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**Ultrasonic examination for arc welded  
steel pipes**

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## Foreword

This Japanese Industrial Standard has been revised by the Minister of Economy, Trade and Industry based on the provision of Article 14, paragraph (1) of the Industrial Standardization Act applied mutatis mutandis pursuant to the provision of Article 16 of the said Act in response to a proposal for revision of Japanese Industrial Standard with a draft being attached, submitted by The Japan Iron and Steel Federation (JISF), an accredited standards development organization. This edition replaces the previous edition (**JIS G 0584** : 2014), which has been technically revised.

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# Ultrasonic examination for arc welded steel pipes

## Introduction

This Japanese Industrial Standard has been prepared based on **ISO 10893-11** : 2011, Edition 1, and its Amendment 1 : 2020 with some modifications of the technical contents.

The vertical lines on both sides and dotted underlines indicate changes from the corresponding International Standard. A list of modifications with the explanations is given in Annex JA.

## 1 Scope

This Standard specifies the automated or manual ultrasonic examination on the welds of carbon steel pipes and ferritic alloy steel pipes (hereafter referred to as steel pipes) whose internal and external surfaces are automatic arc-welded either longitudinally or spirally.

NOTE 1 The examination is normally applicable to steel pipes 350 mm or over in outside diameter and 6 mm or over in wall thickness.

NOTE 2 The examination covered is normally applied to the detection of imperfections oriented parallel to the weld line. The examination of imperfections perpendicular to the weld line can be applied by agreement between the purchaser and the manufacturer.

NOTE 3 The International Standard corresponding to this Standard and the symbol of degree of correspondence are as follows.

ISO 10893-11 : 2011 *Non-destructive testing of steel tubes — Part 11 : Automated ultrasonic testing of the weld seam of welded steel tubes for the detection of longitudinal and/or transverse imperfections* + Amendment 1 : 2020 (MOD)

In addition, symbols which denote the degree of correspondence in the contents between the relevant International Standard and **JIS** are IDT (identical), MOD (modified), and NEQ (not equivalent) according to **ISO/IEC Guide 21-1**.

## 2 Normative references

Part or all of the provisions of the following standards, through reference in this text, constitute provisions of this Standard. The most recent editions of the standards (including amendments) indicated below shall be applied.

JIS G 0202 *Glossary of terms used in iron and steel (Testing)*

JIS G 0203 *Glossary of terms used in iron and steel (Products and quality)*

JIS G 0431 *Steel products — Employer's qualification system for non-destructive testing (NDT) personnel*