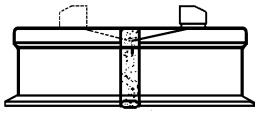
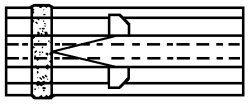
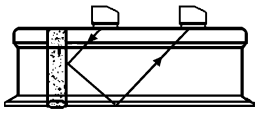
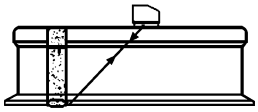
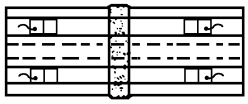
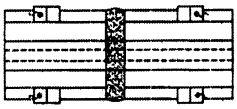
NDT Supply.com, Inc.
7952 Nieman Road
Lenexa, KS 66214-1560 USA
Phone: 913-685-0675, Fax: 913-685-1125
e-mail: sales@ndtsupply.com, www.ndtsupply.com

Table C.1 — Positioning of probes

Summary of test			
1	Test of head for non-planar defects		One 70° double crystal probe from both sides
2	Test of head for planar defects		Two 70° single crystal probes (TX & RX)
3	Test of web for planar defects		Two 45° single crystal probes in tandem with a positioning rig
4	Test of middle of foot		One 45° single crystal probe from both sides
5	Test of ankles		One 70° single crystal probe
6	Test of toes		One 70° single crystal probe
	Total number of probes required:	6 or 7	

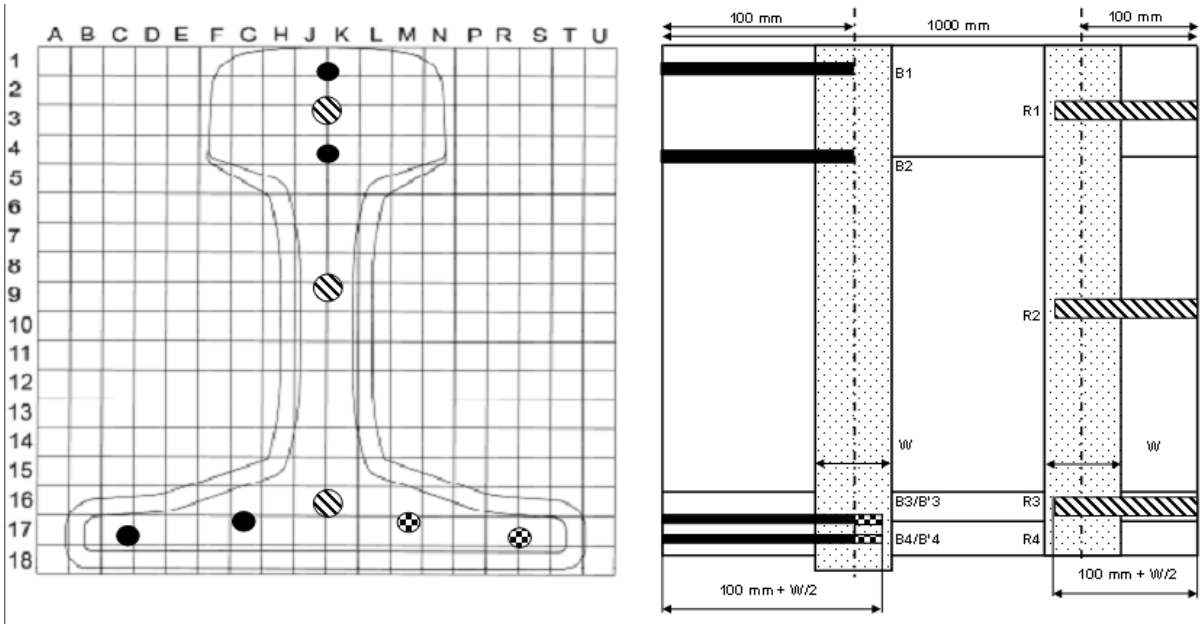
C.7 A1 Calibration

Timebase - Using the calibration block, see Figure C.1, for each test (C.1 to C.6) calibrate the timebase according to the reference hole used for the calibration sensitivity. The timebase shall be wide enough to do the examination of the whole concerned zone.

Sensitivity - Using the calibration block, the calibration sensitivity is defined for each test (C.1 to C.6).

The positioning of the probes is given in Table C.1.

TÜRK STANDARDLARININ TELiF HAKKI TSE'YE AiTTiR. STANDARDIN BU NÜSHASININ KULLANIM iZNi TSE TARAFINDAN TCDD GENEL MÜDÜRLÜGÜ'A VERiLMiSTiR. BASILMA TARiHi: 25.02.2015
TSE'DEN iZiN ALINMADAN STANDARDIN BiR BÖLÜMÜ/TAMAMI iLTiBAS EDiLEMEZ, ÇOGALTILAMAZ.



Key

	weld (right weld shall have weld collar ground flush under the foot)
	weld centre line
	Φ 5 mm flat bottomed hole (in depth of 100 mm)
	Φ 5 mm flat bottomed hole (in depth of 100 mm +W/2 mm)
	Φ 10 mm flat bottomed hole (in depth of 100 mm +W/2 mm)
W	nominal gap

Figure C.1 — Positioning of the holes (front view and side view) A1

TÜRK STANDARDLARININ TELiF HAKKI TSE'YE AiTTiR. STANDARDIN BU NÜSHASININ KULLANIM iZNi TSE TARAFINDAN TCDD GENEL MÜDÜRLÜGÜ'A VERiLMiSTiR. BASILMA TARiHi: 25.02.2015
TSE'DEN iZiN ALINMADAN STANDARDIN BiR BÖLÜMÜ/TAMAMI iLTiBAS EDiLEMEZ, ÇOGALTILAMAZ.