Quick guide

1. Check the reference and the marks of the parts to be checked.

2. Visual examination (note surface defects)

3. Acquisition of images & saving

4. Check the image quality

   • Check the grey levels in the different zones as well as the normalized signal to noise ratio by moving the 20x55pixel zone (min to obtain see standard)

   • Check the spatial resolution (IQI duplex)

   • Check the IQI wires visible after activating the Teledyne filter

5. Note the indications present on the image & compare them to the ASTM reference images (2422 for castings)

6. Note the position of the indications on the map - Photo of the part.

7. Complete the test report.

8. Store the tested part in the part area awaiting sanction.

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Case studies 1

CP120B & Go-Scan 1510 XR

CP120B & Go-Scan 1510 XR
Best portable solution to reach Class B (ISO17636-2) with small thicknesses

Equipment

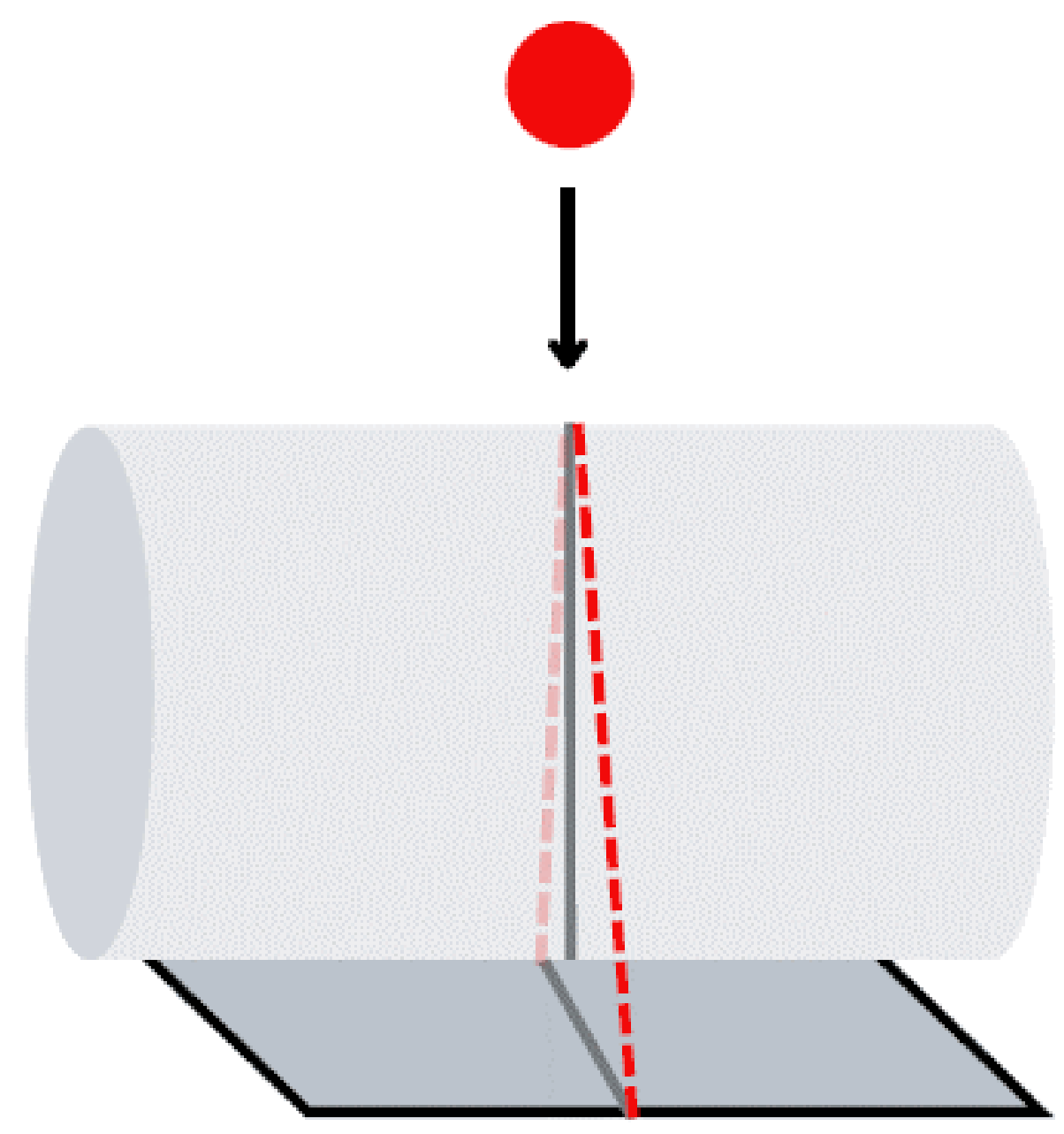| Generator	Detector
CP120B	**Go-Scan 1510 XR**
Focal spot: 0,8 mm	Resolution: 49,5 µm

FFD: 300 mm

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CP120B & Go-Scan 1510 XR
Best portable solution to reach Class B (ISO17636-2) with small thicknesses

Technique & material

Superimposed technique
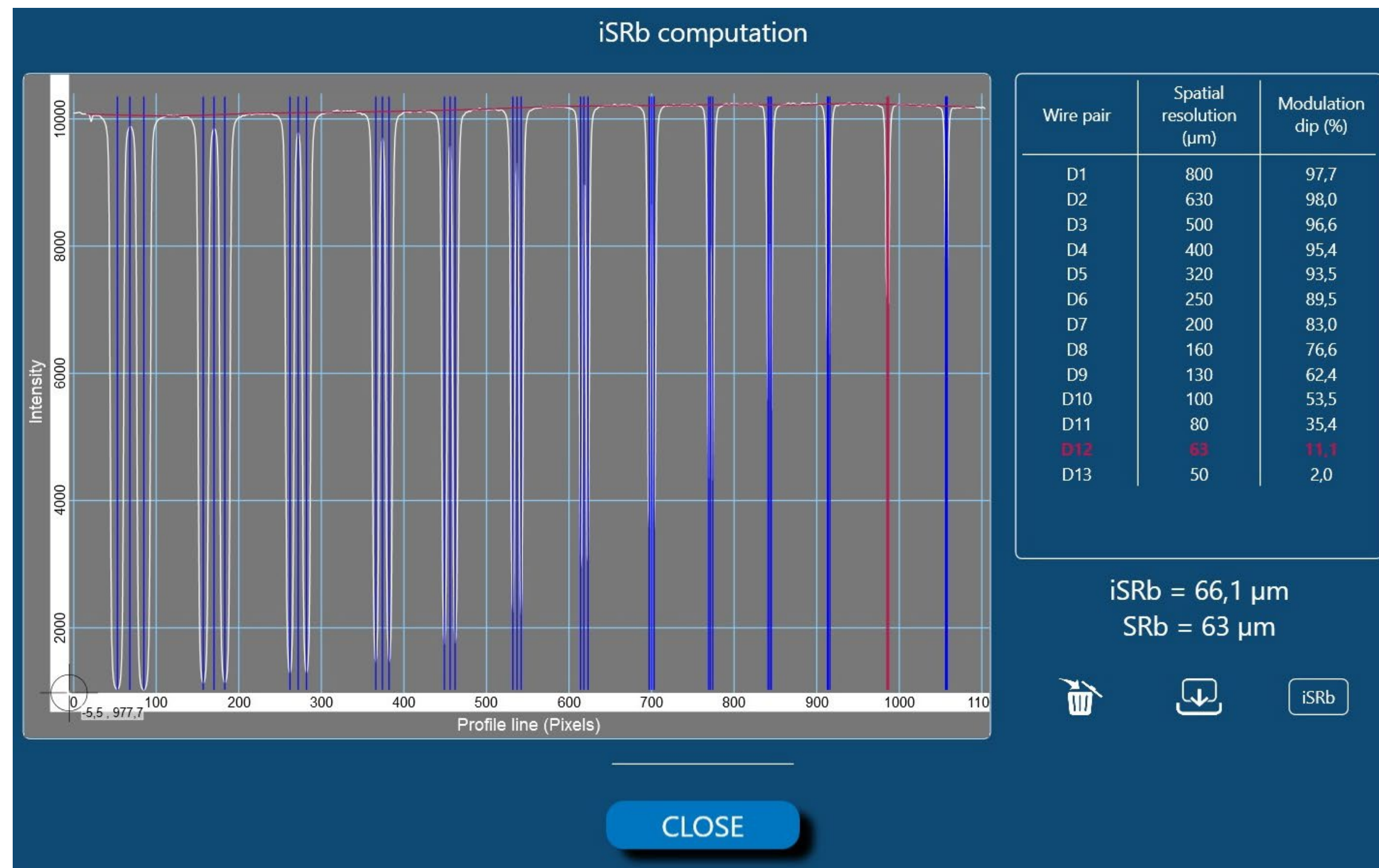

Steel pipe:
- 50 mm (OD)
- Single wall thickness: 1,5 mm

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Best portable solution to reach Class B (ISO17636-2) with small thicknesses

iSRb computation

Wire pair	Spatial resolution (µm)	Modulation dip (%)
D1	800	97,7
D2	630	98,0
D3	500	96,6
D4	400	95,4
D5	320	93,5
D6	250	89,5
D7	200	83,0
D8	160	76,6
D9	130	62,4
D10	100	53,5
D11	80	35,4
D12	63	11,1
D13	50	2,0

iSRb = 66,1 µm
SRb = 63 µm

CLOSE

Class B validated

CP120B & Go-Scan 1510 XR
Best portable solution to reach Class B (ISO17636-2) with small thicknesses
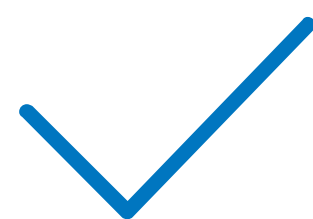
Class B (ISO 17636-2)

Required:
- SRb of 50 µm (D13)
- W17 visible
- SNR : 168*

Achieved:
- SRb of 63 µm (D12)
- W18 visible
- SNR : 353

✓ Class B validated thanks to the compensation principles.

*Requested SNR for class B between 50 & 150 kV is 120 (+40% in HAZ)

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Case studies 2

CP225D & Go-Scan 3025

CP225D & Go-Scan 3025
The portable solution for all your NDT applications

Equipment

Generator

Detector

CP225D

Focal spot: 3 mm

Go-Scan 2325

Resolution: 120 µm

FFD: 700 mm

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CP225D & Go-Scan 3025
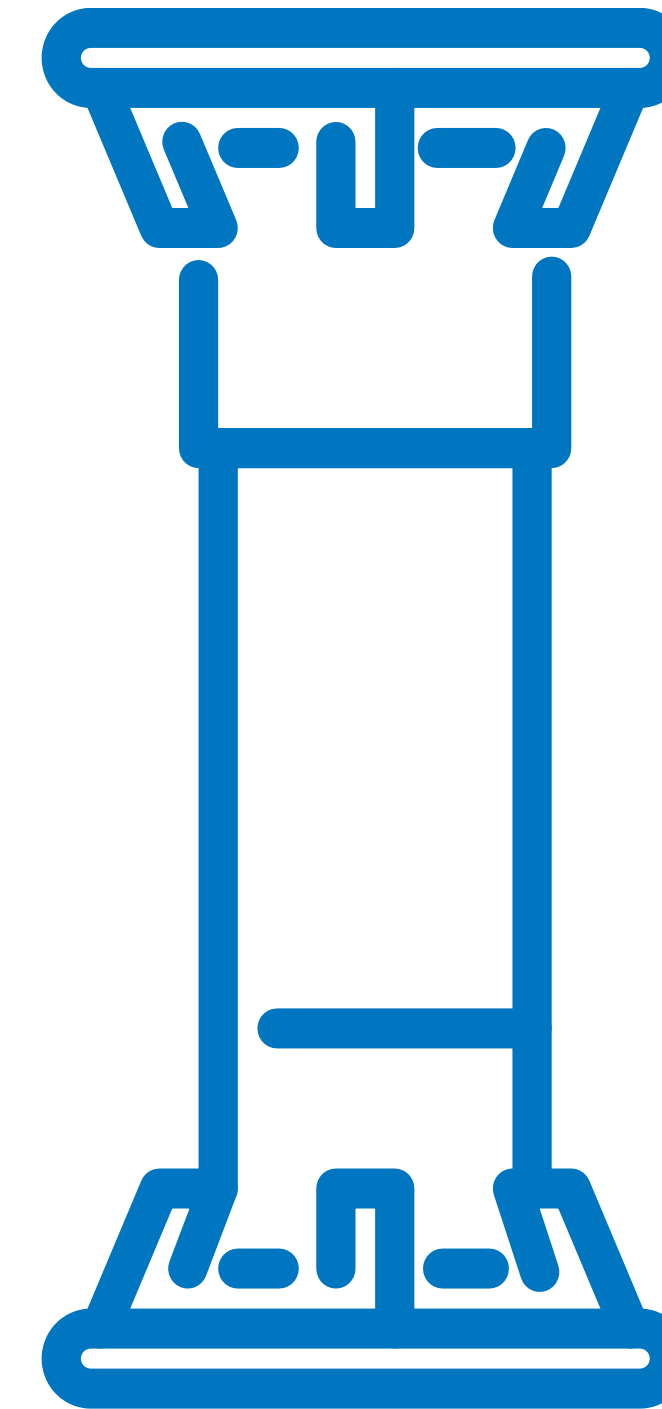## The portable solution for all your NDT applications

Material & Shooting settings

MATERIAL:
- Steel pipe
- 90 mm (OD)
- Single wall thickness: 6 mm

SHOOTING SETTINGS:
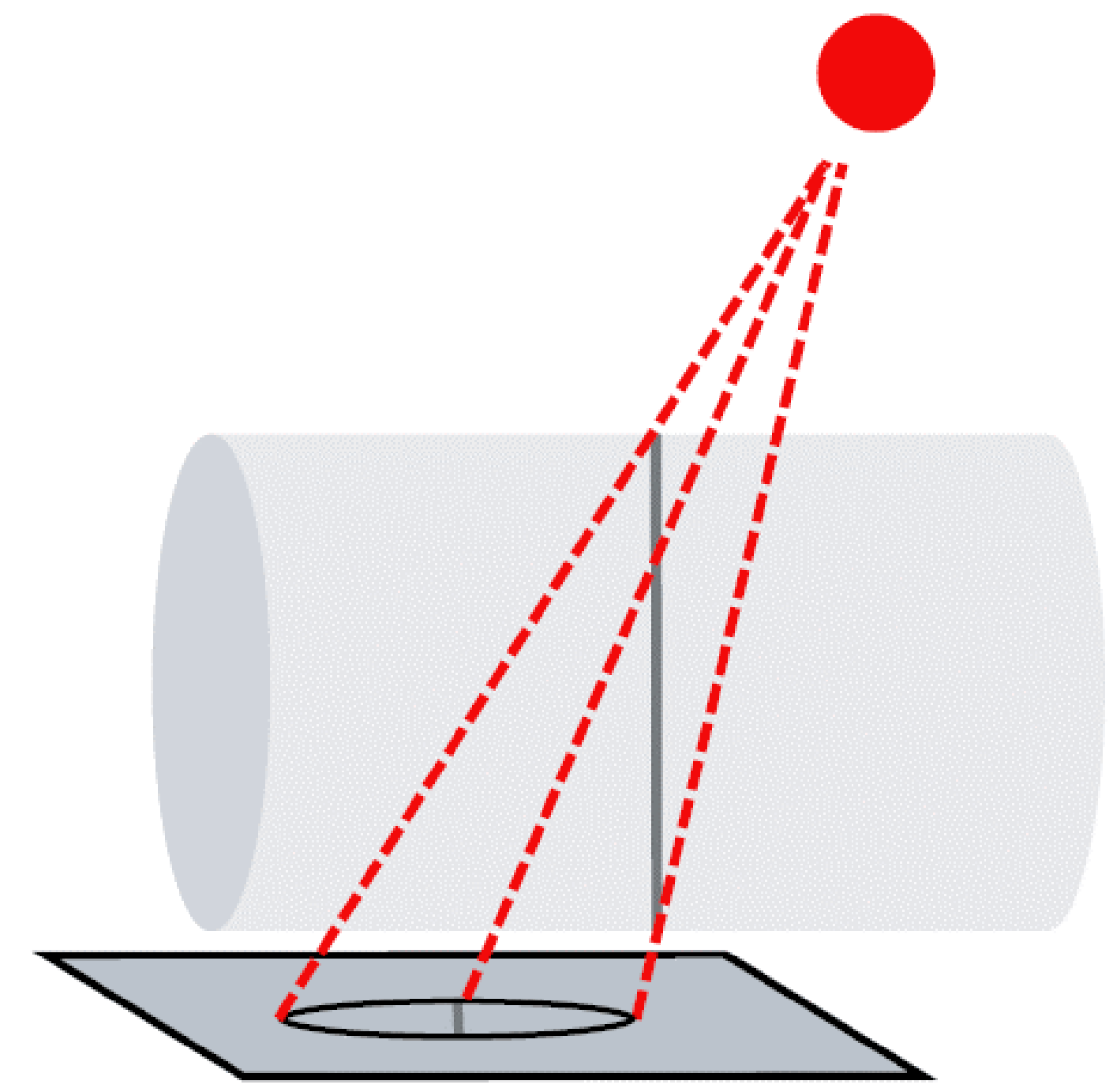- 225 kV
- 4 mA
- 3.5 sec integration time
- 5 frames

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CP225D & Go-Scan 3025
The portable solution for all your NDT applications

Technique

Double wall double image ellipse technique

Class B not validated

CP225D & Go-Scan 3025
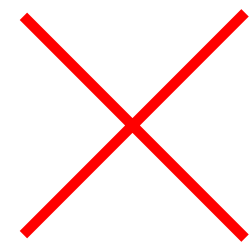## The portable solution for all your NDT applications

Class B (ISO 17636-2)

Required:
- SRb of 80 μm (D11)
- W14 visible
- SNR : 140*

Achieved:
- SRb of 130 μm (D9)
- W15 visible
- SNR : 196

Class B not validated.

*Requested SNR for class B between 150 & 250 kV is 100 (+40% in HAZ)

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Thanks!

For more information, please visit www.teledyneicm.com

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