



Standard Practice for Ultrasonic Examination of Steel Forgings¹



This standard is issued under the fixed designation A388/A388M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last approval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or approval.

1. Scope²

1.1 This practice³ covers the examination procedures for the contact, pulse-echo ultrasonic examination of steel forgings by the straight and angle-beam techniques. The straight beam techniques include utilization of the DGS (Distance Gain-Size) method. See Appendixes A-D.

1.2 This practice is to be used whenever the inquiry, contract, order, or specification states that forgings are to be subject to ultrasonic examination in accordance with Practice A388/A388M.

1.3 Supplementary requirements of an optional nature are provided for use at the option of the purchaser. The supplementary requirements shall apply only when specified individually by the purchaser in the purchase order or contract.

1.4 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.5 This specification and the applicable material specifications are expressed in both inch-pound units and SI units. However, unless the order specifies the applicable "M" specification designation [SI units], the material shall be furnished to inch-pound units.

1.6 This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. Referenced Documents

2.1 ASTM Standards:⁴

- A388/A388M Specification for Vacuum-Treated Steel Forgings for Generator Rotors
- A745/A745M Practice for Ultrasonic Examination of Austenitic Steel Forgings
- E117 Practice for Evaluating Performance Characteristics of Ultrasonic Pulse-Echo Testing Instruments and Systems without the Use of Electronic Measurement Instruments
- E428 Practice for Fabrication and Control of Metal, Other than Aluminum, Reference Blocks Used in Ultrasonic Testing
- E1065 Guide for Evaluating Characteristics of Ultrasonic Search Units

2.2 Other Document:

- Recommended Practice for Nondestructive Personnel Qualification and Certification SNT-TC-1A, (1988 or later)⁵

3. Terminology

3.1 Definitions:

3.1.1 *indication levels (clusters), n*—five or more indications in a volume representing a 2-in. [50-mm] or smaller cube in the forging.

3.1.2 *individual indications, n*—single indications showing a decrease in amplitude as the search unit is moved in any direction from the position of maximum amplitude and which are too small to be considered traveling or planar.

3.1.3 *planar indications, n*—indications shall be considered continuous over a plane if they have a major axis greater than 1 in. [25 mm] or twice the major dimension of the transducer, whichever is greater, and do not travel.

3.1.4 *traveling indications, n*—indications whose leading edge moves a distance equivalent to 1 in. [25 mm] or more of metal depth with movement of the transducer over the surface of the forging.

4. Significance and Use

4.1 This practice shall be used when ultrasonic inspection is required by the order or specification for inspection purposes where the acceptance of the forging is based on limitations of the number, amplitude, or location of discontinuities, or a combination thereof, which give rise to ultrasonic indications.

4.2 The ultrasonic quality level shall be clearly stated as order requirements.

⁵ Available from the American Society for Nondestructive Testing, 1711 Arlington Ln., PO. Box 2818, Columbus, OH 43228-0518.

¹A Summary of Changes section appears at the end of this standard.

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