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GB/T 12606-2016 / ISO 10893-3:2011

Replacing GB/T 12606-1999

**Automated full peripheral flux leakage testing of
seamless and welded (except submerged arc-welded)
ferromagnetic steel tubes for the detection of longitudinal
and/or transverse imperfections**

(ISO 10893-3:2011, Non-destructive testing of steel tubes - Part 3: Automated full peripheral flux leakage testing of seamless and welded (except submerged arc-welded) ferromagnetic steel tubes for the detection of longitudinal and/or transverse imperfections, IDT)

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Table of Contents

Foreword.....	3
1 Scope	5
2 Normative references	5
3 Terms and definitions	5
4 General requirements.....	6
5 Test method.....	7
6 Reference tube.....	9
7 Equipment calibration and checking.....	12
8 Acceptance.....	13
9 Test report	13
Annex A (Normative) Limitations of magnetic flux leakage test method.....	15

Foreword

This Standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This Standard replaces GB/T 12606-1999 *Steel Tubes - The Testing Method of Magnetic Flux Leakage*. Compared with GB/T 12606-1999, the main technical changes in this Standard are as follows:

- modified the scope (see Clause 1 of this Edition, Clause 1 of Edition 1999);
- added normative references, terms and definitions, general requirements (see Clause 2, Clause 3, Clause 4 of this Edition);
- modified the steel tube inner diameter range of un-machined inner surface groove (see 6.1.2 of this Edition, 6.1.5 of Edition 1999);
- modified the selection requirements for the reference tube (see 6.1.3 of this Edition, 6.3.1 of Edition 1999);
- modified the borehole diameter range (see 6.1.2 of this Edition, 6.2.3 of Edition 1999);
- modified the requirements for the width and the length of reference notch (see 6.2.2 of this Edition, 6.1.4.2 and 6.1.4.3 of Edition 1999);
- modified the acceptance level and marks (see Table 1 of this Edition, Table 1 of Edition 1999);
- deleted the contents of flaw detection principle, flaw detection equipment (Clause 3 and Clause 4 of Edition 1999);
- added requirements for the number of re-inspection (see 8.2 of this Edition);
- modified the content of Annex A; deleted Annex B (see Annex A of this Edition, Annex B of Edition 1999).

This Standard uses translation method to identically use ISO 10893-3:2011 *Non-destructive testing of steel tubes - Part 3: Automated full peripheral flux leakage testing of seamless and welded (except submerged arc-welded) ferromagnetic steel tubes for the detection of longitudinal and/or transverse imperfections*.

The Chinese document which has consistency with the international normative reference in this Part is as follows:

- GB/T 9445-2008, *Non-destructive testing - Qualification and certification of personnel* (ISO 9712:2005, IDT)

This Part was proposed by China Iron and Steel Industry Association.

This Part shall be under the jurisdiction of National Technical Committee on Steel of Standardization Administration of China (SAC/TC 183).

The drafting organizations of this Standard: Tianjin Steel Pipe Group Co., Ltd., Hengyang Valin Steel Pipe Co., Ltd., Metallurgical Industry Information Standards Institute.

Main drafters of this Standard: Zhao Renshun, An Jianbo, Zhao Bin, Dong Li, Zhang Li.

Version of standard substituted by this Standard is:

- GB/T 12606-1999.

Automated full peripheral flux leakage testing of seamless and welded (except submerged arc-welded) ferromagnetic steel tubes for the detection of longitudinal and/or transverse imperfections

1 Scope

This Standard specifies requirements for automated full peripheral magnetic flux leakage testing of seamless and welded ferromagnetic steel tubes, with the exception of submerged arc-welded (SAW) tubes, for the detection of imperfections.

Unless otherwise specified in the purchase order, this Standard is applicable to the detection of predominantly longitudinal imperfections.

This Standard is applicable to the inspection of tubes with an outside diameter equal to or greater than 10 mm.

This Standard can also be applicable to the testing of hollow sections.

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 9712, *Non-destructive testing - Qualification and certification of personnel*

ISO 11484, *Steel products - Employer's qualification system for non-destructive testing (NDT) personnel*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 11484 and the following apply.

3.1 reference standard

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