

Recommended Practice for Ultrasonic and Magnetic Examination of Offshore Structural Fabrication and Guidelines for Qualification of Technicians

API RECOMMENDED PRACTICE 2X
FOURTH EDITION, APRIL 2004

REAFFIRMED, SEPTEMBER 2020



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Upstream Segment

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FOREWORD

This recommended practice is under the jurisdiction of the API subcommittee on Offshore Structures.

Changes between this edition and the 3rd edition have been marked with “change bars” in the margin.

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CONTENTS

	Page
1 SCOPE	1
2 REFERENCES	1
3 DEFINITIONS	1
4 PLANNING	2
5 QUALIFICATION OF PERSONNEL	2
5.1 General	2
5.2 Examination Prerequisites	3
5.3 Qualification Examinations	3
5.4 Reexamination	6
6 EXTENT OF NONDESTRUCTIVE EXAMINATION.....	6
6.1 Time of Examination	6
6.2 Examination During Onshore Fabrication	6
6.3 Examination During Offshore Installation	6
7 TECHNICAL RECOMMENDATIONS FOR UT	7
7.1 Applicability of Ultrasonic Examination to Offshore Structures	7
7.2 Advantages and Limitations of Ultrasonic Examination of Welds	7
7.3 Significance of Discontinuities.....	9
7.4 Procedure Qualification and Approval	9
7.5 Equipment	10
7.6 Preparation for Examination	16
7.7 Scanning Techniques	16
7.8 Discontinuity Location	21
7.9 Discontinuity Evaluation	27
7.10 Acceptance Criteria	33
7.11 Reporting	41
7.12 Verification	41
8 TECHNICAL RECOMMENDATIONS FOR MAGNETIC PARTICLE TESTING.....	42
8.1 Applicability of Magnetic Particle Examination to Offshore Structures	42
8.2 Advantages and Limitations	42
8.3 Procedure Qualification and Approval	42
8.4 Equipment	43
8.5 Examination Technique	45
8.6 Equipment Performance Checks (Standardization) and Evaluation of System Sensitivity	49
8.7 Interpretation and Evaluation of Indications	50
8.8 Acceptance Criteria	51
8.9 Reporting	51
APPENDIX A—EXAMPLE QUESTIONS FOR WRITTEN UT TEST	53
APPENDIX B—CONSTRUCTION AND UT EVALUATION OF MOCKUP STRUCTURES	57
APPENDIX C—EXAMPLE OF SCORING UT PERSONNEL PERFORMANCE..	59
APPENDIX D—EXAMPLES OF UT AND MT REPORT FORMS.....	63

APPENDIX E—GLOSSARY OF NONDESTRUCTIVE EXAMINATION TERMINOLOGY	69
APPENDIX F—BIBLIOGRAPHY OF BACKGROUND REFERENCES	77

Figures

1—Weld Profiles Suitable for Preparation of Ultrasonic Test Plates	4
2—Method of Producing Incomplete Fusion “Defects” on Bevel Faces	5
3—Significance of Discontinuities	9
4—International Institutes of Welding (ITW) Ultrasonic Reference Blocks	13
5—Institute of Welding (IOW) Block	14
6—Check of Sweep Linearity	14
7—IIW Block—Determination of Angle Beam Transducer Index	14
8—IIW Block Showing Determination of Transducer Beam Angles	14
9—Determination of Beam Spread	15
10—Measurement of Beam Profile in the Vertical Plane	15
11—Measurement of Beam Spread in the Horizontal Plane	15
12—Weld Root Index	17
13—Weld Root Marking of Members for Installation Pile Splice Welds	18
14—Parameters Associated With Geometry of Pipe Intersection	19
15—Weld Root Examination	20
16—Scanning Patterns	20
17—Weld Scanning	21
18—Transfer Correction Determination	21
19—Graphical Plotting Cards Example 1	22
20—Graphical Plotting Cards Example 2	23
21—Graphical Plotting Cards Example 3	23
22—Graphical Plotting Cards Example 4	24
23—Graphical Plotting Cards Example 5	24
24—Graphical Plotting Cards Example 6	25
25—Graphical Plotting Cards Example 7	26
26—Graphical Plotting Cards Example 8	26
27—Circumferential Beam Path Scan	27
28—Skip Distance Adjustment for Circumferential Beam Path	28
29—Graphical Plotting Card for Circumferential Beam Path	29
30—Alternate Method for Determination of Skip Distance on Current Surfaces ...	30
31—Probe Manipulation for Spherical Discontinuity	30
32—Probe Manipulation for Planar Discontinuity	30
33—Distance Amplitude Correction	30
34—Beam Boundary Technique	31
35—Beam Boundary Plotting	32
36—Maximum Amplitude Technique	34
37—Multiple Reflectors	34
38—Circumferential Direction Beam Profile	34
39—20-Decibel d/B Beam Boundary Method	34
40—Length Measurement Comparison	34
41—Weld Profile Classifications	36
42—Design Curves for Different Weld Profiles Curve X From API RP 2A-WSD .	36
43—Reference for Level “A” Examination Block	37
44—Level A Acceptance Weld Quality	38
45—Internal Reflectors and All Other Welds	39
46—Reference for Level C Examination Block	40
47—Definitions	41
48—T, K, and Y Root Defects	42
49—Longitudinal Field Produced by Electromagnetic Yoke Setup	43

50—Radial Field Produced by “Single-Leg” Electromagnetic Setup	44
51—Magnetization Plan Setups	46
52—Illustration of API-Recommended Magnetic Field Indicator	46
53—Electromagnetic Yoke Setup for Detection of Longitudinal Discontinuities...	47
54—Electromagnetic Yoke Setup for Detection of Transverse Discontinuities	47
55—Incorrect and Correct Electromagnetic Yoke Setup for T and Y Joint Connections.....	48
56—Acceptable Setup for Scanning with “Single-Leg” Electromagnetic Method	48
57—Single-Leg Electromagnetic Setup for Detection of Longitudinal Discontinuities.....	48
A-1—Question 17 Diagram.....	54
A-2—Question 18 Diagram.....	54
A-3—Question 19 Diagram.....	55
B-1—Technique for Examining Welds Containing Natural Defects.....	58
C-1—Example of Key to Placement of Reflectors in Test Plate	60
C-2—Example of Typical Ultrasonic Technician Report of Test Results	61
C-3—Graphical Evaluation of Technician’s Report	62
D-1—Ultrasonic Examination Report Rejected Indications	66

Tables

1—Recommended Maximum Time Intervals Between Recalibration and Recertification of NDE Equipment	11
2—Recommended Standards and Maximum Performance Check Intervals for NDE and Mechanical Measuring Equipment.....	12
3—Transfer Correction Gain Adjustment	21

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1 Scope

This recommended practice (RP) for nondestructive examination (NDE) of offshore structural fabrication and guidelines for qualification of personnel contains guidance on NDE methods which have evolved from fabrication experience with offshore structures. These methods are commonly used and have found acceptance due to their reliable detection of discontinuities. The five NDE methods routinely used in offshore structural fabrication are visual (VT), penetrant (PT), magnetic particle (MT), radiography (RT), and ultrasonic (UT) examinations. This recommended practice primarily addresses the MT and UT methods. Guidance on VT, PT and RT is incorporated by reference to ANSI/AWS D1.1. Further recommendations are offered for determining the qualifications of personnel using MT and UT techniques. Recommendations are also offered for the integration of these techniques into a general quality control program. The interrelationship between joint design, the significance of defects in welds, and the ability of NDE personnel to detect critical-size defects is also discussed.

THIS DOCUMENT IS NEITHER A CODE NOR A SPECIFICATION AND SHOULD NOT BE UTILIZED AS SUCH BY THE OPERATOR.

2 References

The applicable editions of non-API standards referenced herein are as follows. Only the latest editions of these standards should be considered applicable, unless otherwise stated.

API

- RP 2A-LRFD *Recommended Practice for Planning, Designing and Constructing Fixed Offshore Platforms—Load and Resistance Factor Design*
- RP 2A-WSD *Recommended Practice for Planning, Designing and Constructing Fixed Offshore Platforms Working Stress Design*

ANSI¹/AWS²

- A3.0 *Standard Welding Terms and Definitions*
- D1.1 *Structural Welding Code—Steel*
- B1.10 *Guide for the Nondestructive Inspection of Welds*
- B1.11 *Guide for the Visual Inspection of Welds*

¹American National Standards Institute, 11 West 42nd Street, New York, New York 10036.

²American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33135.

ASNT³

- SNT-TC-1A *Recommended Practice for Qualification and Certification of NDE Personnel*

ASTM⁴

- A 435/A 435M *Straight-Beam Ultrasonic Examination of Steel Plates*
- A 578/A 578M *Straight-Beam Ultrasonic Examination of Plain and Clad Steel Plates for Special Applications*
- E 587 *Standard Practice for Ultrasonic Angle-Beam Examination by the Contact Method*
- E 709 *Standard Guide for Magnetic Particle Examination*
- E 1444 *Standard Practice for Magnetic Particle Examination*

3 Definitions

The welding terminology used herein is defined in the American Welding Society publication A3.0. Relevant ultrasonic terminology is defined in the Glossary section, Appendix E, of this document. Other definitions of interest are tabulated in the following. For the purpose of this standard, the following definitions apply:

3.1 acceptance criteria: Limit of shape, size, and position of discontinuities acceptable within the context of the specific design requirements.

3.2 agency personnel: Personnel employed and trained by an independent organization, offered to the Operator on a contract basis, for assisting in the construction inspection.

3.3 certification: Written testimony of qualification.

3.4 designer: The person, firm, corporation, or other organization employed by the Operator during fabrication and installation with responsibility for examining all details of fabrication to ensure compliance with construction specifications.

3.5 inspector: The individual representing the Operator during fabrication and installation with responsibility for examining all details of fabrication to ensure compliance with construction specifications.

3.6 NDE examination: An examination of materials and fabrication by qualified personnel responsible to the inspector using equipment for the purpose of locating and sizing discontinuities in materials or welds and reporting

³American Society of Nondestructive Testing, Inc., 1711 Arlington Lane, P.O. Box 28518, Columbus, Ohio 43228-0518, www.asnt.org.

⁴ASTM International, 100 Barr Harbor Drive, West Conshohocken, Pennsylvania 19428-2959, www.astm.org.