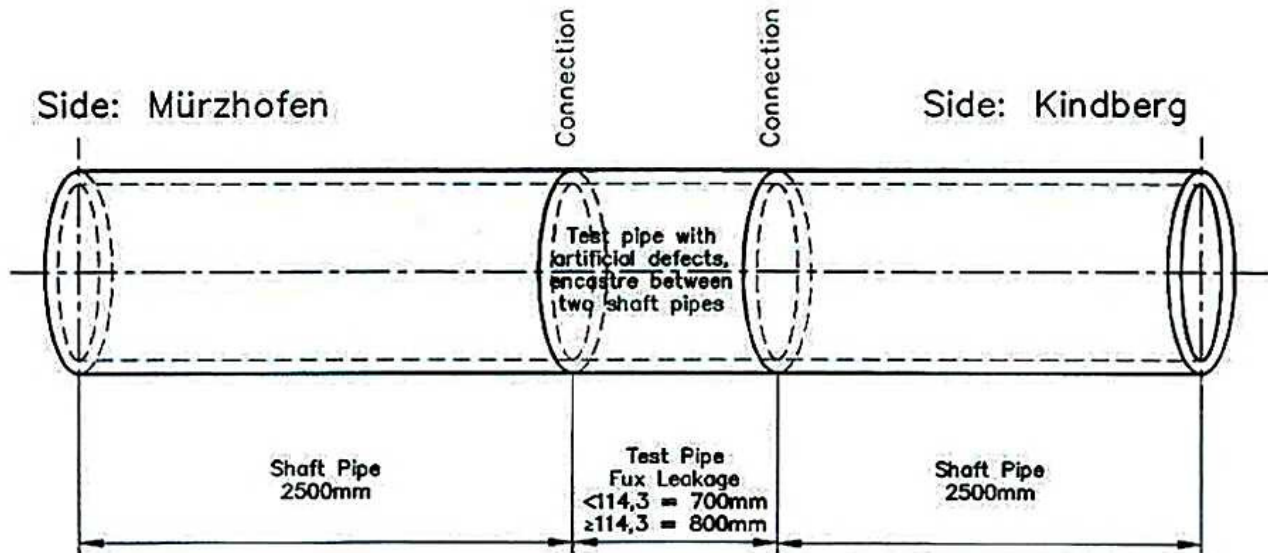


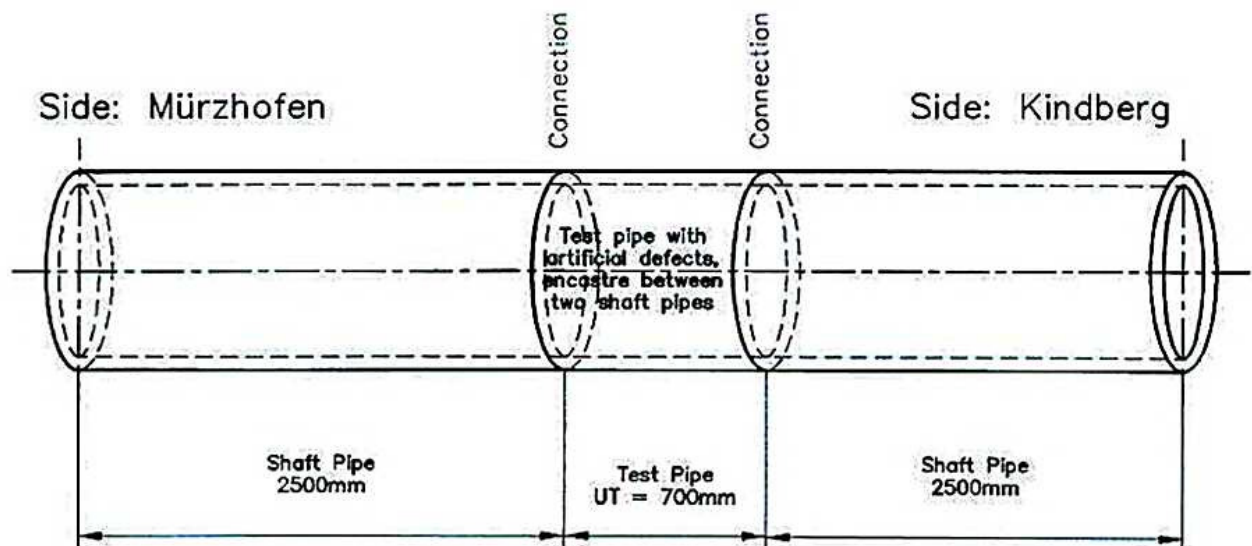
1. Test Pipe for normal inspection on flux leakage and UT – units.

The test pipe with the artificial defects is chucked between two shaft pipes.

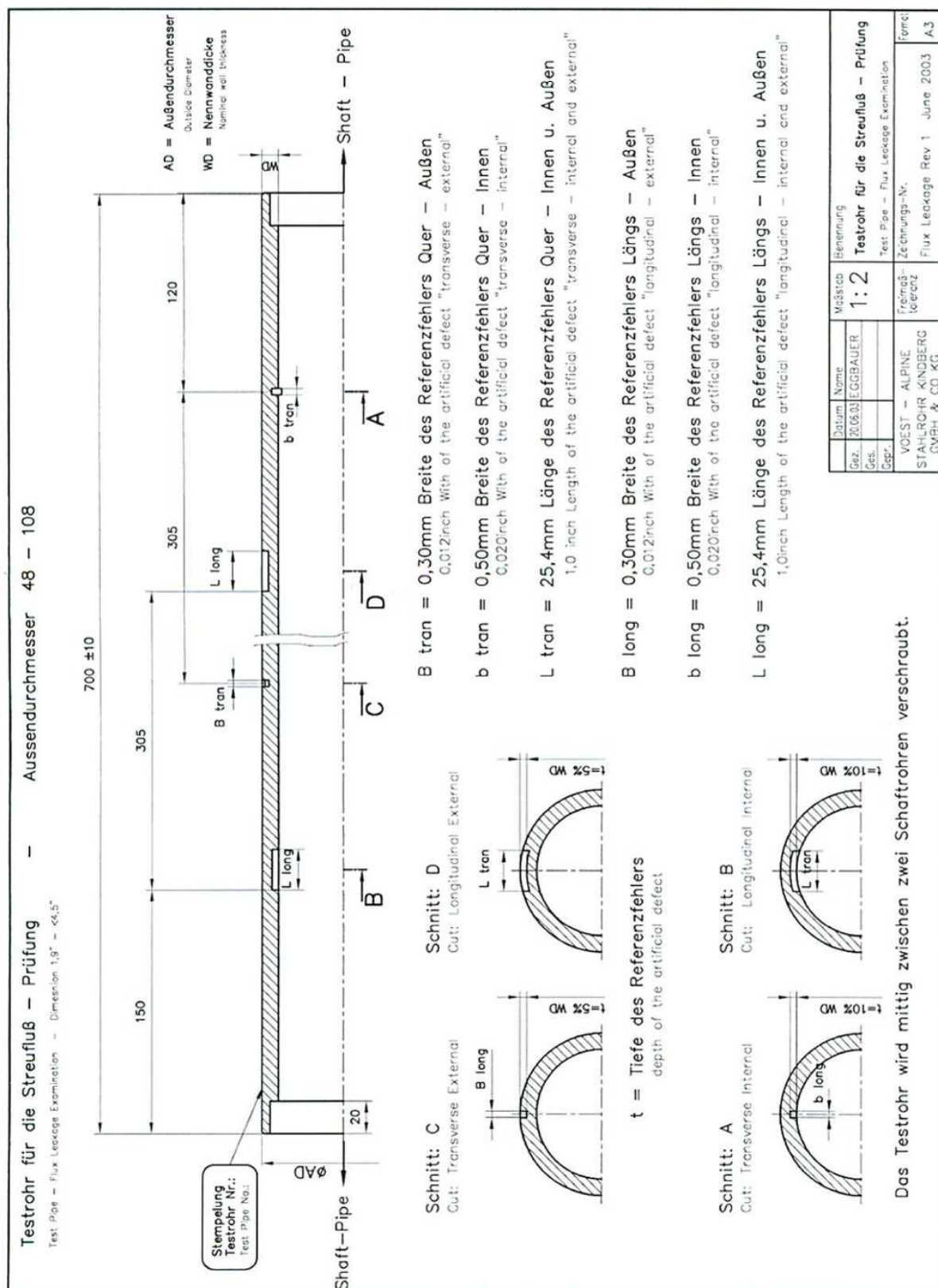
Test Pipe System- Flux Leakage Inspection



Pipe System – Ultrasonic Inspection



## Flux Leakage Inspection – Detail Drawing



2. For test runs on the flux – leakage and UT – unit we prepare additionally following test pipes.

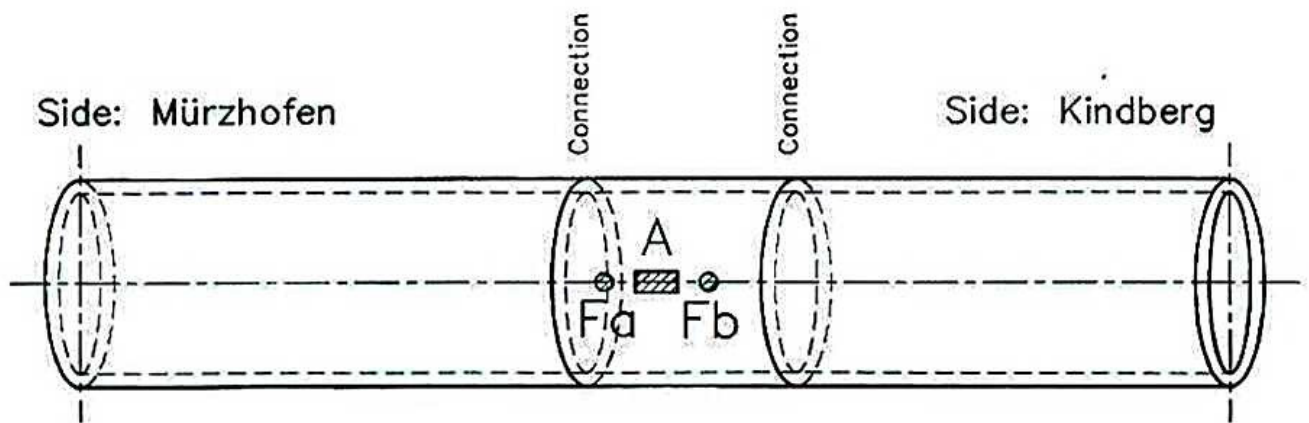
a. Test pipe with  $\frac{1}{4}$ " FBH (10% nWT) on the external and internal surface

Additionally wall reduction on internal surface.

Fa =  $\frac{1}{4}$ " FBH on internal surface

A = wall reduction internal surface max. 1" x 1"

Fb =  $\frac{1}{4}$ " FBH on external surface

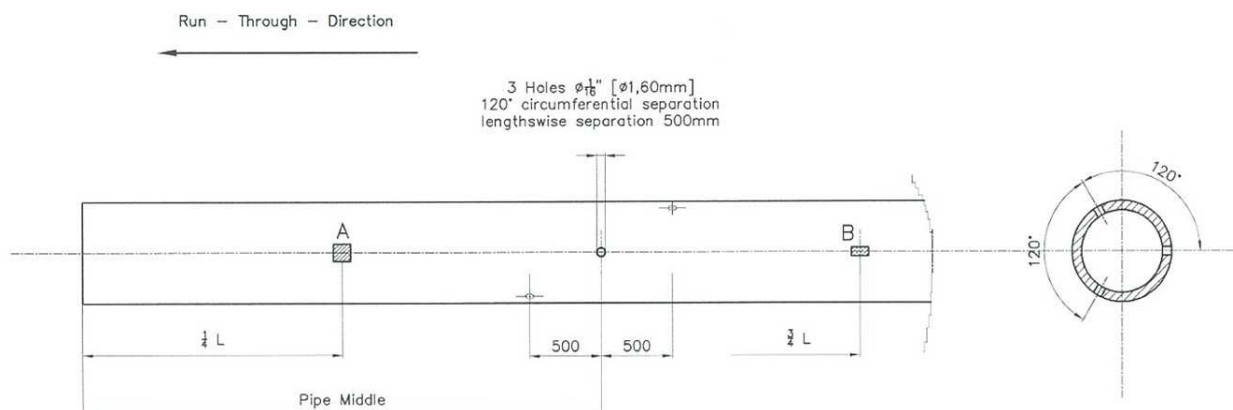


b. Test pipe with 3 holes,  $\frac{1}{16}$ " for Flux Leakage Inspection and wall reductions for UT – Inspection on the external surface

A = 1" x 1" edges grinded

B = 10mm x 20mm edges grinded ( $\varnothing 60,30 \times 4,83$ )

B = 12mm x 20mm edges grinded ( $\varnothing 177,80 \times 10,36$ )



- c. Test pipe with artificial defects on pipe ends and notches with different orientations for flux leakage -, MPI – on pipe ends and ultrasonic inspection unit.

Pipe Ends: longitudinal and transverse notch, 5% nWT, length 1", width 0,020"

Notches with different orientations on external surface:

Producible Degree: 0°, 11°, 22,5°, 45°, 67°, 90°, -67°, -45° - 22,5°, -11°, 0°

