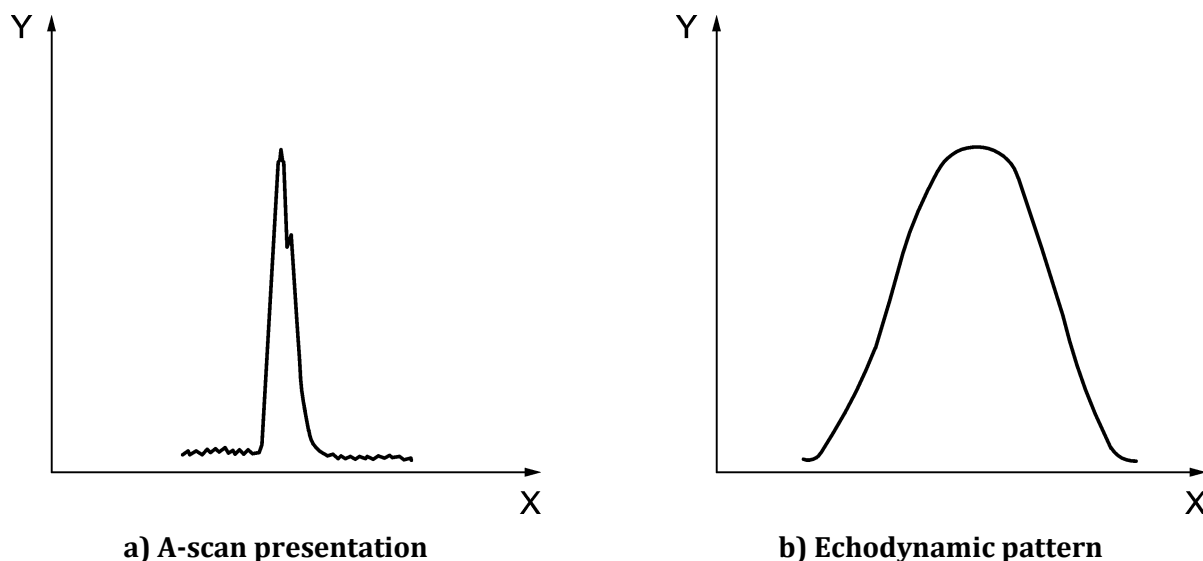
13.1 Classification of indications

Where practicable, classification of indications according to their echodynamic pattern shall be made by scanning from a minimum of two mutually perpendicular directions.

a) Pattern 1:

As the probe is moved, the A-scan display shows a single sharp indication rising smoothly in amplitude to a maximum and then falling smoothly to zero (see Figure 1a)).

This A-scan display in combination with the echodynamic pattern in Figure 1b) obtained from the side-drilled holes used to plot the beam profile, corresponds to discontinuity dimensions smaller than or equal to the -6 dB beam profile.



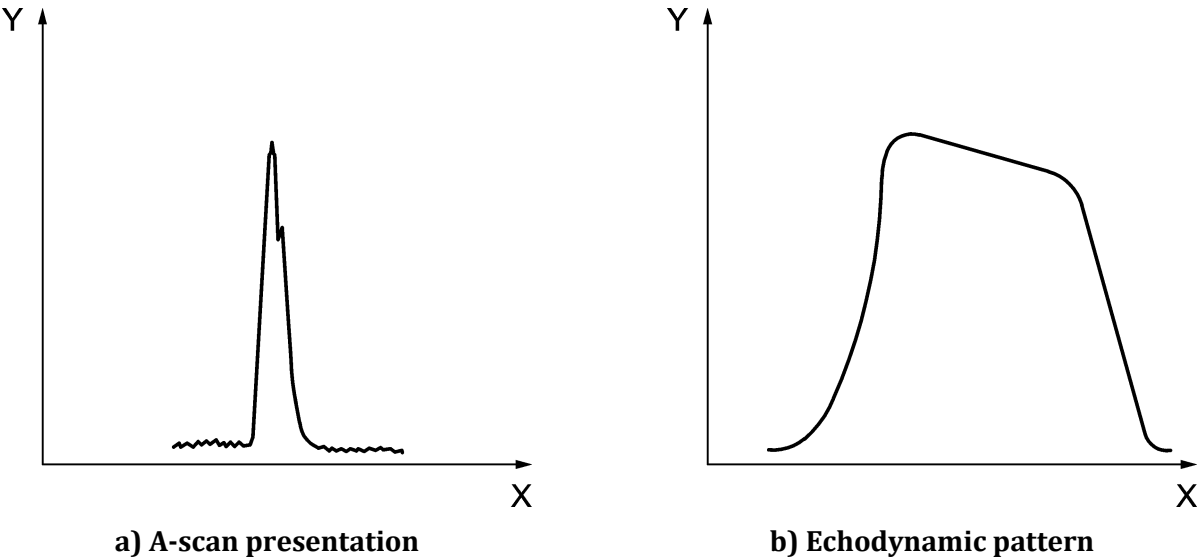
**Key**

- a) X pattern of A-Scan at fixed probe position (at typical probe position)
- b) X pattern of curve amplitude against probe shift (variation in signal amplitude as probe is moved)
- Y amplitude

**Figure 1 — Pattern 1 - A-scan presentation and echo envelope presentation**

b) Pattern 2:

As the probe is moved, the A-scan display shows a single sharp indication rising smoothly in amplitude to a maximum and then falling smoothly to zero (see Figure 2 a)). This A-scan display in combination with the echodynamic pattern in Figure 2 b) obtained from the side-drilled holes used to plot the beam profile, corresponds to discontinuity dimensions greater than the to -6 dB beam profile.



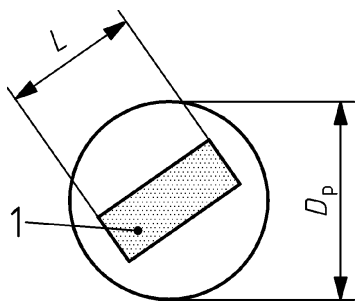
- Key**
- a) X pattern of A-Scan at fixed probe position (at typical probe position)
  - b) X pattern of curve amplitude against probe shift (variation in signal amplitude as probe is moved)
  - Y amplitude

**Figure 2 — Pattern 2 - A-scan presentation and echo envelope presentation**

**13.2 Classification of discontinuities**

Discontinuities shall be classified according to their echodynamic patterns as follows:

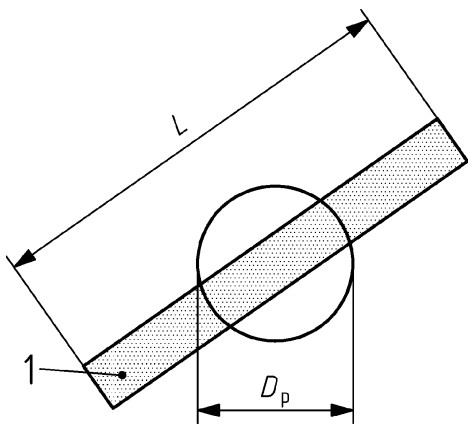
- a) Point-like discontinuity:  
  
Echodynamic pattern 1 and/or dimension equal to or less than the -6 dB beam width (see Figure 3).
- b) Extended discontinuity:  
  
Echodynamic pattern 2 and/or dimension greater than the -6 dB width (see Figure 4).
- c) Isolated discontinuities:  
  
The distance *d*, between points corresponding to the maxima of the indications of adjacent discontinuities exceeds 40 mm (see Figure 5).
- d) Grouped discontinuities:  
  
The distance *d*, between points corresponding to the maxima of the indications of adjacent discontinuities is less than or equal to 40 mm (see Figure 6).



**Key**

- 1** Conventional outline of -6 dB discontinuity
- $D_p$  Width of beam at depth of discontinuity
- $L$  Conventional length of -6 dB discontinuity

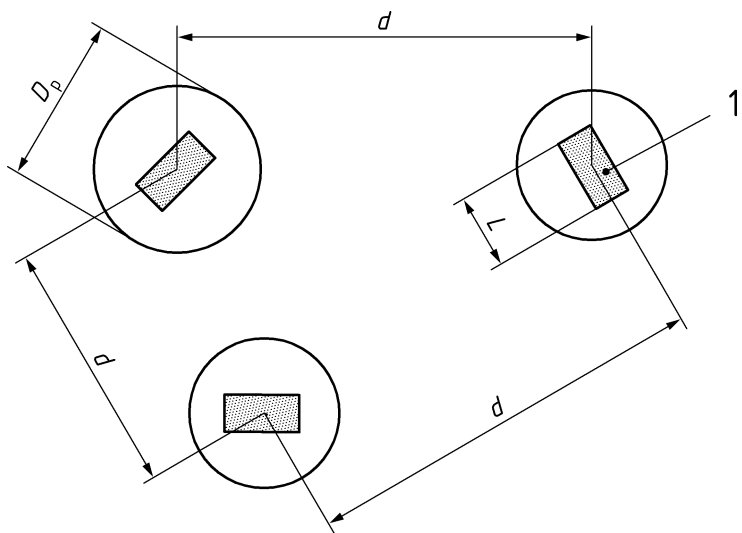
**Figure 3 — Point-like discontinuity  
( $L \leq D_p$ )**



**Key**

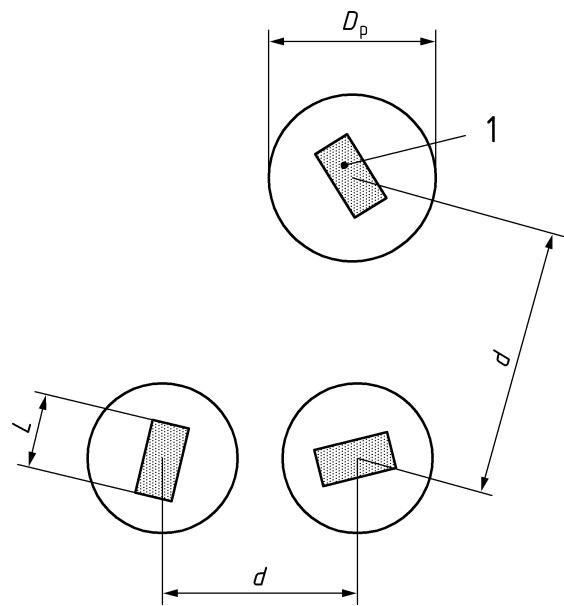
- 1** Conventional outline of -6 dB discontinuity
- $D_p$  Width of beam at depth of discontinuity
- $L$  Conventional length of -6 dB discontinuity

**Figure 4 — Extended discontinuity  
( $L > D_p$ )**



- Key**
- 1 Conventional outline of -6 dB discontinuity
  - $D_p$  Width of beam at depth of discontinuity
  - $d$  Distance between two discontinuities
  - $L$  Conventional length of -6 dB discontinuity

**Figure 5 — Isolated discontinuities**  
**( $L \leq D_p, d > 40 \text{ mm}$ )**



- Key**
- 1 Conventional outline of -6 dB discontinuity
  - $D_p$  Width of beam at depth of discontinuity
  - $d$  Distance between two discontinuities
  - $L$  Conventional length of -6 dB discontinuity

**Figure 6 — Grouped discontinuities**  
**( $L \leq D_p, d \leq 40 \text{ mm}$ )**

14 Recording levels and acceptance criteria

Several quality classes may be applied to a forging or to parts of a forging. The applicable quality class(es) shall be agreed between the purchaser and supplier. Table 5 details recording levels and acceptance criteria which shall be applied to three quality classes for normal-beam probes. Tables 6 and 7 detail recording levels and acceptance criteria which shall be applied for angle-beam probes.

Table 5 — Quality classes, recording levels and acceptance criteria for normal-beam probes<sup>a</sup>

Forging thickness $t$ mm	Recording level $d_{eq}^b$ mm	Acceptance criteria for	
		Isolated discontinuities $d_{eq}^b$ mm	Extended or grouped discontinuities $d_{eq}^b$ mm
Quality class 1			
$t \leq 75$	$> 5$	$\leq 8$	$\leq 5$
$75 < t \leq 250$	$> 8$	$\leq 11$	$\leq 8$
$250 < t \leq 400$	$> 14$	$\leq 19$	$\leq 14$
$t > 400$	Indication with a 80 % reduction of backwall echo	Indication with a total loss of backwall echo. A total loss of backwall echo shall be considered when its amplitude becomes less than 5 % of its initial value measured near the indication or less than or equal to grass	
Quality class 2			
$t \leq 75$	$> 3$	$\leq 5$	$\leq 3$
$75 < t \leq 250$	$> 5$	$\leq 8$	$\leq 5$
$250 < t \leq 400$	$> 8$	$\leq 11$	$\leq 8$
$400 < t \leq 600$	$> 11$	$\leq 15$	$\leq 11$
$t > 600$	Indication with a 80 % reduction of backwall echo	Indication with a total loss of backwall echo. A total loss of backwall echo shall be considered when its amplitude becomes less than 5 % of its initial value measured near the indication or less than or equal to grass	
Quality class 3			
$t < 75$	$> 2$	$\leq 3$	$\leq 2$
$75 < t \leq 250$	$> 3$	$\leq 5$	$\leq 3$
$250 < t \leq 400$	$> 5$	$\leq 8$	$\leq 5$
$400 < t \leq 600$	$> 8$	$\leq 11$	$\leq 8$
$t > 600$	Indication with a 80 % reduction of backwall echo	Indication with a total loss of backwall echo. A total loss of backwall echo shall be considered when its amplitude becomes less than 5 % of its initial value measured near the indication or less than or equal to grass	
<sup>a</sup> Reflector diameter shall not be interpreted as representing the dimension of the discontinuity which caused the echo.			
<sup>b</sup> $d_{eq}$ = Equivalent diameter of flat-bottomed hole.			

Table 6 — Recording levels and acceptance criteria for angle-beam probes for DGS technique<sup>a</sup>

Forging thickness <i>t</i> mm	Recording level <i>d</i> <sub>eq</sub> <sup>a</sup> mm	Acceptance criteria for	
		Isolated discontinuities <i>d</i> <sub>eq</sub> mm	Extended or grouped discontinuities <i>d</i> <sub>eq</sub> mm
<i>t</i> ≤ 75	> 3	≤ 5	≤ 3
75 < <i>t</i> ≤ 250	> 5	≤ 8	≤ 5
250 < <i>t</i> ≤ 400 <sup>b</sup>	> 8	≤ 11	≤ 8
<sup>a</sup> <i>d</i> <sub>eq</sub> = Equivalent diameter of flat bottomed hole.			
<sup>b</sup> For thicknesses > 400 mm testing shall be as agreed between purchaser and supplier.			

Table 7 — Recording levels and acceptance criteria for angle-beam probes for DAC technique<sup>a, b, c</sup>

Forging thickness <i>t</i> mm	Nominal test frequency MHz	Recording level %	Acceptance criteria for	
			Isolated discontinuities %	Extended or grouped discontinuities %
<i>t</i> ≤ 75	1	30	60	30
	2	50	100	50
75 < <i>t</i> ≤ 250	1	50	100	50
	2	100	200	100
250 < <i>t</i> ≤ 400	1	100	200	100
	2	200	400	200
<sup>a</sup> Based on 3 mm diameter side-drilled holes.				
<sup>b</sup> A DAC based on 3 mm diameter side drilled holes shall be constructed for each frequency of probe used.				
<sup>c</sup> The indication amplitude in dB, relative to the DAC, is given in Annex B.				

15 Sizing

Where the extent of a discontinuity is required to be evaluated, one or more of the following techniques, as agreed between the purchaser and the supplier, shall be used. These techniques shall be carried out in accordance with the requirements detailed in EN ISO 16827:

- a) 6 dB-drop technique;
- b) 20 dB-drop technique;
- c) maximum amplitude technique.

## 16 Test report

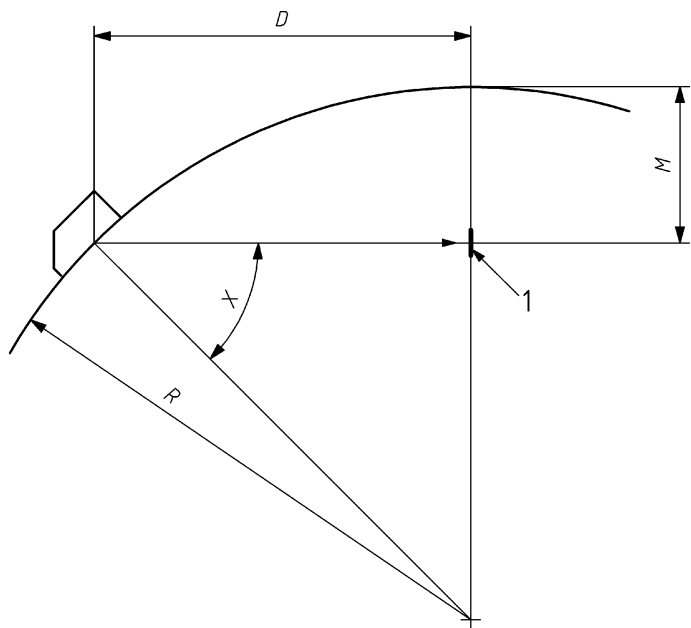
All tests shall be the subject of a written report which shall include the following information as minimum requirements:

- a) name of supplier;
- b) order number;
- c) identification of forging(s) to be tested;
- d) scope of the test: surface areas and applicable quality classes;
- e) stage of manufacture at which ultrasonic test was performed;
- f) surface condition;
- g) equipment used (instrument, probes, calibration and reference blocks);
- h) technique(s) used to set test sensitivity;
- i) reference to this standard and, if applicable, reference to the written procedure used;
- j) test results: location, classification and amplitude (in terms of FBH-equivalent diameter, or in percent of SDH) of all discontinuities exceeding the appropriate recording level;
- k) details of any restrictions to the required scanning coverage and if applicable the extent of the (untested) near surface zone;
- l) date of the test;
- m) name, qualification, certification (if specified) and signature of the operator.

**Annex A**  
(informative)

**Maximum testable depth for corresponding beam path range for  
circumferential angle-beam scans**

Figure A.1 and Table A.1 show the maximum testable depth  $M$  for circumferential angle-beam scans for a given probe and beam path range  $D$ .



- Key**
- 1 reflector
  - $D$  is the beam path range for normal incidence on a radial reflector
  - $M$  is the maximum testable depth for a particular probe angle and outside radius  $R$
  - $R$  outside radius
  - $X$  beam angle
- Regarding  $X$ ,  $M$  and  $D$ , see Table A.1 underneath.

**Figure A.1 — Maximum testable depth and corresponding beam path range for circumferential  
angle-beam scans**

**Table A.1 — Maximum testable depth and corresponding beam path range**

Beam angle, $X$	Maximum testable depth, $M$	Beam path range, $D$
70°	0,06 $R$	0,34 $R$
60°	0,13 $R$	0,50 $R$
50°	0,24 $R$	0,64 $R$
45°	0,30 $R$	0,70 $R$
35°	0,42 $R$	0,82 $R$
NOTE    The maximum testable depth and beam path range to this depth for radial reflectors are given in terms of the outside radius $R$ of the forging.		

**Annex B**  
(informative)

**Amplitude of indication in dB relative to % DAC**

As an alternative to constructing a DAC which is a percentage of the 3 mm diameter side-drilled hole DAC (100 % DAC), the required recording /acceptance level may be achieved by constructing the 3 mm DAC (100 % DAC) and adjusting the amplitude according to Table B.1.

**Table B.1 — Amplitude of indication in dB relative to % DAC**

DAC %	Amplitude of indication relative to DAC dB
25	−12
30	−10
50	−6
60	−4
100	0
200	+6
400	+12

## **Annex C** (informative)

### **Significant technical changes to the version EN 10228-4:1999**

Some significant technical changes to the previous version EN 10228-4:1999 are listed below:

- a) Scope has been aligned with EN 10228-3;
- b) updating of the normative references;
- c) generally updating and alignment of the designations to the actual state of art;
- d) new Table 1 concerning surface finish related to quality class;
- e) statement in chapter 9 concerning stage of manufacture aligned with EN 10228-3;
- f) method of production for the types 3b and 3c in Table 2 updated;
- g) supplementary footnote c) in Table 4 concerning scanning coverage with angle-beam probes for products of type 3c);
- h) correlation between terms and Figures 1 and 2 have been updated in Clause 13;
- i) Note in Table A.1 updated.



***This page deliberately left blank***

# British Standards Institution (BSI)

BSI is the national body responsible for preparing British Standards and other standards-related publications, information and services.

BSI is incorporated by Royal Charter. British Standards and other standardization products are published by BSI Standards Limited.

## About us

We bring together business, industry, government, consumers, innovators and others to shape their combined experience and expertise into standards-based solutions.

The knowledge embodied in our standards has been carefully assembled in a dependable format and refined through our open consultation process. Organizations of all sizes and across all sectors choose standards to help them achieve their goals.

## Information on standards

We can provide you with the knowledge that your organization needs to succeed. Find out more about British Standards by visiting our website at [bsigroup.com/standards](https://bsigroup.com/standards) or contacting our Customer Services team or Knowledge Centre.

## Buying standards

You can buy and download PDF versions of BSI publications, including British and adopted European and international standards, through our website at [bsigroup.com/shop](https://bsigroup.com/shop), where hard copies can also be purchased.

If you need international and foreign standards from other Standards Development Organizations, hard copies can be ordered from our Customer Services team.

## Copyright in BSI publications

All the content in BSI publications, including British Standards, is the property of and copyrighted by BSI or some person or entity that owns copyright in the information used (such as the international standardization bodies) and has formally licensed such information to BSI for commercial publication and use.

Save for the provisions below, you may not transfer, share or disseminate any portion of the standard to any other person. You may not adapt, distribute, commercially exploit, or publicly display the standard or any portion thereof in any manner whatsoever without BSI's prior written consent.

## Storing and using standards

Standards purchased in soft copy format:

- A British Standard purchased in soft copy format is licensed to a sole named user for personal or internal company use only.
- The standard may be stored on more than 1 device provided that it is accessible by the sole named user only and that only 1 copy is accessed at any one time.
- A single paper copy may be printed for personal or internal company use only.

Standards purchased in hard copy format:

- A British Standard purchased in hard copy format is for personal or internal company use only.
- It may not be further reproduced – in any format – to create an additional copy. This includes scanning of the document.

If you need more than 1 copy of the document, or if you wish to share the document on an internal network, you can save money by choosing a subscription product (see 'Subscriptions').

## Reproducing extracts

For permission to reproduce content from BSI publications contact the BSI Copyright & Licensing team.

## Subscriptions

Our range of subscription services are designed to make using standards easier for you. For further information on our subscription products go to [bsigroup.com/subscriptions](https://bsigroup.com/subscriptions).

With **British Standards Online (BSOL)** you'll have instant access to over 55,000 British and adopted European and international standards from your desktop. It's available 24/7 and is refreshed daily so you'll always be up to date.

You can keep in touch with standards developments and receive substantial discounts on the purchase price of standards, both in single copy and subscription format, by becoming a **BSI Subscribing Member**.

**PLUS** is an updating service exclusive to BSI Subscribing Members. You will automatically receive the latest hard copy of your standards when they're revised or replaced.

To find out more about becoming a BSI Subscribing Member and the benefits of membership, please visit [bsigroup.com/shop](https://bsigroup.com/shop).

With a **Multi-User Network Licence (MUNL)** you are able to host standards publications on your intranet. Licences can cover as few or as many users as you wish. With updates supplied as soon as they're available, you can be sure your documentation is current. For further information, email [subscriptions@bsigroup.com](mailto:subscriptions@bsigroup.com).

## Revisions

Our British Standards and other publications are updated by amendment or revision.

We continually improve the quality of our products and services to benefit your business. If you find an inaccuracy or ambiguity within a British Standard or other BSI publication please inform the Knowledge Centre.

## Useful Contacts

### Customer Services

**Tel:** +44 345 086 9001

**Email (orders):** [orders@bsigroup.com](mailto:orders@bsigroup.com)

**Email (enquiries):** [cservices@bsigroup.com](mailto:cservices@bsigroup.com)

### Subscriptions

**Tel:** +44 345 086 9001

**Email:** [subscriptions@bsigroup.com](mailto:subscriptions@bsigroup.com)

### Knowledge Centre

**Tel:** +44 20 8996 7004

**Email:** [knowledgecentre@bsigroup.com](mailto:knowledgecentre@bsigroup.com)

### Copyright & Licensing

**Tel:** +44 20 8996 7070

**Email:** [copyright@bsigroup.com](mailto:copyright@bsigroup.com)

### BSI Group Headquarters

389 Chiswick High Road London W4 4AL UK

