



Standard Practice for Ultrasonic Examination of Heavy Steel Forgings¹

This standard is issued under the fixed designation A 388/A 388M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript (a) indicates an editorial change since the last revision or reappraisal.

1. Scope^a

1.1 This practice² covers the examination procedures for the contact, pulse-echo ultrasonic examination of heavy steel forgings by the straight and angle-beam techniques. The straight beam techniques include utilization of the DGS (Distance Gain-Size) method. See [Appendix X3](#).

1.2 This practice is to be used whenever the inquiry, contract, order, or specification states that forgings are to be subject to ultrasonic examination in accordance with Practice A 388/A 388M.

1.3 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.4 This specification and the applicable material specifications are expressed in both inch-pound units and SI units. However, unless the order specifies the applicable "M" specification designation [SI units], the material shall be furnished to inch-pound units.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:³

[A 469/A 469M](#) Specification for Vacuum-Treated Steel Forgings for Generator Rotors

[A 745/A 745M](#) Practice for Ultrasonic Examination of Austenitic Steel Forgings

[E 317](#) Practice for Evaluating Performance Characteristics of Ultrasonic Pulse-Echo Testing Instruments and Systems without the Use of Electronic Measurement Instruments

[E 428](#) Practice for Fabrication and Control of Metal, Other than Aluminum Reference, Blocks Used in Ultrasonic Examination

[E 1065](#) Guide for Evaluating Characteristics of Ultrasonic Search Units

2.2 *ANSI Standard:*

B 46.1 Surface Texture⁴

2.3 *Other Document:*

Recommended Practice for Nondestructive Personnel Qualification and Certification SNT-TC-1A, (1988 or later)⁵

3. Terminology

3.1 Definitions:

3.1.1 *indication levels (clusters), n*—five or more indications in a volume representing a 2-in. [50-mm] or smaller cube in the forging.

3.1.2 *individual indications, n*—single indications showing a decrease in amplitude as the search unit is moved in any direction from the position of maximum amplitude and which are too small to be considered traveling or planar.

3.1.3 *planar indications, n*—indications shall be considered continuous over a plane if they have a major axis greater than 1 in. [25 mm] or twice the major dimension of the transducer, whichever is greater, and do not travel.

3.1.4 *traveling indications, n*—indications whose leading edge moves a distance equivalent to 1 in. [25 mm] or more of metal depth with movement of the transducer over the surface of the forging.

4. Ordering Information

4.1 When this practice is to be applied to an inquiry, contract, or order, the purchaser shall so state and shall also furnish the following information:

4.1.1 Designation number (including year date).

4.1.2 Method of establishing the sensitivity in accordance with 8.2.2 and 8.3.3 (Vee- or rectangular-notch).

¹ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

² Available from the American Society for Nondestructive Testing, 1711 Arlington Ln., P.O. Box 28518, Columbus, OH 43228-0518.

^aA Summary of Changes section appears at the end of this standard.

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Nuclear Science Abstracts ,1971 *Design Guide for Vehicle Spur and Helical Gears* American Gear Manufacturers Association,1993 Nondestructive Evaluation of Aging Bridges and Highways Society of Photo-optical Instrumentation Engineers,1995 **Historical Industry Standards** ,1979 **Specification for Wellhead Surface Safety Valves and Underwater Safety Valves for Offshore Service** American Petroleum Institute. Production Department,1991

Standards Cross-reference List LaDonna Thompson,Kathy Beckman,Patricia Ricci,1977 *Handbook of Valves and Actuators* Brian Nesbitt,2007-08-02 Industries which use pumps seals and pipes will almost certainly also use valves in their systems Someone in each industry needs to be able to design purchase or maintain the right valve for the job in hand and that can amount to a lot of valves world wide Here is a single resource which is aimed at those designers and end users plus their engineering staff Brian Nesbitt is a well known consultant with a considerable publishing record A lifetime of experience backs up the huge amount of practical detail found in this volume Its international approach is no accident it will have world wide take up Ideal reference for industry Practical approach compared with competition Buyers guide included

Tenth World Conference on Non-Destructive Testing, Moscow 1982: Contributed papers, Thursday 26th August ,1982 *Official Export Guide* North American Publishing Company,1995 **Bulletin on Referenced Standards for Committee 6, Standardization of Valves and Wellhead Equipment** American Petroleum Institute. Production Department,1990 **ASME Boiler and Pressure Vessel Code** American Society of Mechanical Engineers. Boiler and Pressure Vessel Committee,1980 *Catalog of American National Standards* American National Standards Institute,1977

Pressure Vessel Engineering Technology R. W. Nichols,1971 **General-purpose Steam Turbines for Petroleum, Chemical, and Gas Industry Services** American Petroleum Institute,1997 **Mechanical Engineering** ,1981 **API Specification** American Petroleum Institute. Production Dept,1988 **Non-destructive Testing** G. Honeyman,1989 This book introduces available non destructive testing NDT techniques to the engineer and shows how these techniques are used to detect flaws in forgings castings bar tube pipe and fabrications It discusses the significance of these flaws in various components with respect to defect types **Materials Evaluation** ,1998 *API Bulletin* ,1990 NASA Contractor Report ,1979

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Table of Contents Astm A388

1. Understanding the eBook Astm A388
 - The Rise of Digital Reading Astm A388
 - Advantages of eBooks Over Traditional Books
2. Identifying Astm A388
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Astm A388
 - User-Friendly Interface
4. Exploring eBook Recommendations from Astm A388
 - Personalized Recommendations
 - Astm A388 User Reviews and Ratings
 - Astm A388 and Bestseller Lists

-
5. Accessing Astm A388 Free and Paid eBooks
 - Astm A388 Public Domain eBooks
 - Astm A388 eBook Subscription Services
 - Astm A388 Budget-Friendly Options
 6. Navigating Astm A388 eBook Formats
 - ePub, PDF, MOBI, and More
 - Astm A388 Compatibility with Devices
 - Astm A388 Enhanced eBook Features
 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Astm A388
 - Highlighting and Note-Taking Astm A388
 - Interactive Elements Astm A388
 8. Staying Engaged with Astm A388
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Astm A388
 9. Balancing eBooks and Physical Books Astm A388
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Astm A388
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Astm A388
 - Setting Reading Goals Astm A388
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Astm A388
 - Fact-Checking eBook Content of Astm A388
 - Distinguishing Credible Sources
 13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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