



15626—
2025

-

(TOFD)

(ISO 15626:2018, IDT)

1 322 « », -
 « » (« « ») « -
 , 4 » -
 2 322 « » -
 3 29 2025 . 1843- -
 4 15626:2018 « - (TOFD). » -
 [ISO 15626:2018 «Non-destructive testing of welds — Time-of-flight diffraction technique (TOFD)—Acceptance levels», IDT]. -
 5
 29 2015 . 162- « 26 -
) « (1 -
 — « », -
 () « ».
 ». , -
 —
 (www.rst.gov.ru)

1 1

2 1

3 1

4 2

5 2

6 2

6.1 2

6.2 2

6.3 4

7 5

7.1 5

7.2 5

7.3 7

7.4 7

7.5 8

() 9

..... 10

(TOFD)

Non-destructive testing of welds. Time-of-flight diffraction technique (TOFD). Acceptance levels

— 2026—04—01

1

(TOFD)

6 300 , , 5817.

10863²

2

ISO 5577, Non-destructive testing. Ultrasonic testing. Vocabulary ()

3

5577,

: https://www.iso.org/obp; : http://www.electropedia.org

3.1 (embedded discontinuity):

3.2 (surface-breaking discontinuity):

¹> » (, «discontinuity») « - 15626:2018.

²> (, ,), , -

4

h— ;
l— ;
t—

5

5817,

1.

1—

5817	10863	
()		1
()		2
D ()		3

6

6.1

X.

z-

6.2

6.2.1

6.2.2 6.2.3.

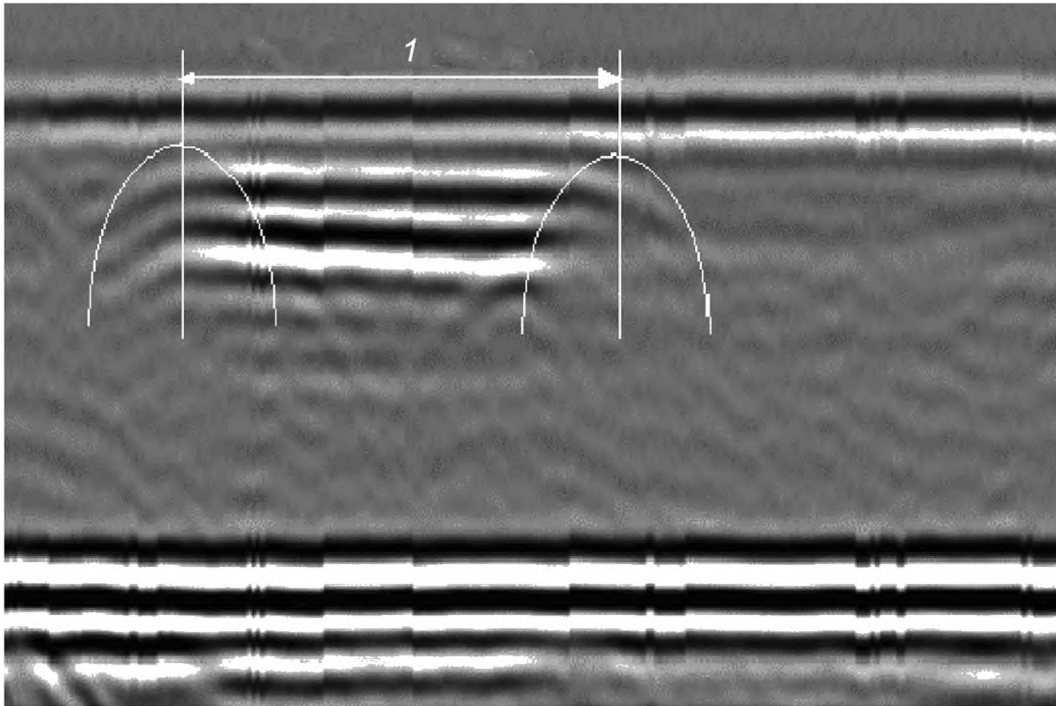
6.2.2

(. 1).

ISO 15626:2018

12.6.2.2 ISO 10863—2022).

6.2.3

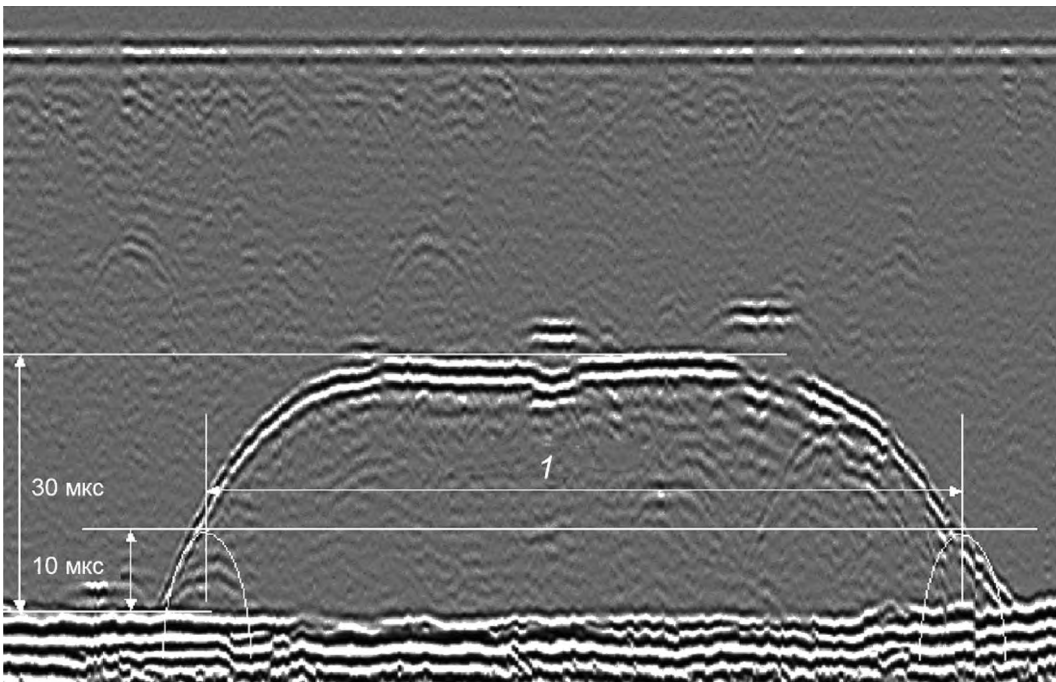


1—

$\frac{1}{3}$

(. 2).

12.6.2.3 ISO 10863—2022).

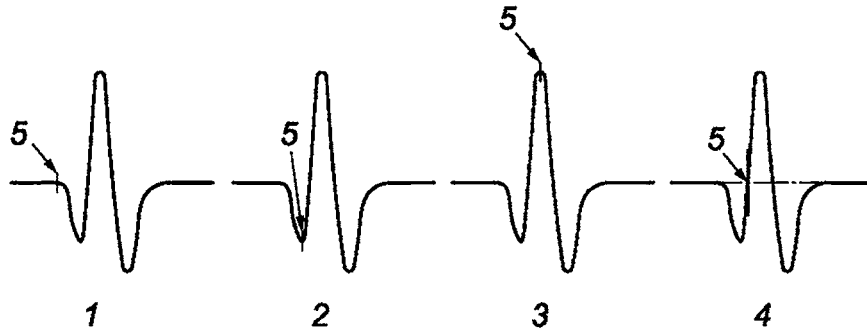


1—
2—

6.3

6.3.1

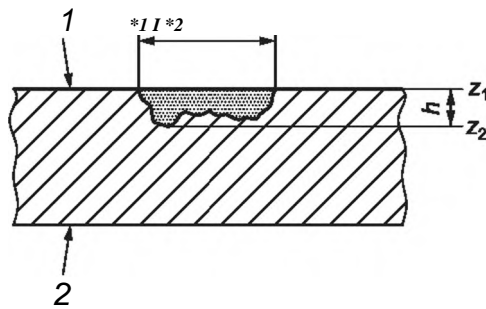
- (3):
- 1— ;
 - 2— ;
 - 3— ;
 - 4— ;



- 1—
- 1; 2—
- 2; 3—
- 3; 4—
- 4; 5—
- 3—
- 1, 2, 3 4

6.3.2

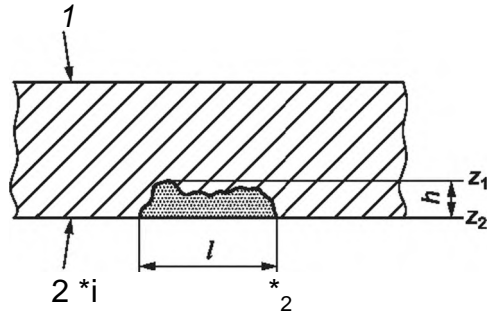
LW- ()



- 1— ; z_2 — ; 2— ; z_1 —
- ; h — ($h = z_2 - z_1$), t —
- ($l = \sqrt{2 \cdot h}$)

4—

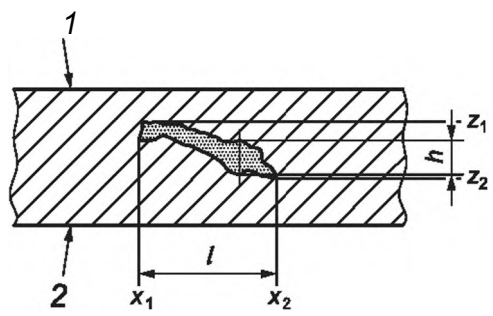
(. 5).



1— ; 2— ; z_2 — ; z_1 —
 ; h — ; l —
 ($h = z_2 - z_1$) ; l —
 ($l = x_2 - x_1$)

6.3.3

(. 6).



1— ; 2— ; z_2 — ; z_1 —
 ; h — ; l —
 ($h = z_2 - z_1$) ; l —
 ($l = x_2 - x_1$)

7

7.1

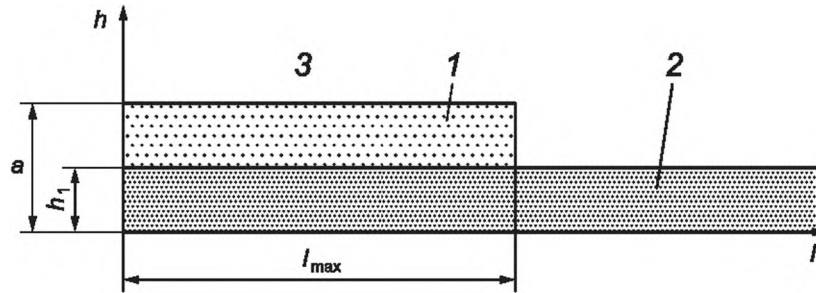
7.2 7.3,
 7.4 7.5

(, ,),

7.2

7.2.1

$h_{11} h_2 h_3$ 2, 3 4, 7.



— : h_2 — ; h_3 — ,
 1 — $l < l$; 2 — $l > l$; 3 — ; h^{\wedge} — , $l > l$

7 —

7.2.2 1

2 — 1

	$h < h_2$, h_3 , h^{\wedge}_{max}	$l < l$		$l > l$, l_1 ,
		h_3 , 3	h_2 ,	
6 $< f < 15$	0,75t	1,5	2	1
15 $< f < 50$	0,75f	2	3	1
50 $< f < 100$	40	2,5	4	2
$f > 100$	50	3	5	2

h_v

7.2.3 2

3 — 2

	$h < h_2$, h_3 , h^{\wedge}_{max}	$l < l$		h^{\wedge} , $l > l$,
		h_3 , 3	h_2 ,	
6 $< f < 15$	t	2	2	1
15 $< f < 50$	t	2	4	1

3

	$h < h_2$ h_3 \wedge max	/s/		h_1 , h_2
		h_3	h_2	
6 < ? < 15	50	3	5	2
? > 100	60	4	6	3

7.2.4 3

4— 3

	$h < h_2$ h_3 \wedge max	\wedge \wedge		h_1 h_2 h_3
		h_3	h_2	
6 < ? < 15	1,5? (20)	2	2	1
15 < ? < 50	1,5? (60)	2,5	4,5	2
50 < ? < 100	60	4	6	3
? > 100	75	5	8	4

7.3

12?,
 - 1 — 3,5?, 150 ;
 - 2 — 4,0?, 200 ;
 - 3 — 4,5?, 250 .

7.4

h^{\wedge}

()

.1

ISO 5577	IDT	5577—2009 « - »
- IDT -		

- [1] ISO 5817 Welding — Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) — Quality levels for imperfections [()]
- [2] ISO 10863 Non-destructive testing of welds — Ultrasonic testing — Use of time-of-flight diffraction technique (TOFD) [(TOFD)]
- [3] ISO 17635 Non-destructive testing of welds — General rules for metallic materials ()

620.179.15:006.354

25.160.40

: , - (TOFD),

30.12.2025.

03.02.2026.

60x847s.

1,86. 1,48.

« , 117418 »

www.gostinfo.ru info@gostinfo.ru

- , .31, .2.