

What is NDT Acceptance Criteria?

An inspectors job does not end after finding the discontinuities. The NDT inspector after completing the examination has to decide whether the discontinuities found during the examination are rejectable or acceptable. This is called application of acceptance criteria. Not all discontinuities found during inspection are rejected.

Where to find acceptance criteria ?

Acceptance criteria will be given in the applicable code or standard. And this depends on the component that is being inspected. The first step is to know where to find the acceptance criteria. And this depends on the component being inspected. For example, for pressure vessel examinations the acceptance criteria is in ASME VIII-1. For process piping it is in ASME B31.3. For structural steels it is in AWS D1.1

What is given in Acceptance Criteria ?

The acceptance criteria can provide the size of the discontinuity or the measured parameter. For example, in case of visual and radiographic examinations, the NDT acceptance criteria will directly provide the size of discontinuity. The criteria may state maximum size of single porosity allowed and any size larger is rejected. The size will be different for aligned porosity and clustered porosity. In ultrasonic testing, the acceptance criteria will generally be based in signal amplitude relative to a reference reflector and measured length.

All NDT inspectors performing examinations must be trained in application of the acceptance criteria.

Prepared by: Anmol Birring, Birring NDE Center