

航空航天无损检测认证部

NANDTB-CN

NANDTB-CN-208 检测方法&验收标准 Method & Acceptance Standard

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序号 No.	检测方法 Method	检测方法标准 NDT Standard	验收标准 Acceptance Criteria
1	渗透检测 PT	GJB 2367A-2005 渗透检验 Liquid penetrant inspection	HB 5480 高强度铝合金优质铸件
			HB 963 铝合金铸件规范
			GJB 2896A 钛及钛合金熔模精密铸件规范 Specification for titanium and titanium alloy investment castings
			QJ 1842A 结构钢、不锈钢熔焊技术要求
2	磁粉检测 MT	GJB 2028A-2019 磁粉检测 Magnetic particle testing	MIL-STD-1907
			GB/T 3077 合金结构钢
		ASTM E1417	GB/T 9444 铸钢铸件 磁粉检测
3	射线照相 RT-Film	GJB 1187A-2019 射线照相检测 Radiography testing	MIL-STD-1907
			HB 5480 高强度铝合金优质铸件
	非胶片射线 RTNF	GJB 1718A 电子束焊接 Electron beam welding	GJB 1718A 电子束焊接
			GJB 2896A 钛及钛合金熔模精密铸件规范
4	超声检测 UT	GB/T 3323.2-2019 NDT of welds - Radiographic testing Part 2: X-and gamma-ray techniques with digital detectors	
		DDA/LDA: ASTM E2698	
		CR: ASTM E2033	
		CT: HB 20446, GB/T 29070 GB/T 38535-2020	
5	涡流检测 ET	GJB 1580A-2019 Ultrasonic inspection of wrought metal	
		GJB 1038.1A-2004 Non-destructive inspecting methods for fiber reinforced composite Part 1: Ultrasonic testing	GJB 2895 碳纤维复合材料层合板和层合件 通用规范/General specification for carbon fiber composite laminates and laminated components
		AMS-STD-2154	AMS-STD-2154
		ASTM E2580	NANDTB-CN-ST005-2011 复合材料超声检测 验收规范
6	腐蚀检查 EI	GJB 2908A-2020 涡流检测方法 EN 15549	GJB 2908A-2020 Eddy current testing
		NE, Temper Etch: MIL-STD-867C, HB 7717	MIL-STD-867C-2008, HB 7717-2002
		AEI: AMS2649C	AMS2649C-2008
7	目视检测 VT	AFD: AMS2642E	AMS2642E-2016
		ISO 17637, GB/T 32259-2015	
		GB/T 41856.1	GB/T 41856.2-2022
8	红外热像 IRT	QJ 2859-1996 Operating methods and judgment rules for industrial endoscopes	
		ASTM E2582	
		EN 17119	
		GB/T 26643	