



Standard Practice for Ultrasonic Testing of the Weld Zone of Welded Pipe and Tubing¹

This standard is issued under the fixed designation E273; 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 reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 This practice² describes general ultrasonic testing procedures for the detection of discontinuities in the weld and adjacent heat affected zones of welded pipe and tubing by scanning with relative motion between the search unit and pipe or tube. When contact or unfocused immersion search units are employed, this practice is intended for tubular products having specified outside diameters ≥ 2 in. (≥ 50 mm) and specified wall thicknesses of $\frac{1}{8}$ to $1\frac{1}{16}$ in. (3 to 27 mm). When properly focused immersion search units are employed, this practice may also be applied to material of smaller diameter and thinner wall.

NOTE 1—When contact or unfocused immersion search units are used, precautions should be exercised when examining pipes or tubes near the lower specified limits. Certain combinations of search unit size, frequency, thin-wall thicknesses, and small diameters could cause generation of unwanted sound waves that may produce erroneous examination results.

1.2 All surfaces of material to be examined in accordance with this practice shall be clean from scale, dirt, burrs, slag, spatter or other conditions that would interfere with the examination results. The configuration of the weld must be such that interfering signals are not generated by reflections from it. Treatment of the inner surface and outer surface weld beads such as trimming (“scarfing”) or rolling is often required to remove protuberances that could result in spurious reflections.

1.3 This practice does not establish acceptance criteria, they must be specified by the using parties.

1.4 The values stated in inch-pound units are to be regarded as the standard. The SI equivalents are in parentheses and may be approximate.

1.5 *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:³

E543 [Specification for Agencies Performing Nondestructive Testing](#)

E1316 [Terminology for Nondestructive Examinations](#)

2.2 ASNT Documents:⁴

[Recommended Practice SNT-TC-1A Personnel Qualification and Certification in Nondestructive Testing](#)
[ANSI/ASNT CP-189 Standard for Qualification and Certification of Nondestructive Testing Personnel](#)

2.3 ISO Standard:⁵

[ISO 9712 Non-destructive Testing—Qualification and Certification of NDT Personnel](#)

3. Terminology

3.1 *Definitions*—For definitions of terms used in this practice, see Terminology [E1316](#).

4. Summary of Practice

4.1 A pulsed ultrasonic angle beam shall be propagated in the wall of the pipe or tube by either the surface contact or immersion method. [Fig. 1](#) illustrates the characteristic oblique sound entry into the pipe wall for both contact and immersion examination from one search unit.

NOTE 2—The immersion examination method may include tanks, wheel search units, or bubbler systems.

¹ This practice is under the jurisdiction of ASTM Committee E07 on Nondestructive Testing and is the direct responsibility of Subcommittee E07.06 on Ultrasonic Method.

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² For ASME Boiler and Pressure Vessel Code applications see related Practice SE-273 in Section II of that Code.

³ For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

⁴ Available from American Society for Nondestructive Testing (ASNT), P.O. Box 28518, 1711 Arlingate Ln., Columbus, OH 43228-0518, <http://www.asnt.org>.

⁵ Available from International Organization for Standardization (ISO), 1, ch. de la Voie-Creuse, CP 56, CH-1211 Geneva 20, Switzerland, <http://www.iso.org>.