



Standard Practice for Eddy Current Examination of Steel Tubular Products Using Magnetic Saturation¹

This standard is issued under the fixed designation E309; 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 covers a procedure for applying the eddy current method to detect discontinuities in ferromagnetic pipe and tubing (**Note 1**) where the article being examined is rendered substantially non-magnetic by the application of a concentrated, strong magnetic field in the region adjacent to the examining coil.

NOTE 1—For convenience, the term tube or tubular product will hereafter be used to refer to both pipe and tubing.

1.2 The procedure is specifically applicable to eddy current testing methods using an encircling-coil assembly. However, eddy current techniques that employ either fixed or rotating probe-coil assemblies may be used to either enhance discontinuity sensitivity on the large diameter tubular products or to maximize the response received from a particular type of discontinuity.

1.3 This practice is intended for use on tubular products having outside diameters from approximately ¼ to 10 in. (6.35 to 254.0 mm). These techniques have been used for smaller and larger sizes however, and may be specified upon contractual agreement between the purchaser and the supplier.

1.4 This practice does not establish acceptance criteria; they must be specified by the using party or parties.

1.5 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

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 appro-*

priate 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 Other Documents:

SNT-TC-1A Recommended Practice for Personnel Qualification and Certification in Nondestructive Testing⁴

ANSI/ASNT CP-189 ASNT Standard for Qualification and Certification of Nondestructive Testing Personnel⁴

NAS-410 NAS Certification and Qualification of Nondestructive Test Personnel⁵

ISO 9712 Nondestructive Testing—Qualification and Certification of Nondestructive Testing Personnel⁶

3. Terminology

3.1 *General*—For definitions of terms used in this practice, refer to Terminology **E1316**.

4. Summary of Practice

4.1 The examination is conducted using one of two general techniques shown in **Fig. 1**.

4.1.1 One technique employs one or more exciter and sensor coils that encircle the tube and through which the tubular product to be examined is passed. Some circuit configurations employ one or more coils that concurrently function as both exciters and sensors. Alternating current passes through the exciting coil which, by reason of its proximity, induces

¹ This practice is under the jurisdiction of ASTM Committee **E07** on Nondestructive Testing and is the direct responsibility of Subcommittee **E07.07** on Electromagnetic Method.

Current edition approved June 1, 2016. Published June 2016. Originally approved in 1966. Last previous edition approved in 2011 as E309 - 11. DOI: 10.1520/E0309-16.

² For ASME Boiler and Pressure Vessel Code applications see related Recommended Practice SE 309 in Section V 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 Aerospace Industries Association (AIA), 1000 Wilson Blvd., Suite 1700, Arlington, VA 22209, <http://www.aia-aerospace.org>.

⁶ Available from International Organization for Standardization (ISO), ISO Central Secretariat, BIBC II, Chemin de Blandonnet 8, CP 401, 1214 Vernier, Geneva, Switzerland, <http://www.iso.org>.