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Conformity assessment system for the use of nuclear energy. Accessories for ultrasonic testing of base materials (semiproducts), welded joints and clad surfaces of equipment and piping of nuclear power installations. General requirements

— 2019—08—01

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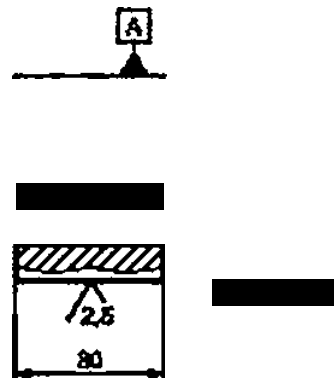
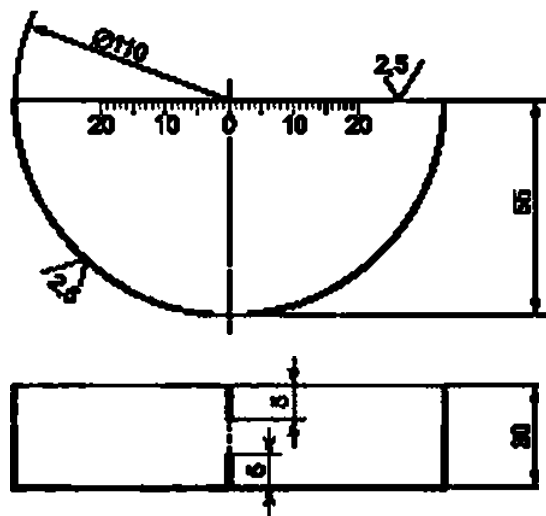
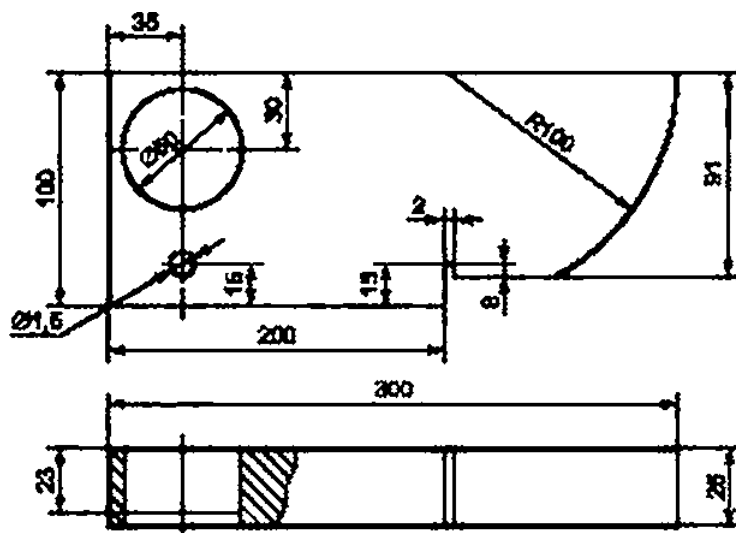


Рисунок 1 — Образец СО-2 (материал — Ст. 20 или Ст. 3)



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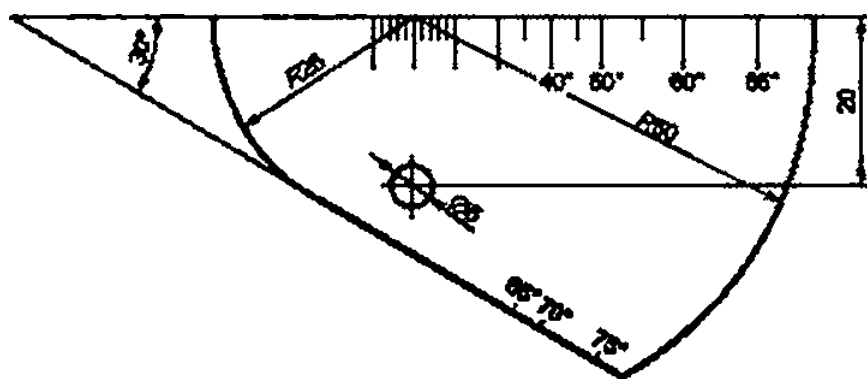
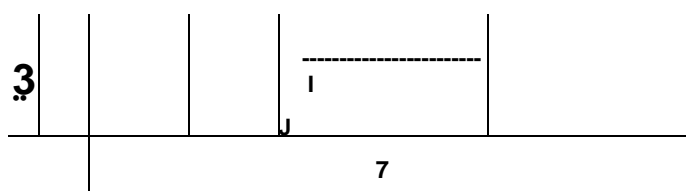
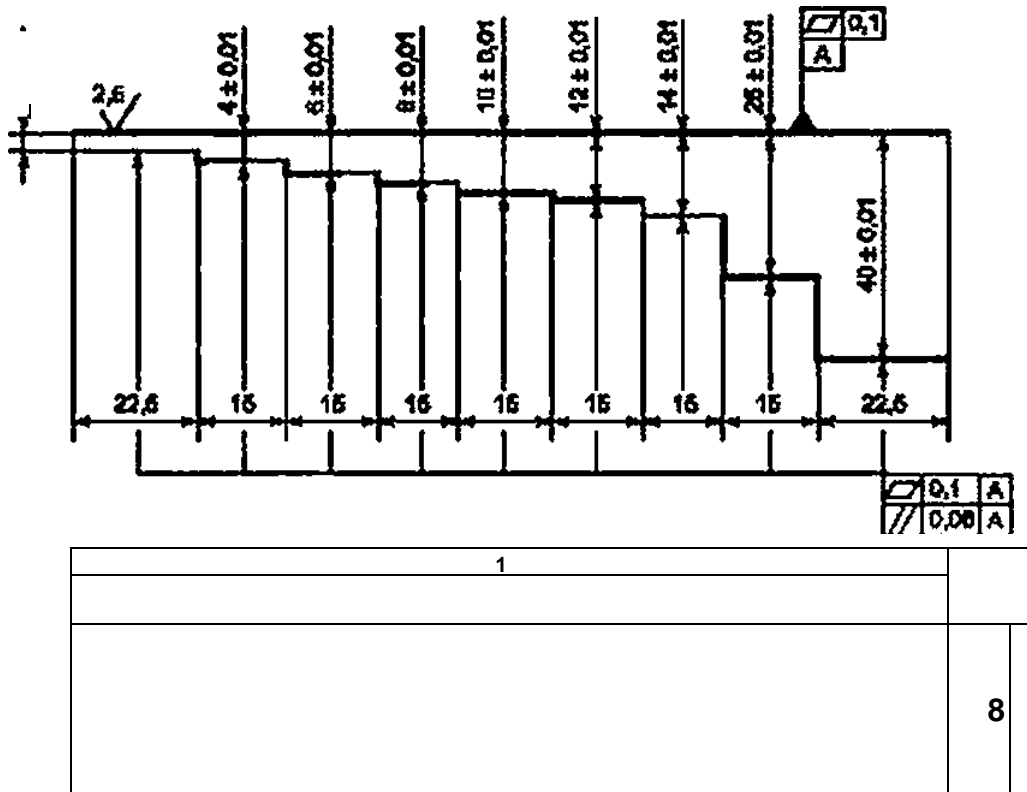
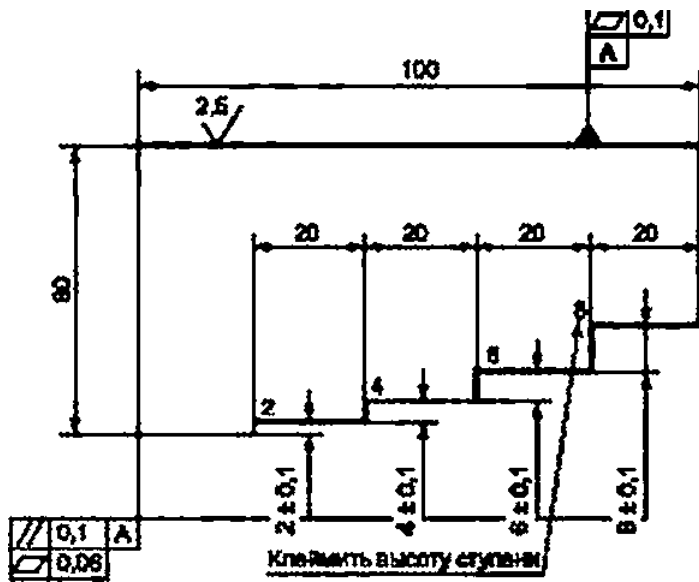


Рисунок 4 — Образец V2



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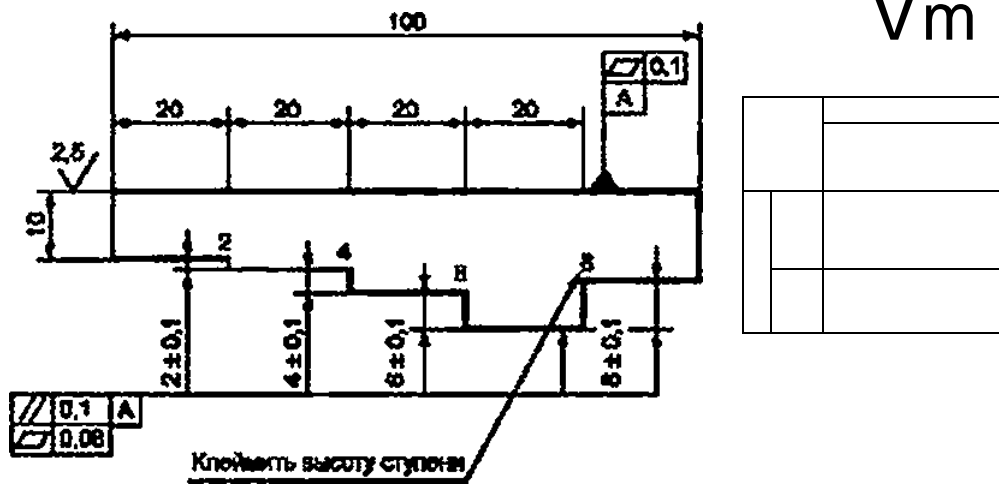
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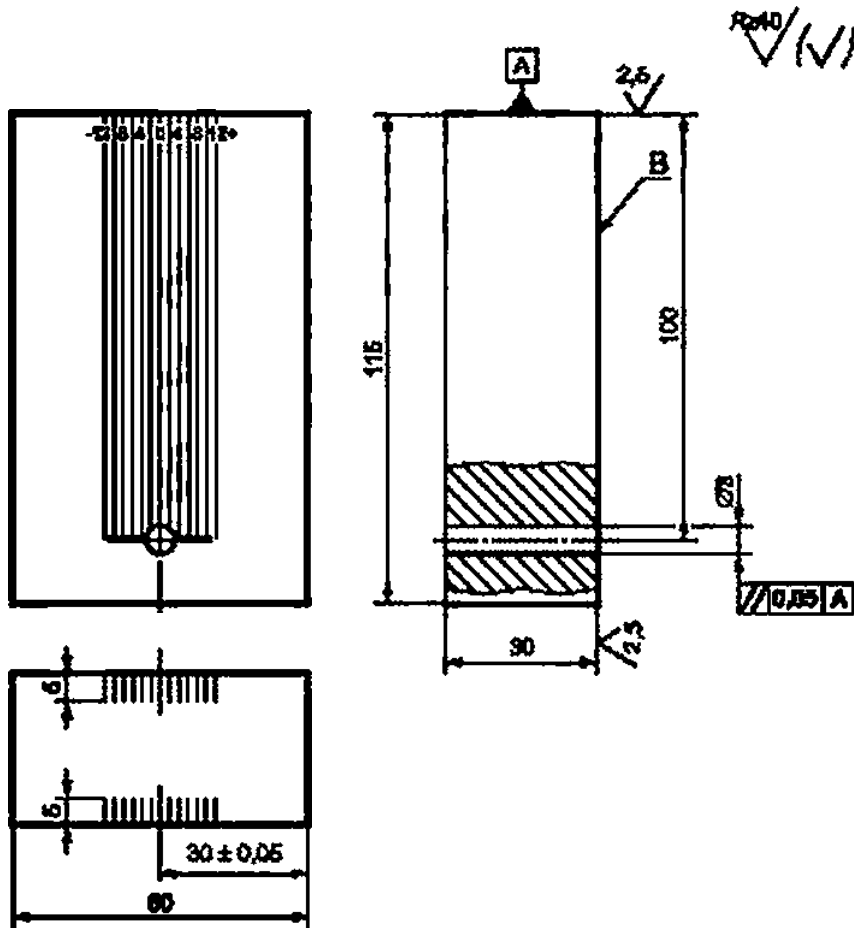
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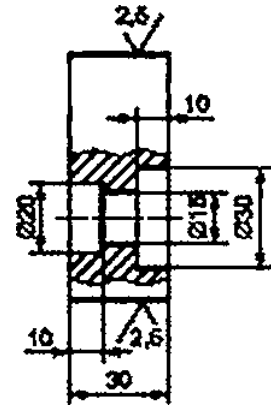
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- S — , .
- X , 2 , 3 — , ;
- — , ;
- h — , ;
- b — , ;
- (, — , ;
- R — , ;
- l_2 — , .

6.8.2.1 L () ± 1.0 .

S — , $\pm 10.0\%$.

6.8.2.2 — ± 0.05 . h .

6.8.2.3 — ± 0.05 . () ± 1.0 . X , — 2 —

50.0 — 3 — 25.0 .

6.8.2.4 — $\pm 1^*$.

6.8.2.5 — ± 0.05 .

6.8.2.6 $\pm 0,3$. 1_2 —

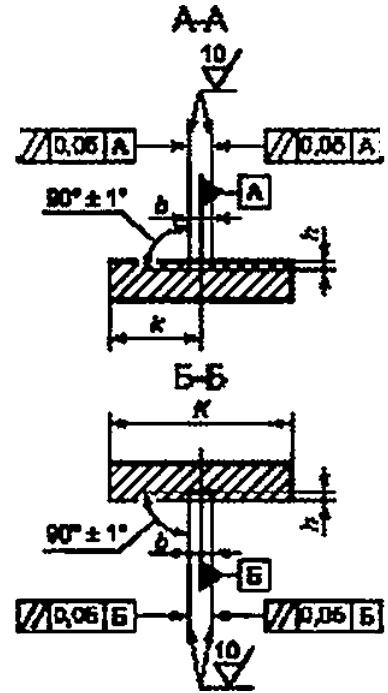
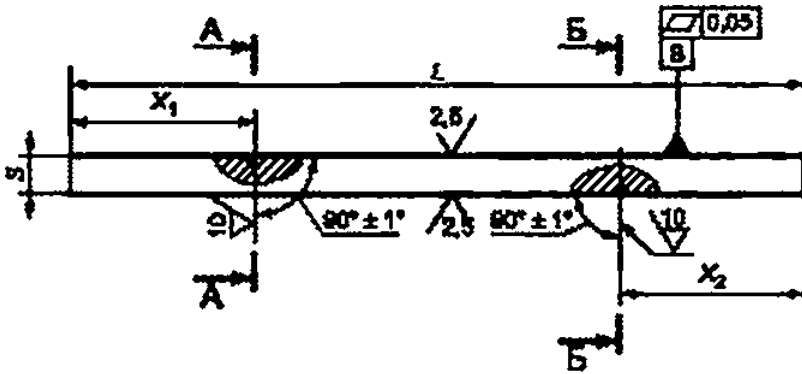
6.8.2.7 d , — ± 0.05 .

6.8.2.8 — ± 0.05 .

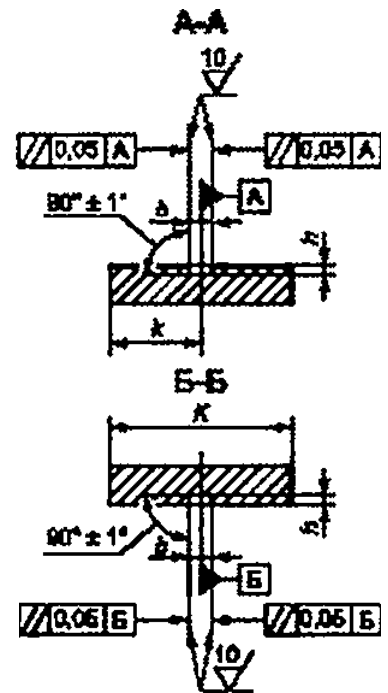
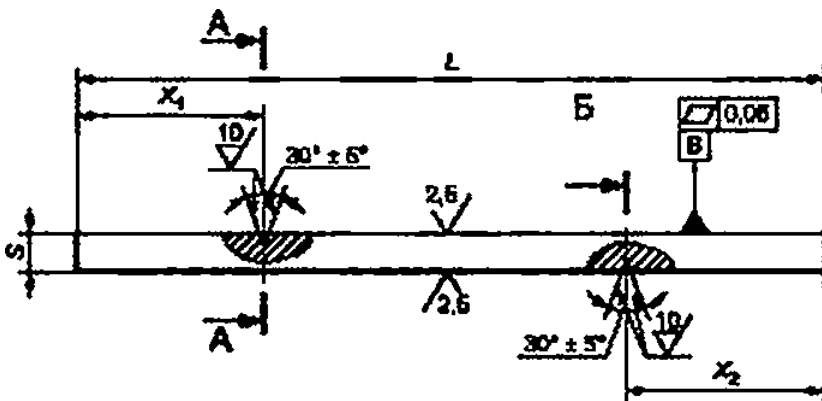
6.8.2.9 () —

6.8.2.10 — h/b — (b l_2)

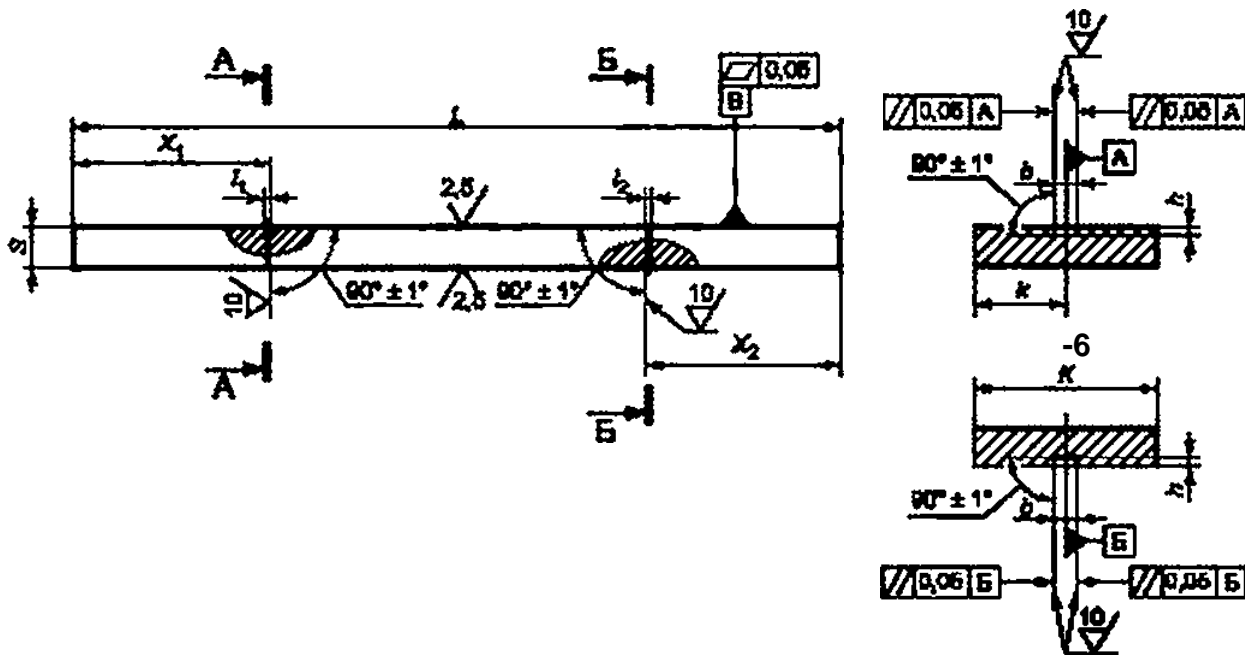
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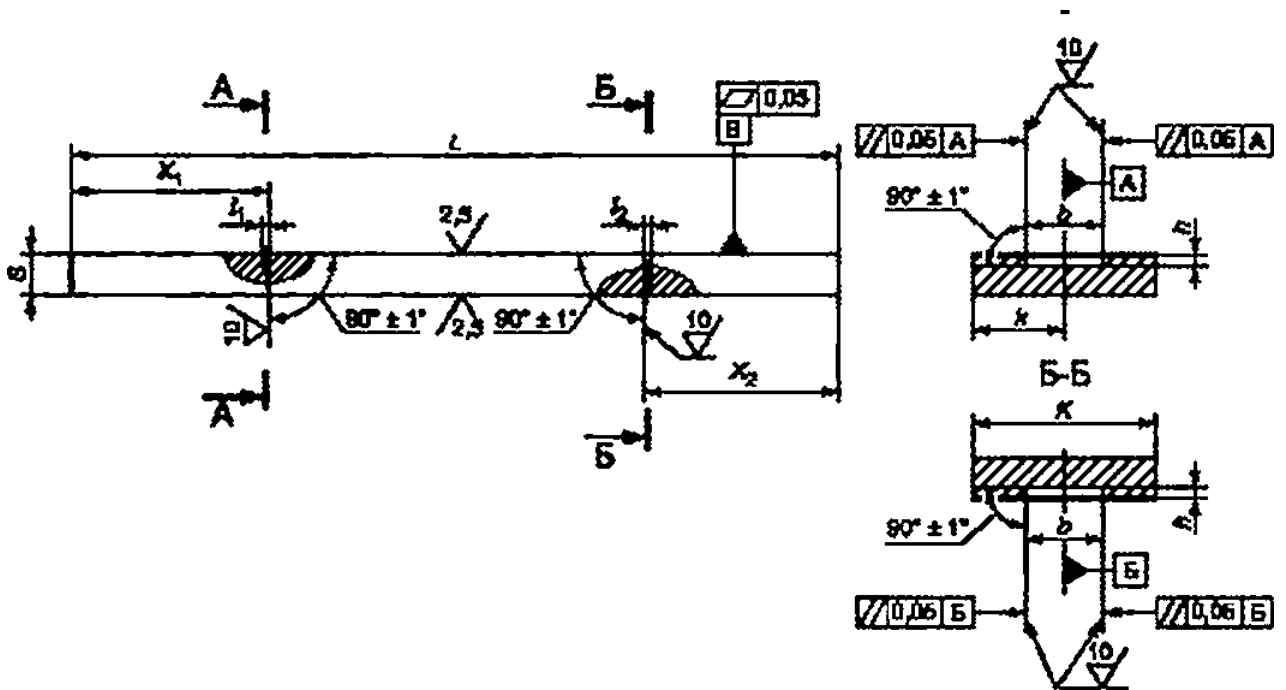
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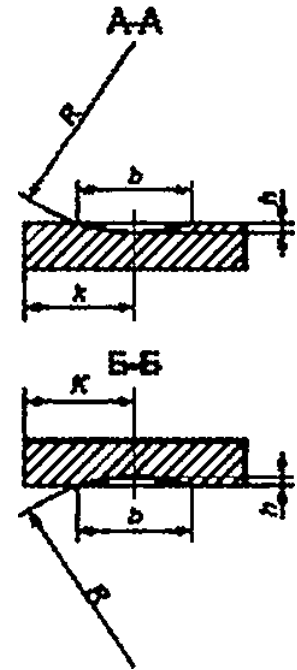
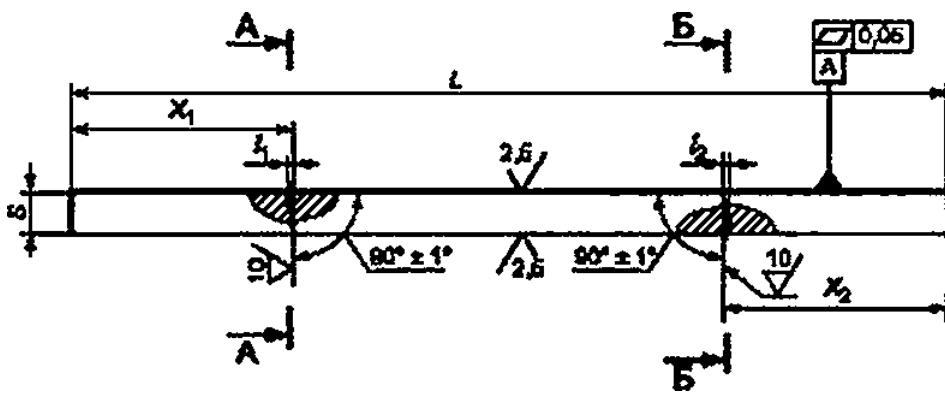
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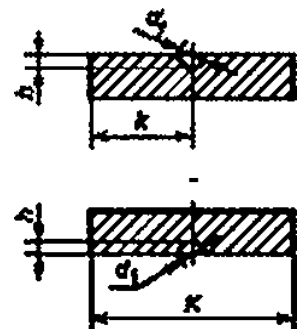
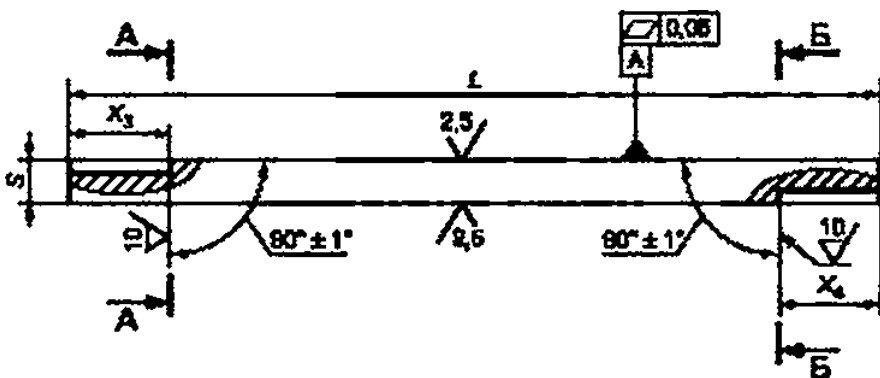
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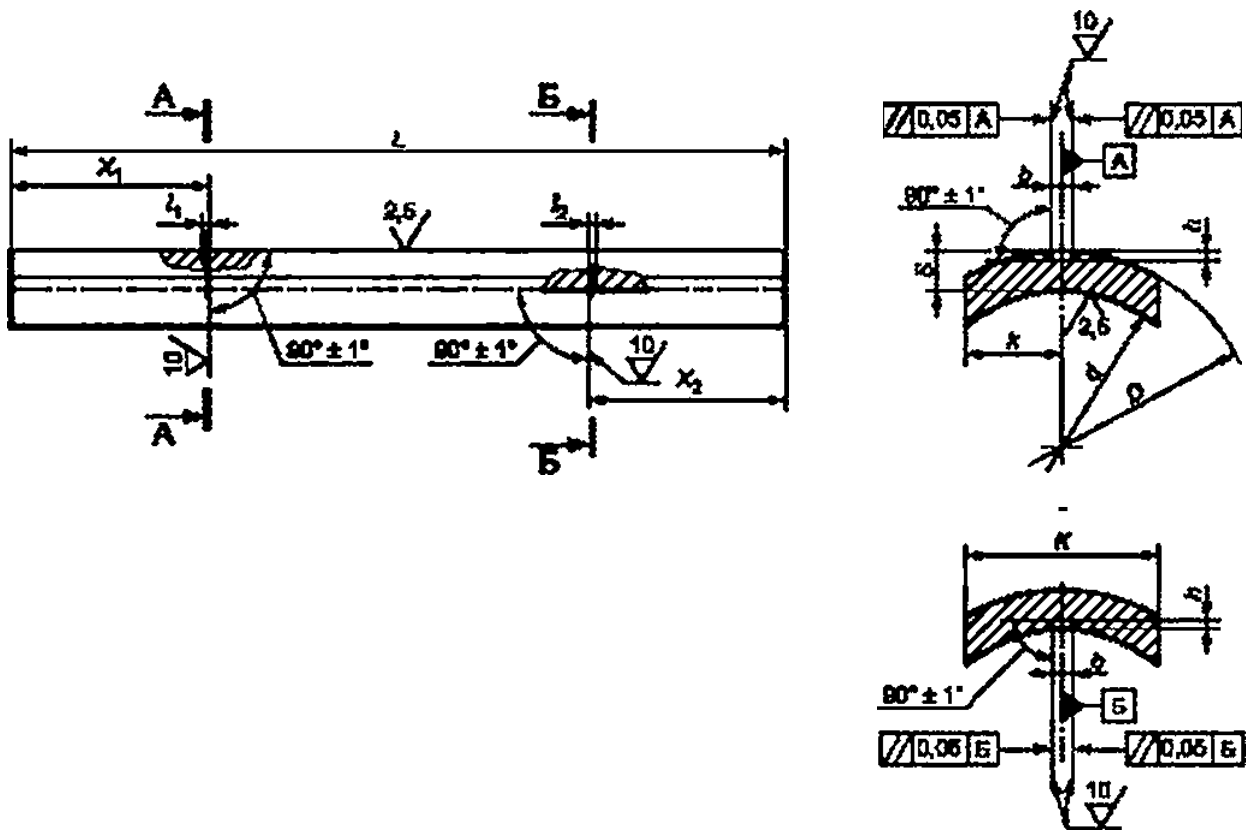
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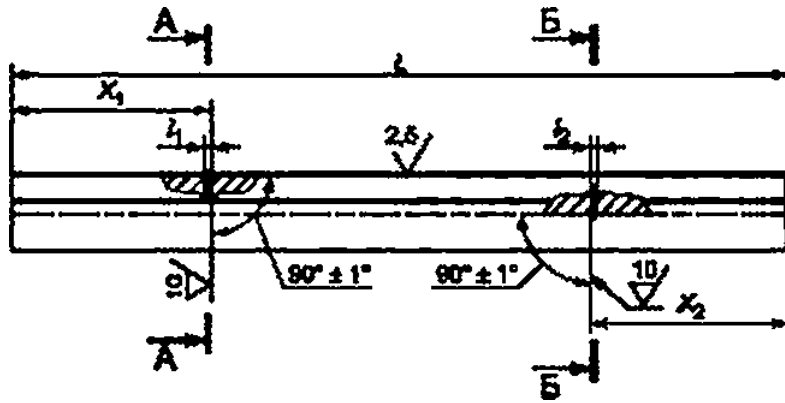
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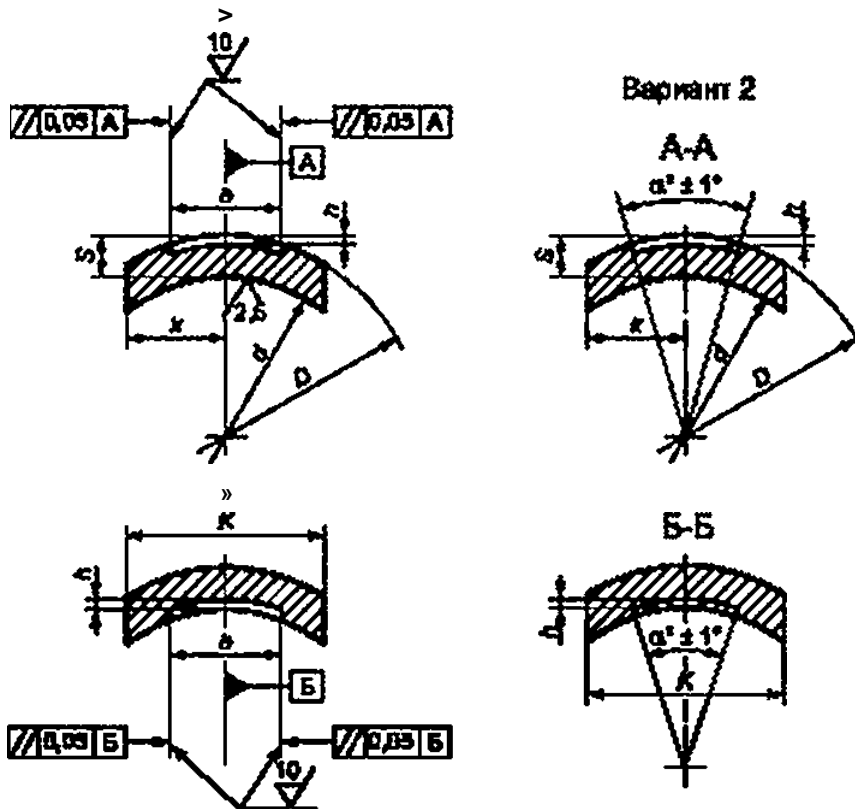
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- — ;
- l_1, l_2 — ;
- 6.8.3.1 L () ± 1.0 .
- S — , $\pm 10,0\%$.
- 6.8.3.2 h ,
- 6.8.3.3 l — ± 0.05 .
- 6.8.3.4 () ± 1.0 . X_1, X_2 — X_1, X_2 — 4
- 50,0 . 3 4 — 25,0 .
- 6.8.3.5 — $\pm 1^\circ$.
- 6.8.3.6 l_1, l_2 —
- ± 0.3
- 6.8.3.7 d_1 R — ± 0.05 . () *
- 6.8.3.8 D d — .
- 6.8.3.9 $\pm 10\%$.
- ± 0.05 .

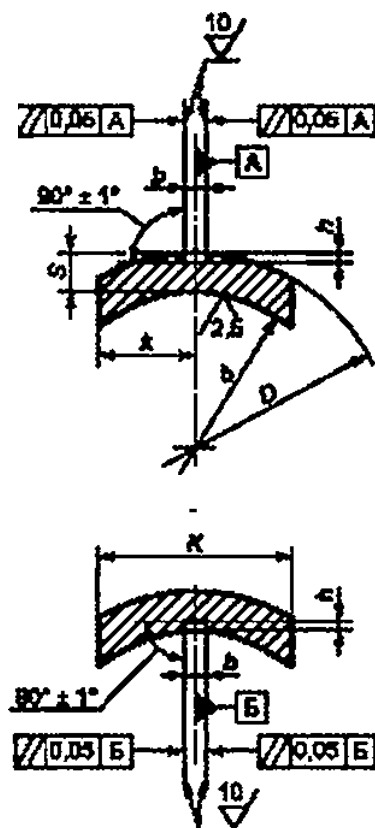
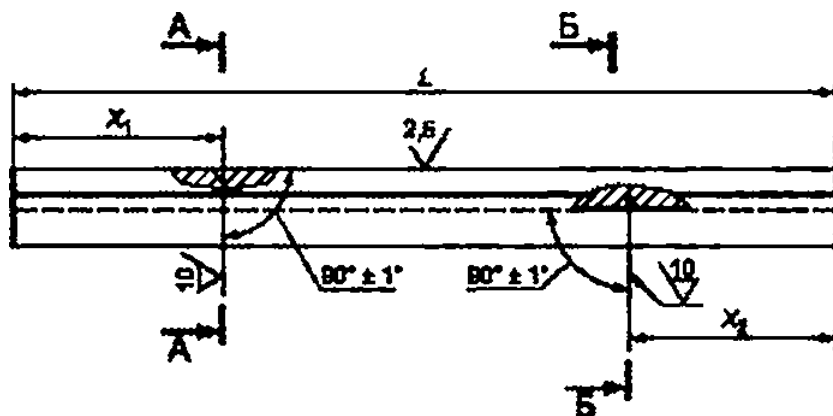


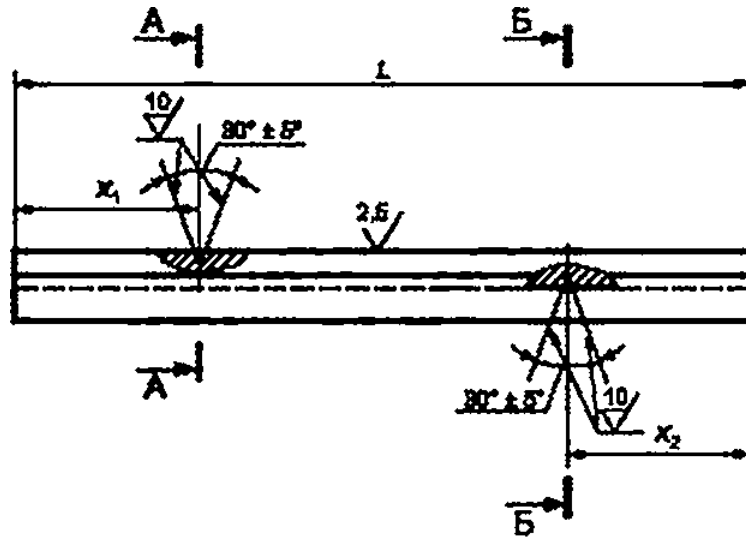


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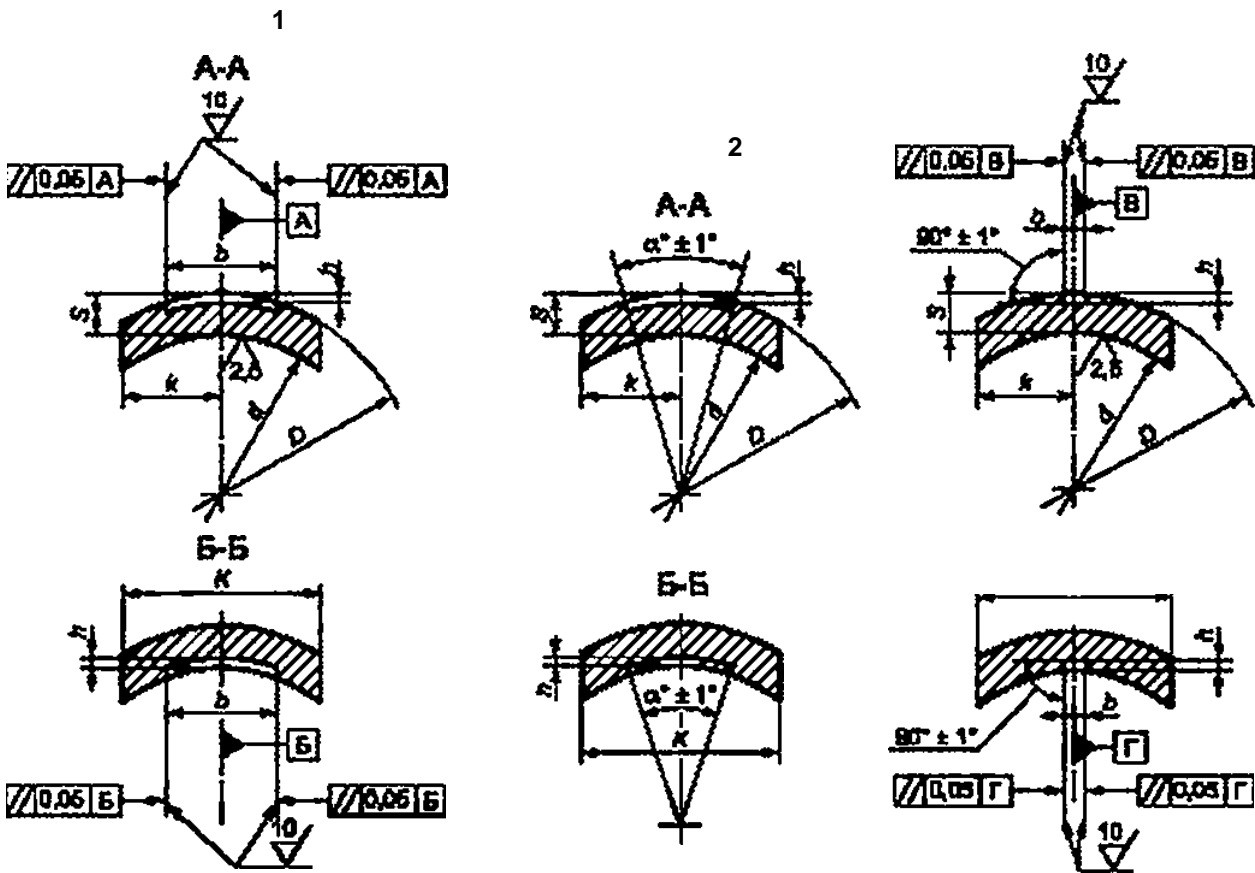


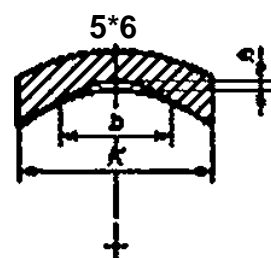
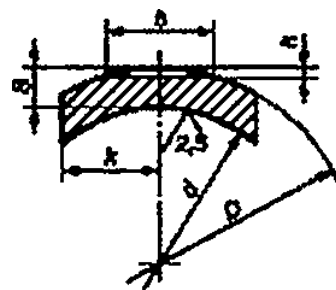
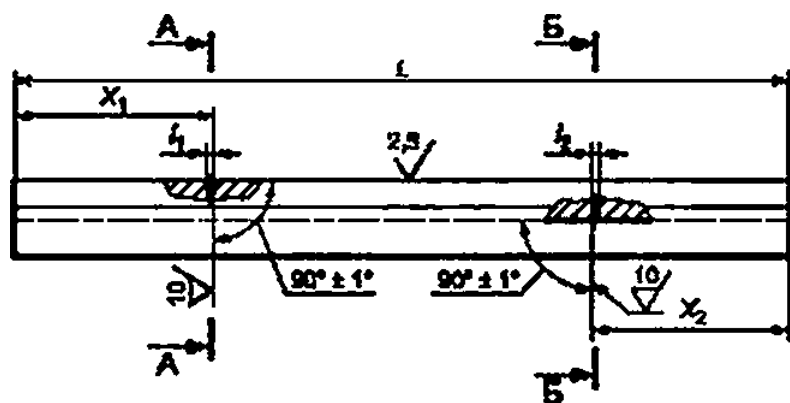
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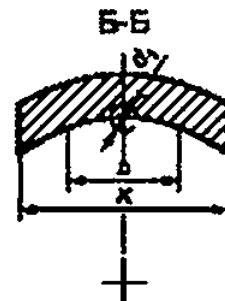
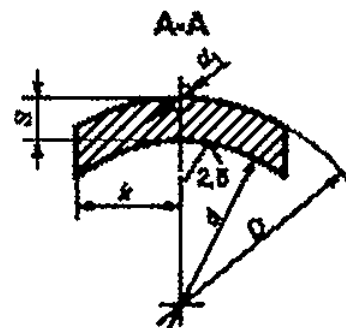
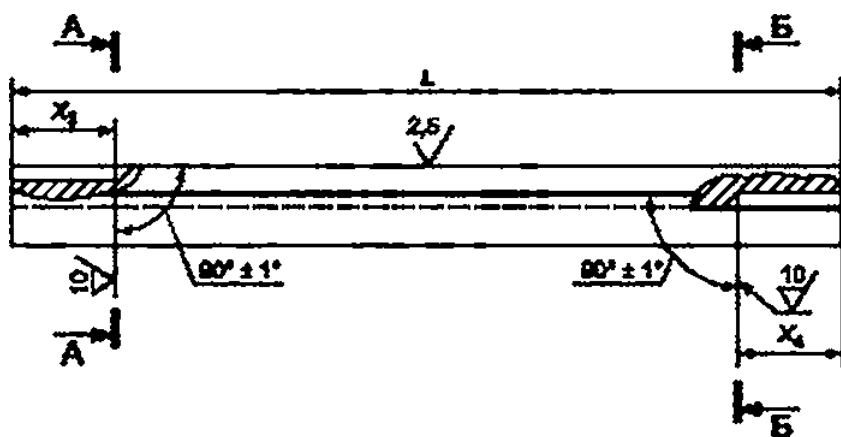


Вариант 3

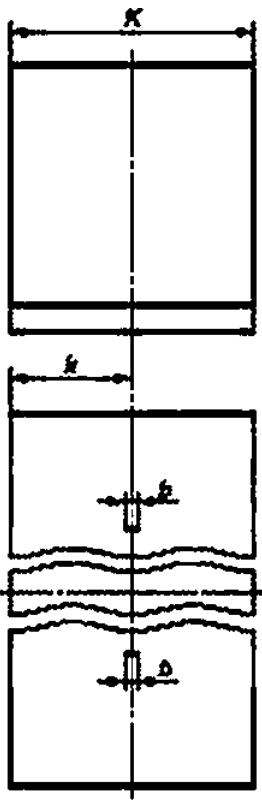




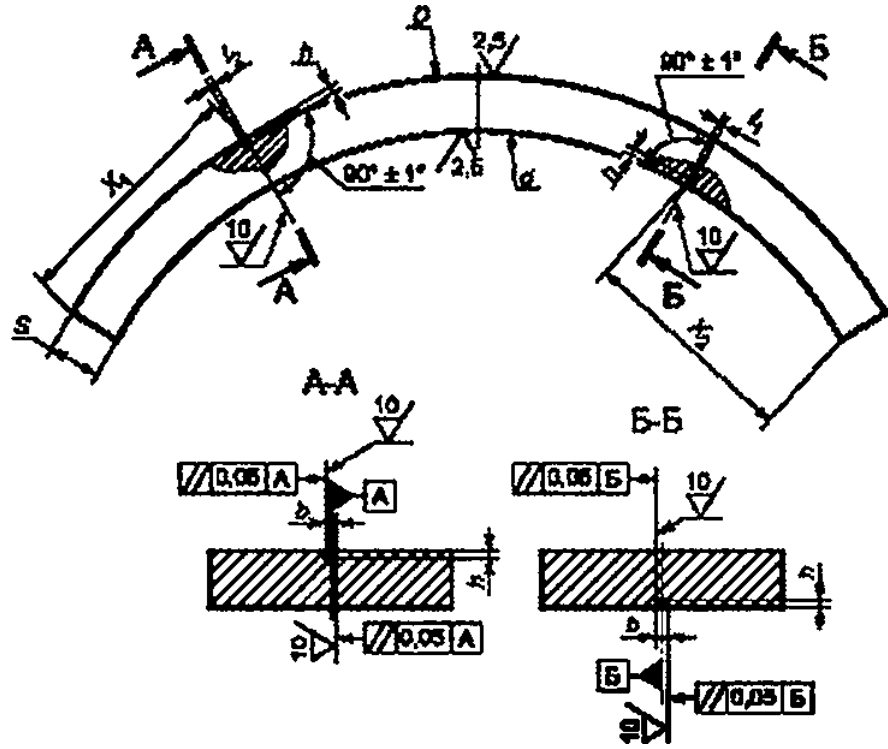
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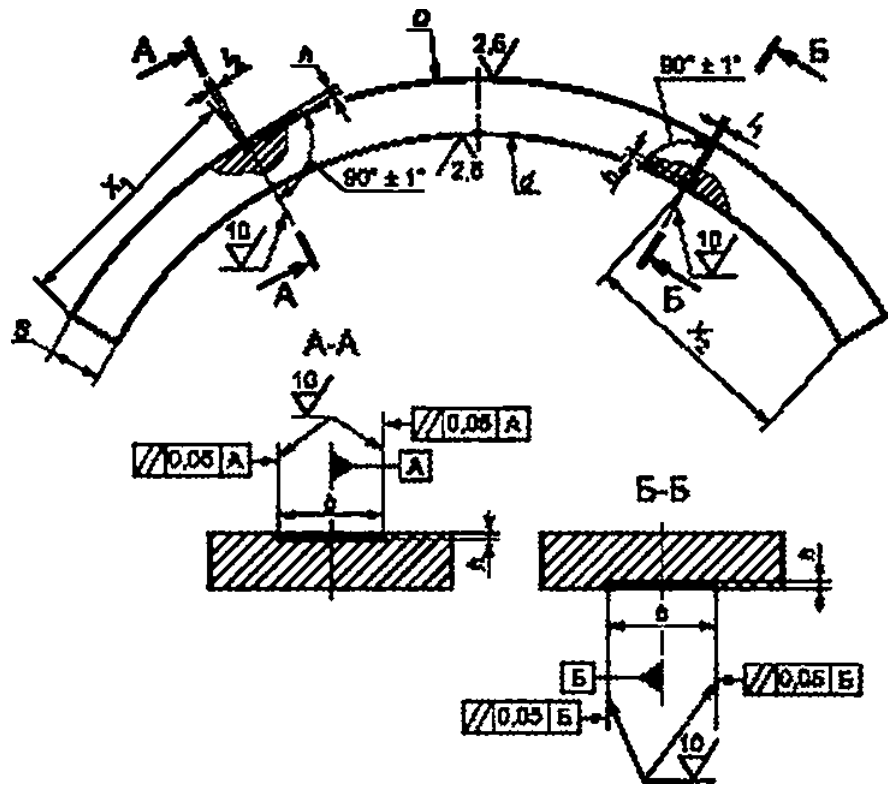
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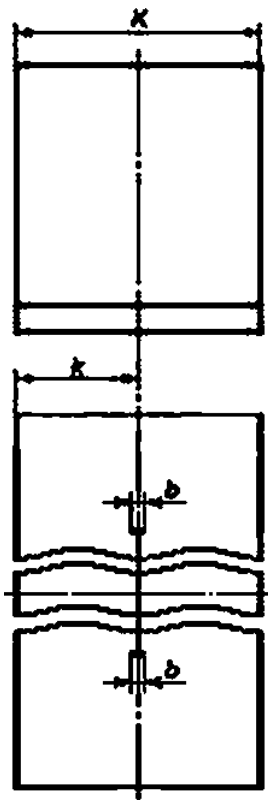
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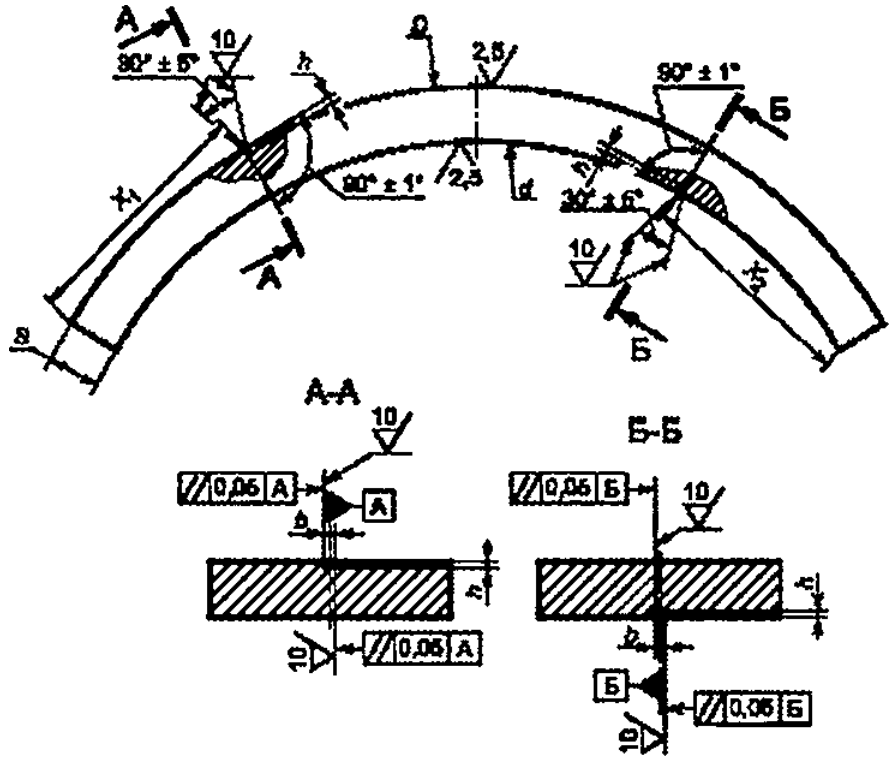
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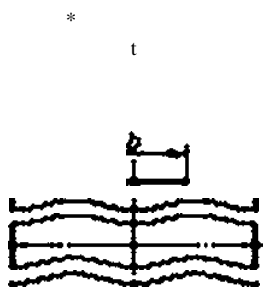
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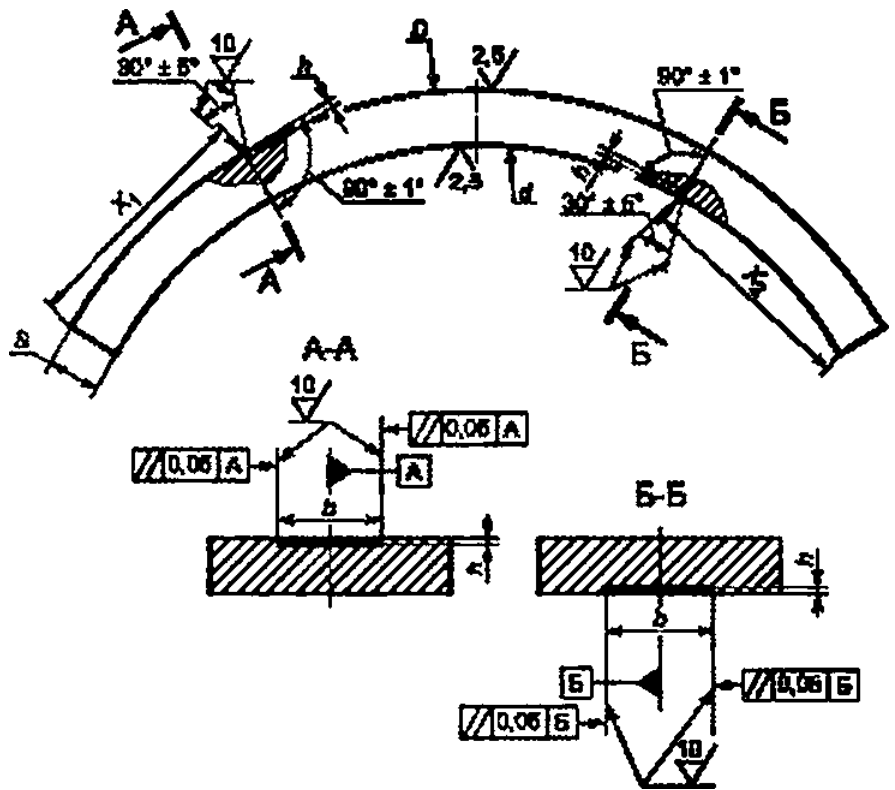
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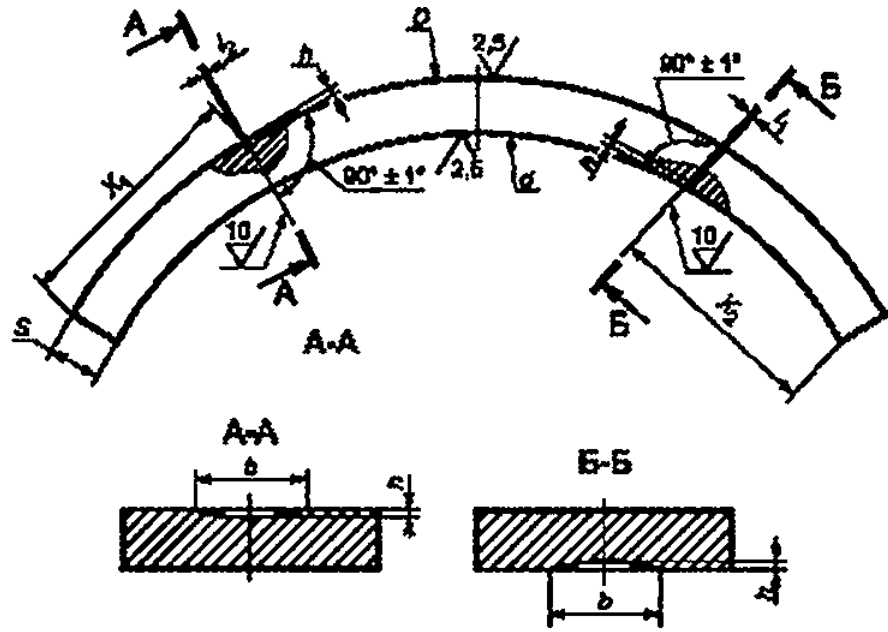
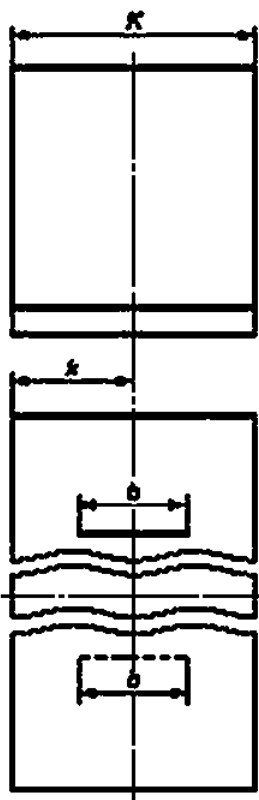
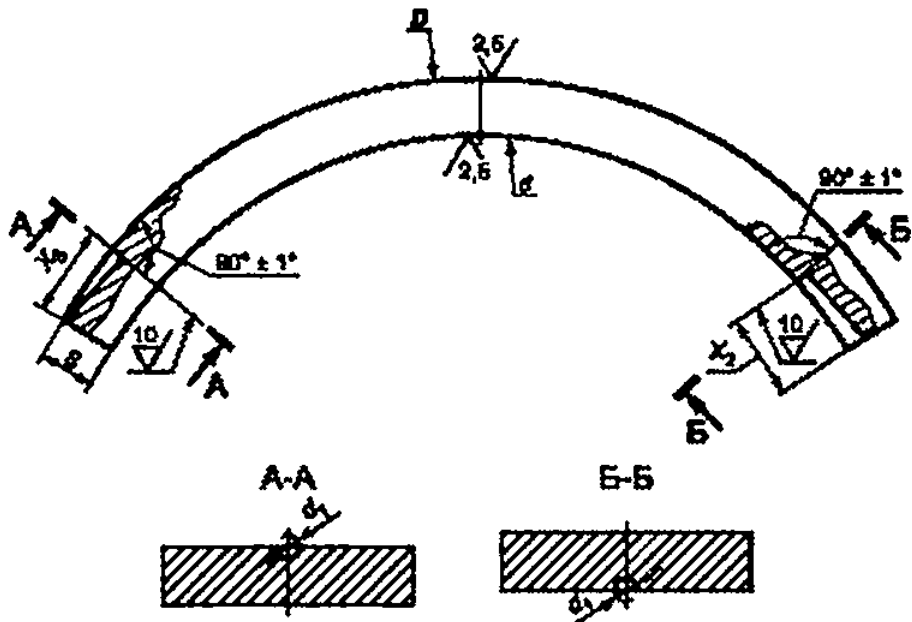
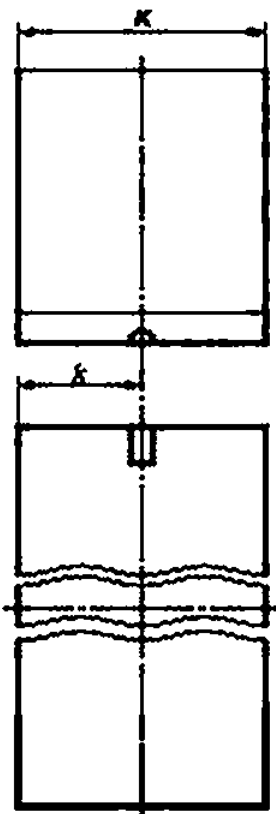


Рисунок 26 — Настроечный образец с сегментными пазами, выполненными вдоль оси гнуть (гиба)

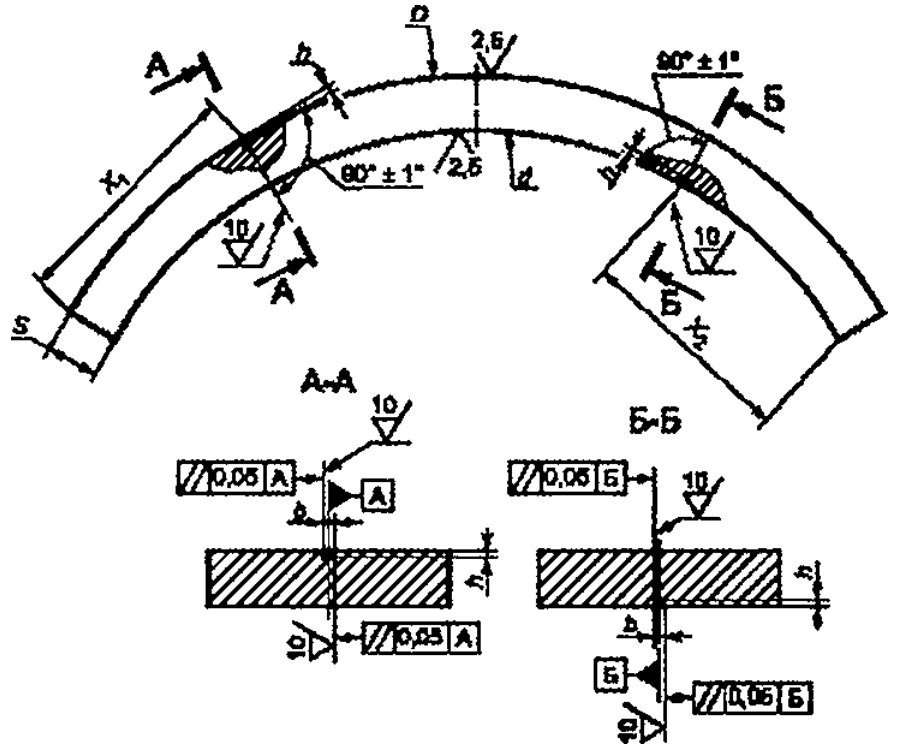


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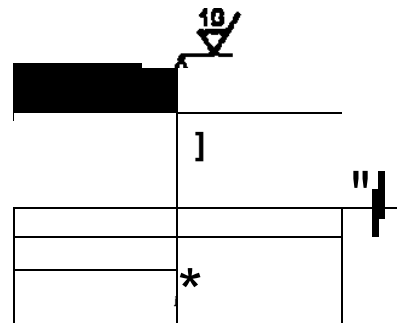
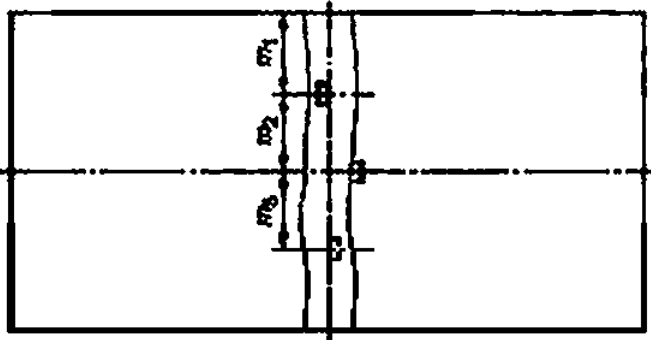
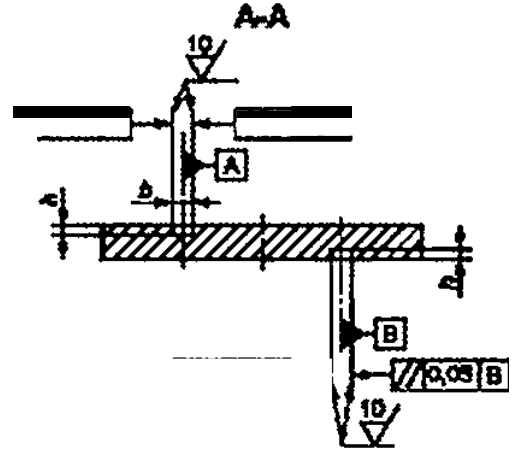
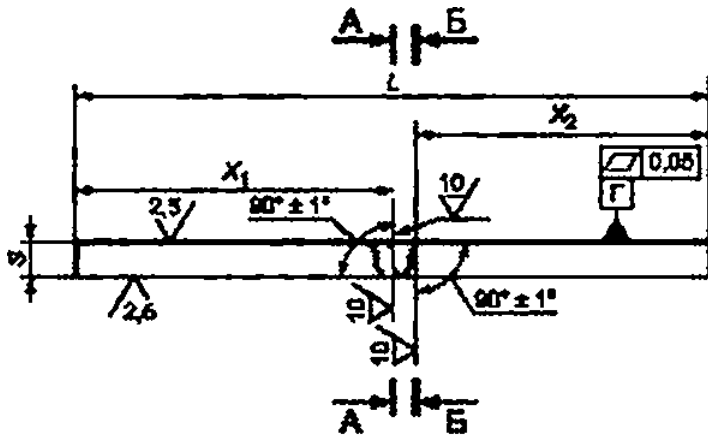
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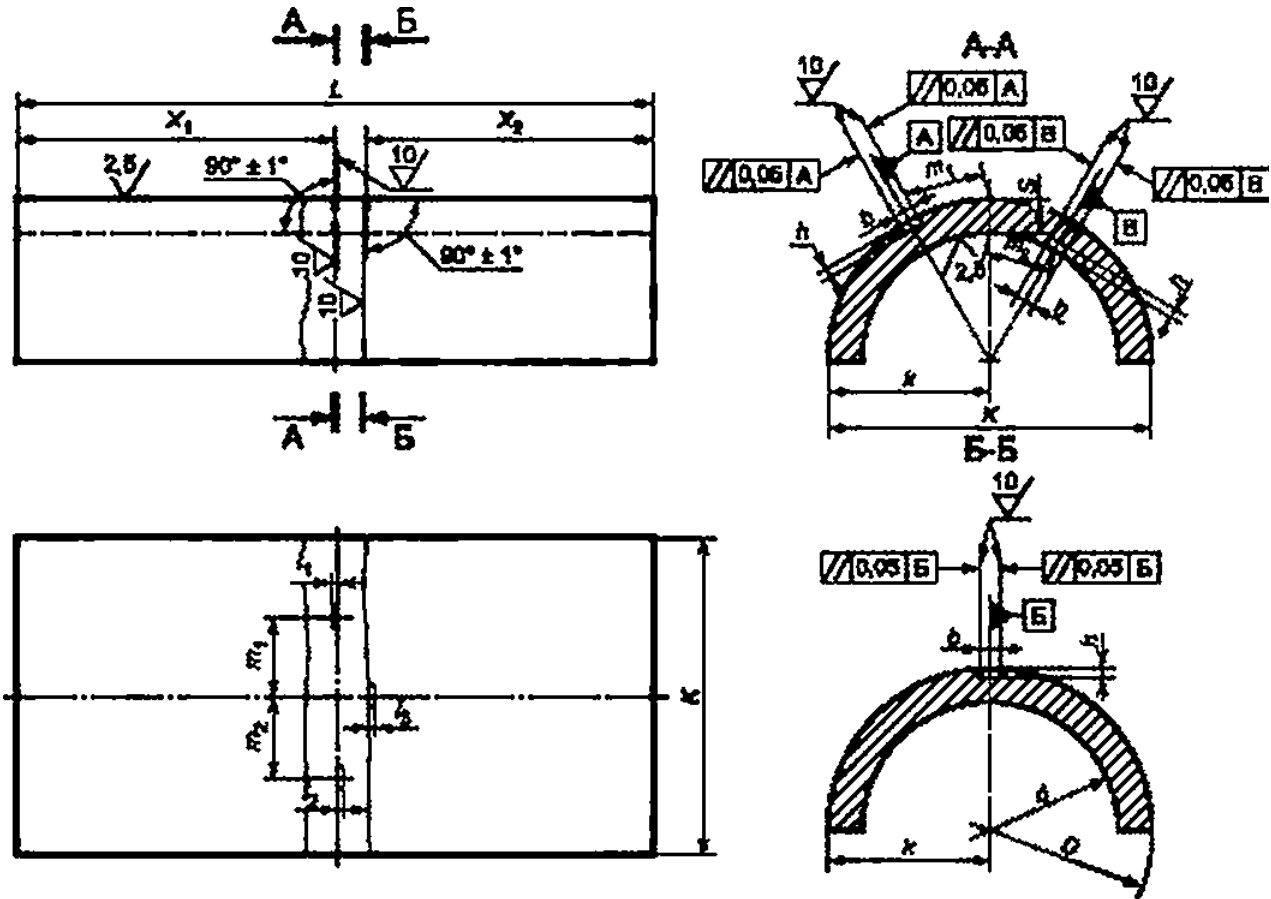
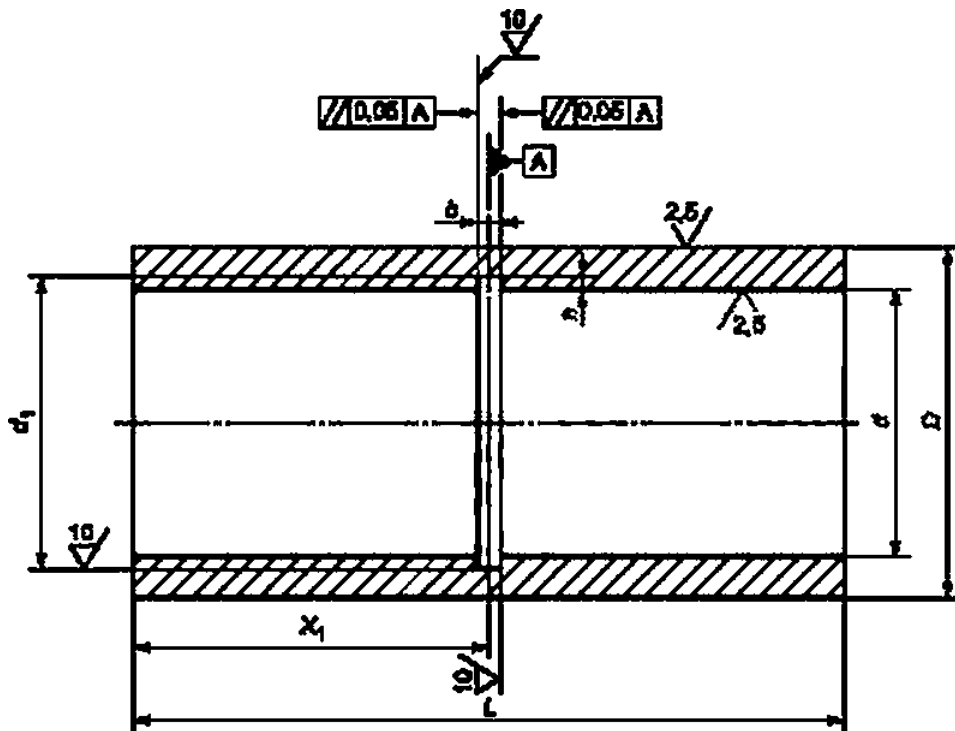


Рисунок 30 — Настраиваемый образец с пазами для ультразвукового контроля аустенитных сварных соединений



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6.9.1 32—39

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- — ;
- h— , ;
- S,— , ;
- — , ;
- — , ;
- l_1 — , ;
- — , ;
- /— , ;
- h_u — , ;
- Z— , ;
- b— , .

6.9.1.1 L ±10,0 % ±10,0 % ±1,0 .

6.9.1.2

— ±0,05 . *

6.9.1.3 d, — ±0,05 .

6.9.1.4 D — *

, 110,0 %.

6.9.1.5 — ±15'.

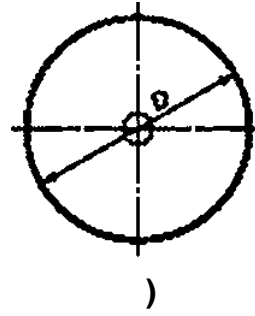
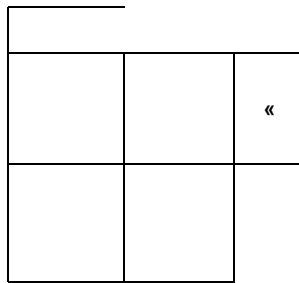
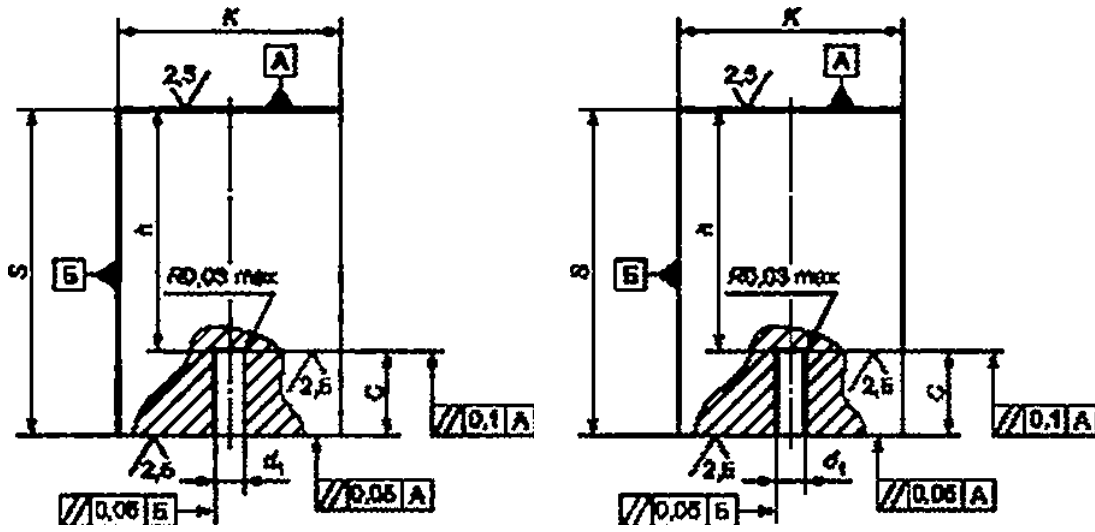
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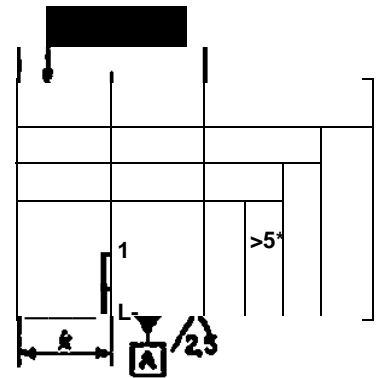
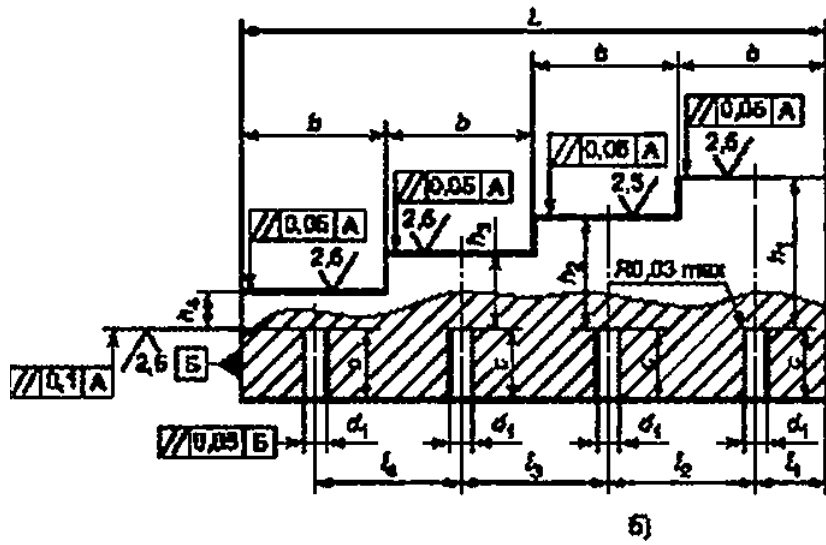
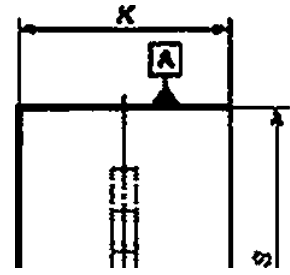
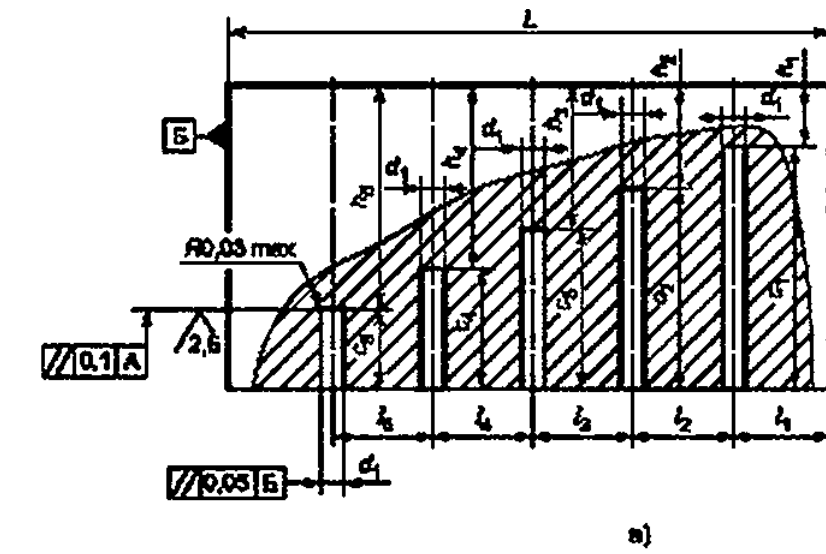
±0.2 .

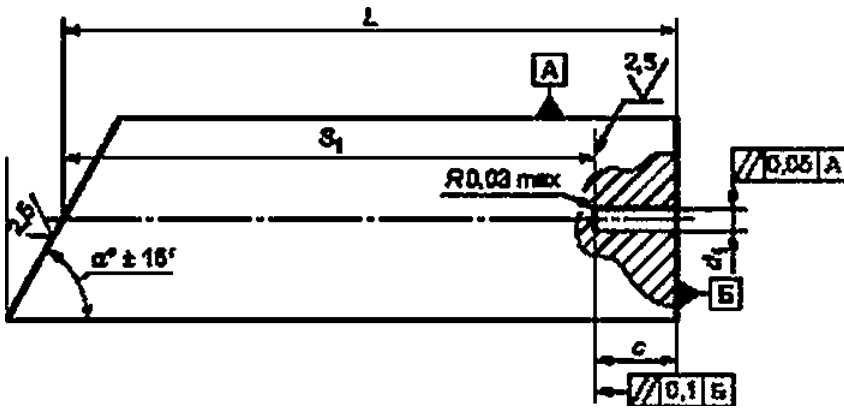
6.9.1.7 - -

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6.9.1.9

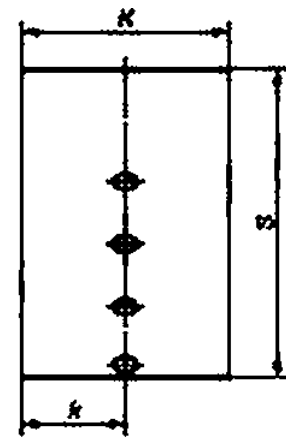
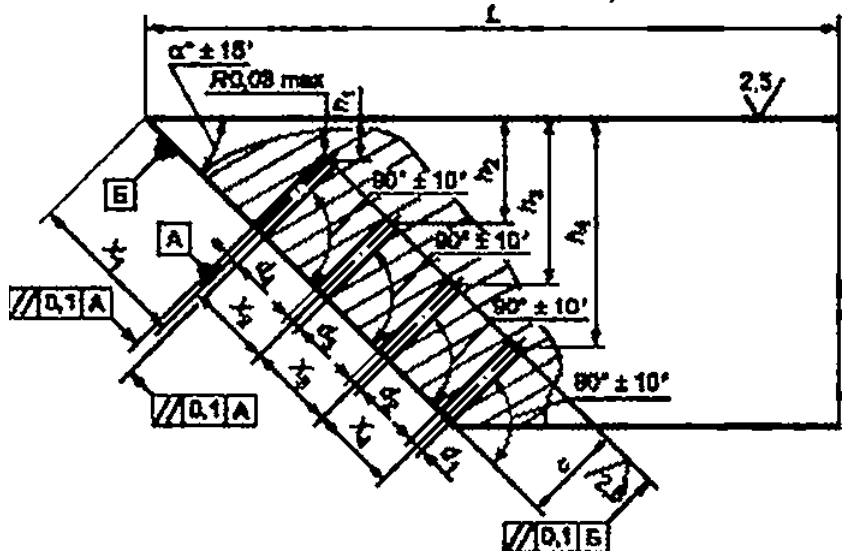




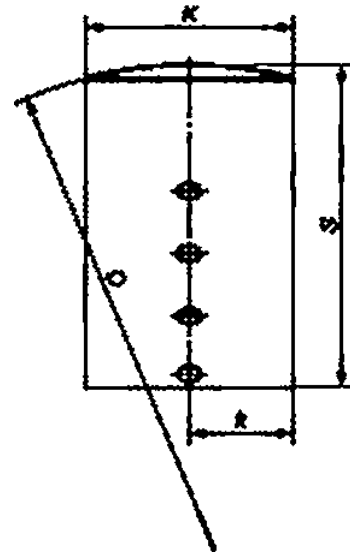
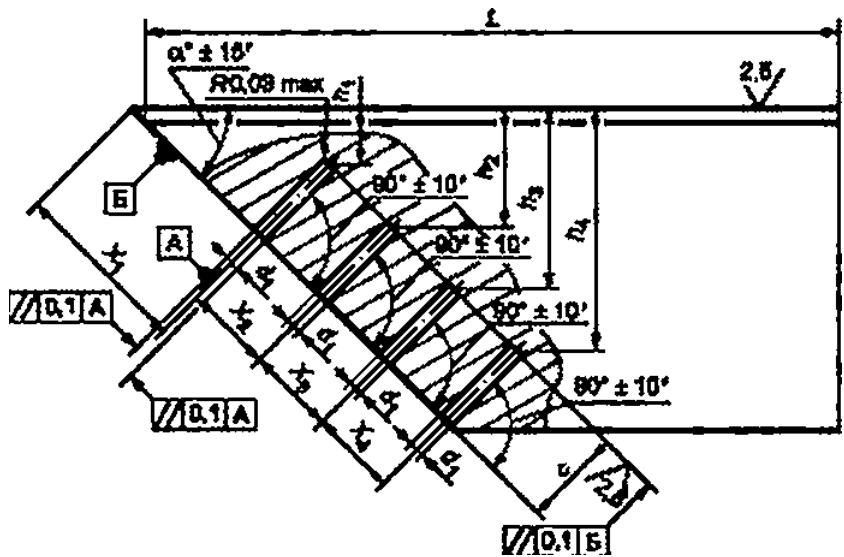


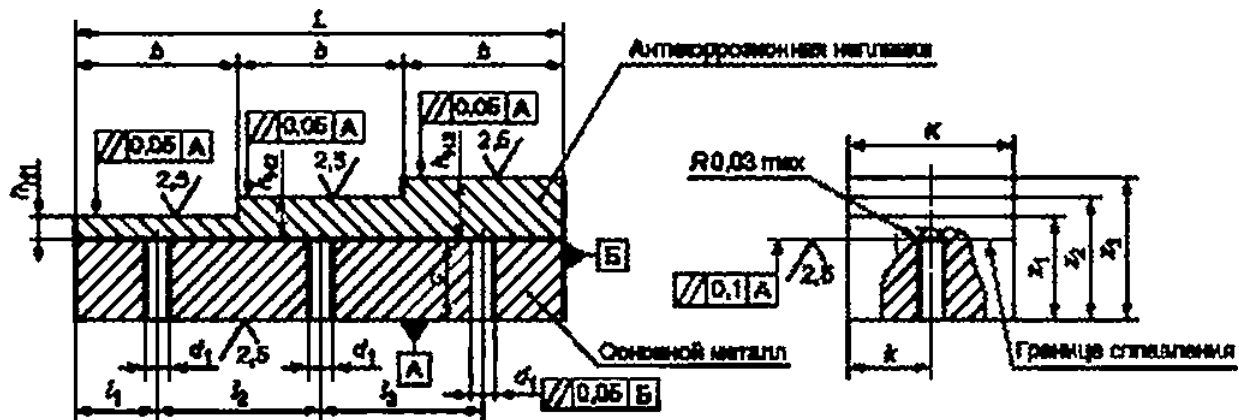
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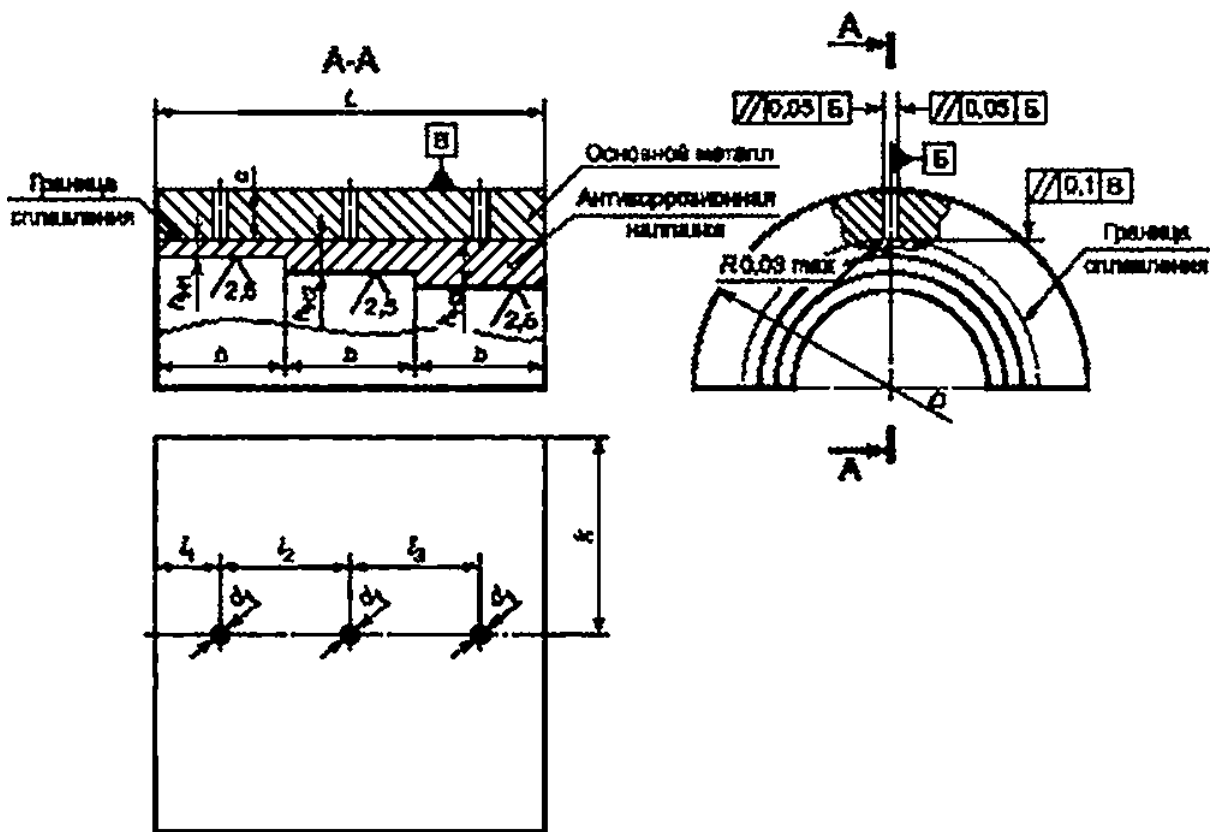


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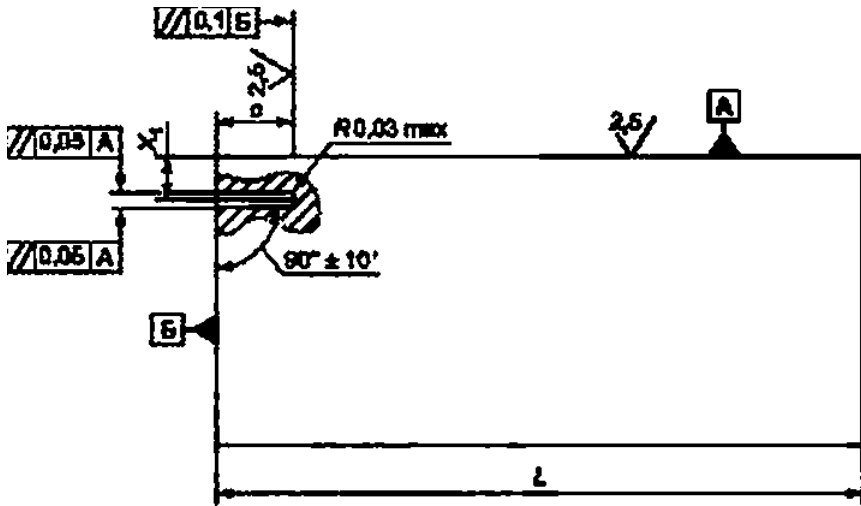




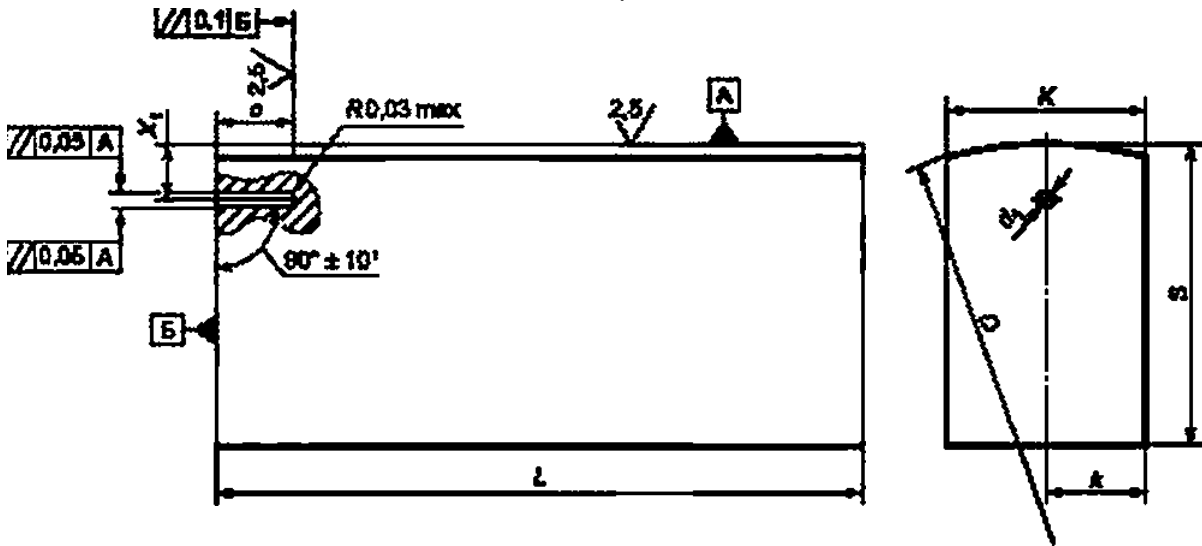
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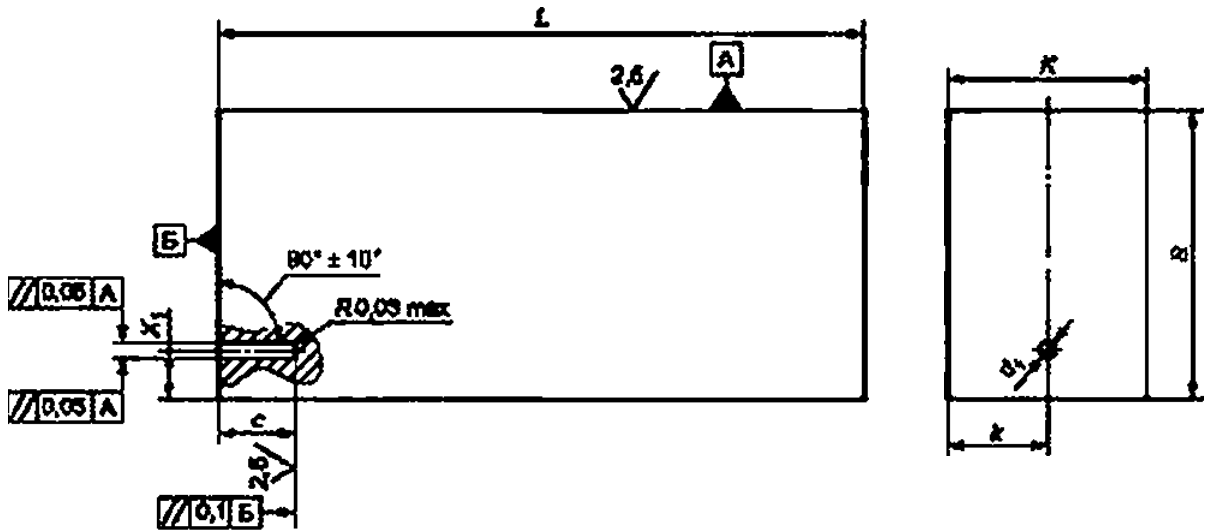


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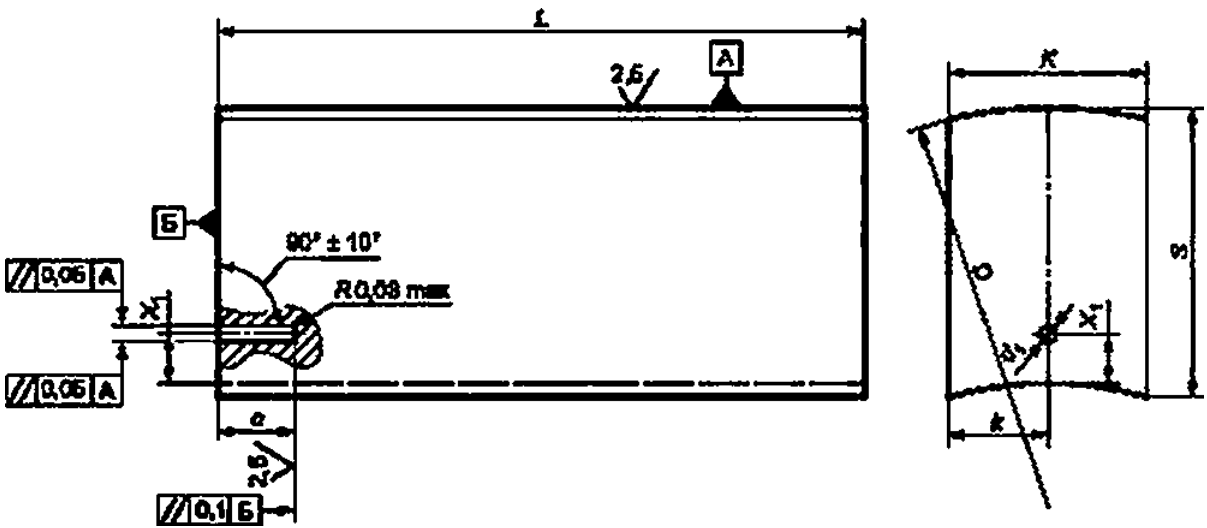


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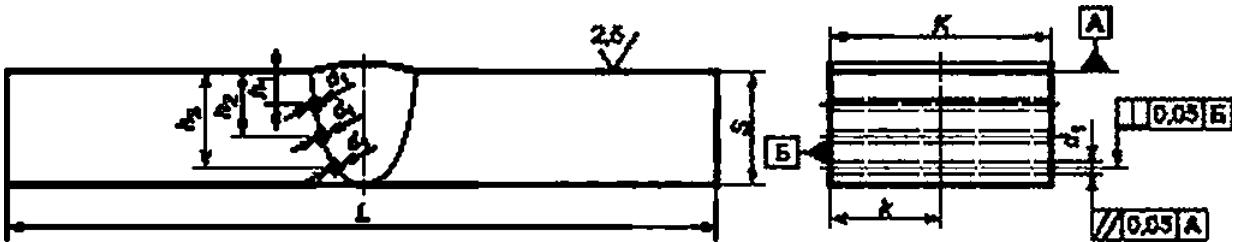
* —
* —
* d —
* d, —

6.10.1 S — L ()! 1,0 *

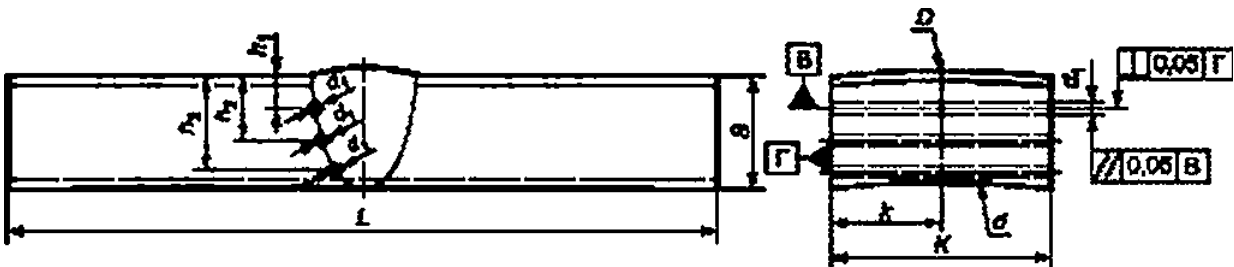
6.10.2 — ± 0.05 110,0 %

6.10.3 d, — ± 0.05

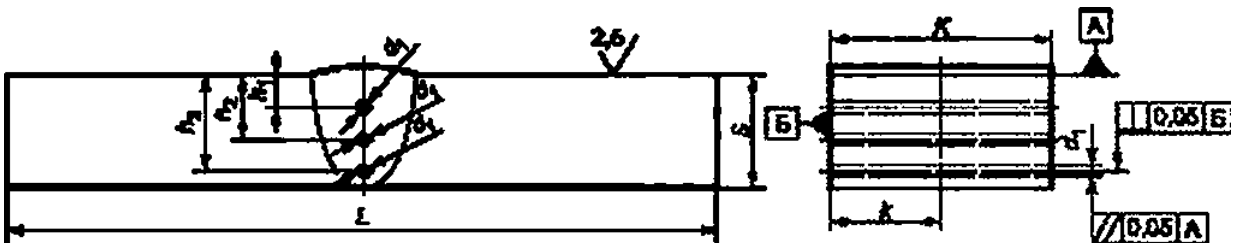
6.10.4 D d — ± 10,0 %.



)

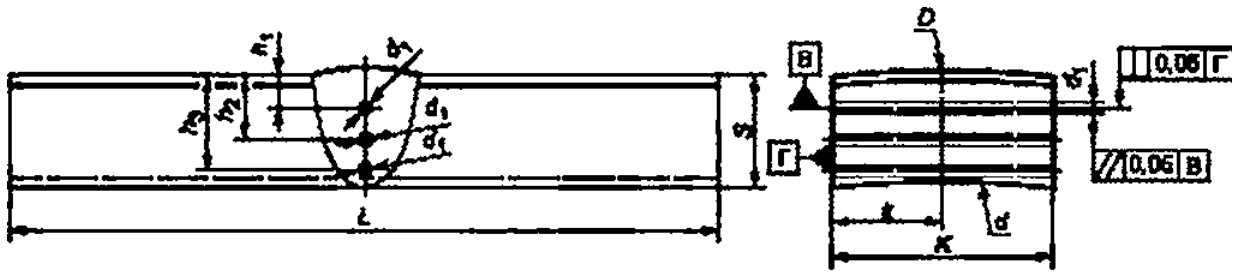


6)

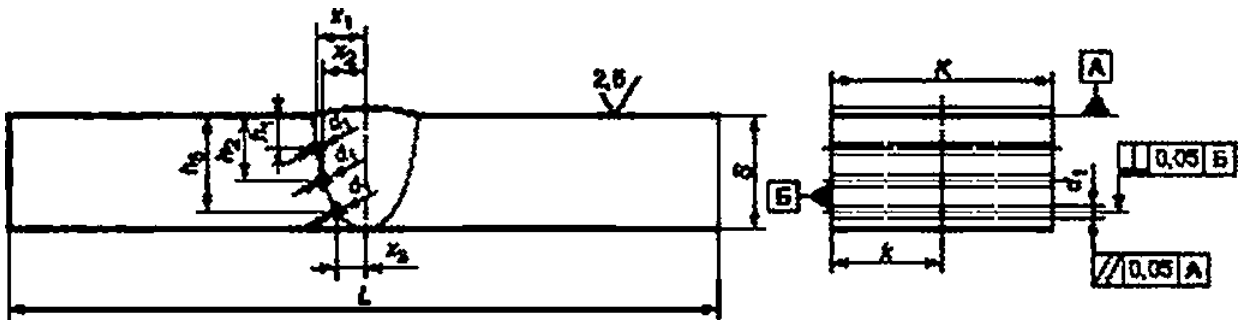


в) НО для УЗК АСС плоскопараллельных ОК с усилением и расположением БЦО по центру СС

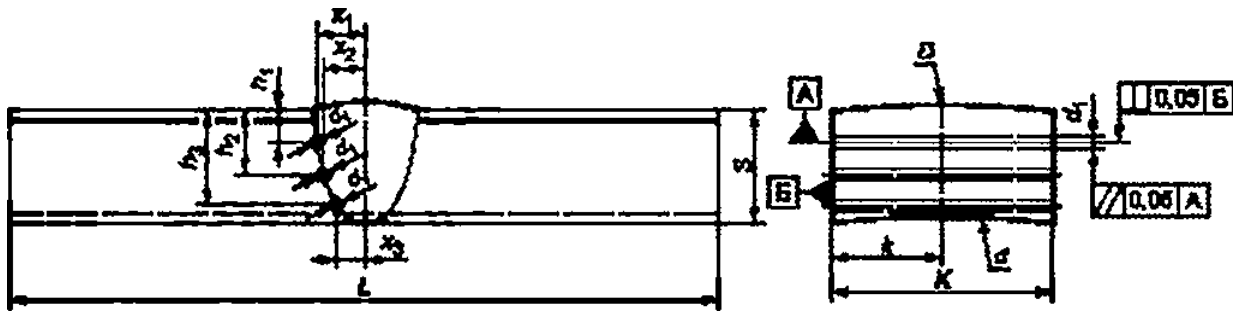
40. 1 —



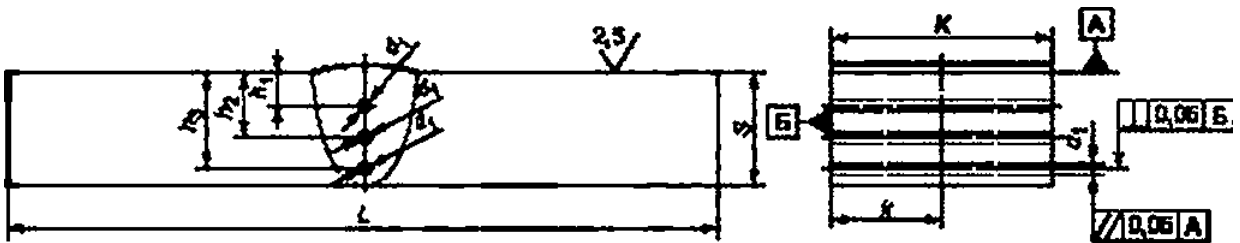
г) НО для УЗК АСС цилиндрических ОК с усилением и расположением БЦО по центру СС



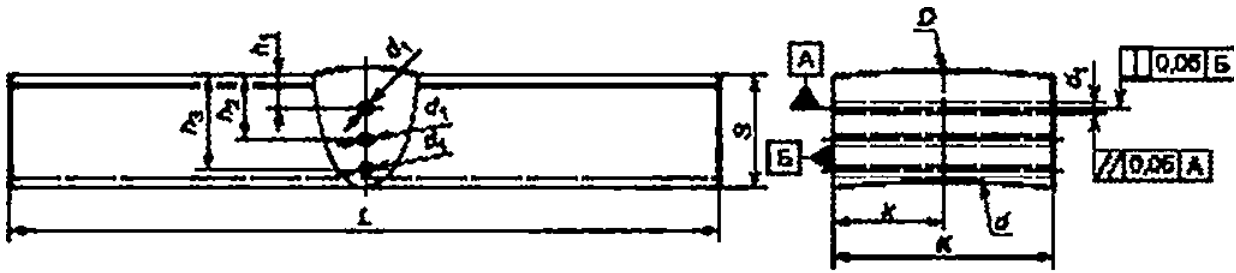
)



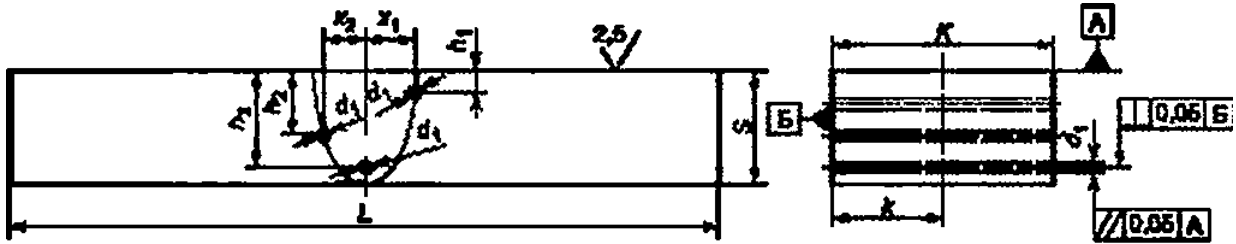
)



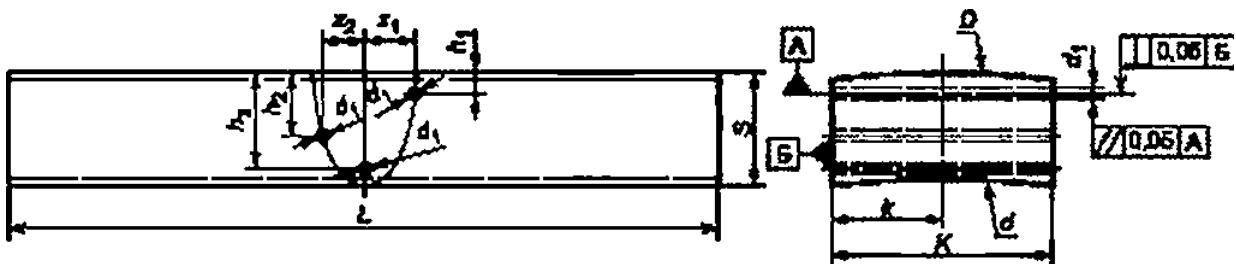
ж) НО для УЗК АСС плоскопараллельных ОК со снятым усилением и расположением БЦО по центру СС



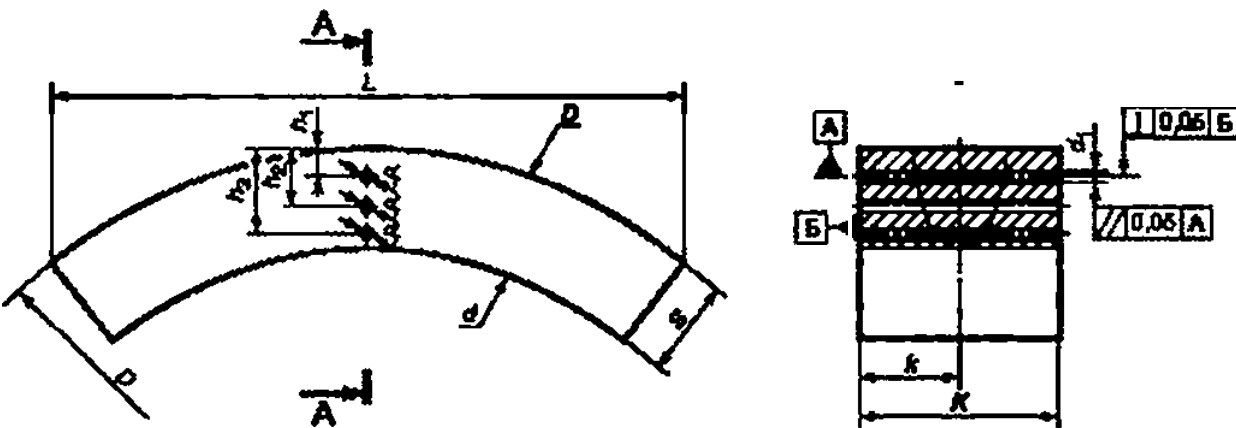
и) НО для УЗК АСС цилиндрических ОК со снятым усилением и расположением БЦО по центру СС



к) НО для УЗК АСС плоскопараллельных ОК со снятым усилением и различным расположением БЦО в СС



л) НО для УЗК АСС цилиндрических ОК со снятым усилением и различным расположением БЦО в СС



40. 3

6.11

41—51.

* L—

• —

- S—
- —

- h—
- D—
- d—
- h_H—
- —
- bi—
- l—
- b—

6.11.1 S—

6.11.2

6.11.3

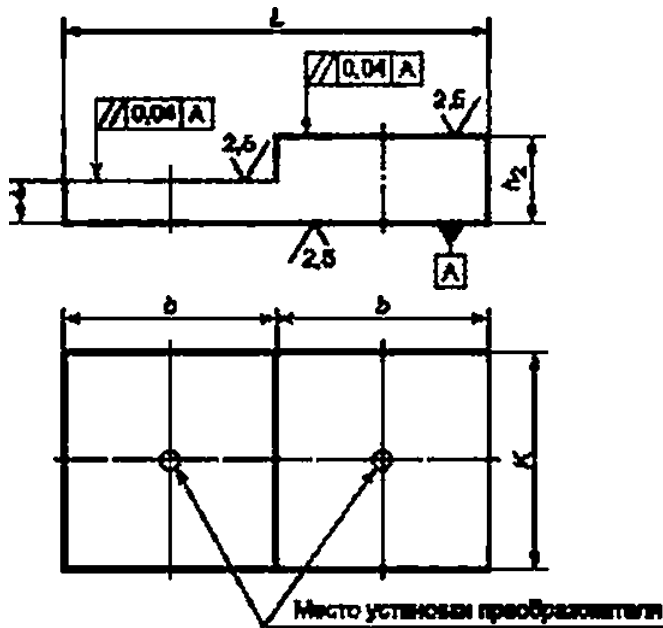
6.11.4

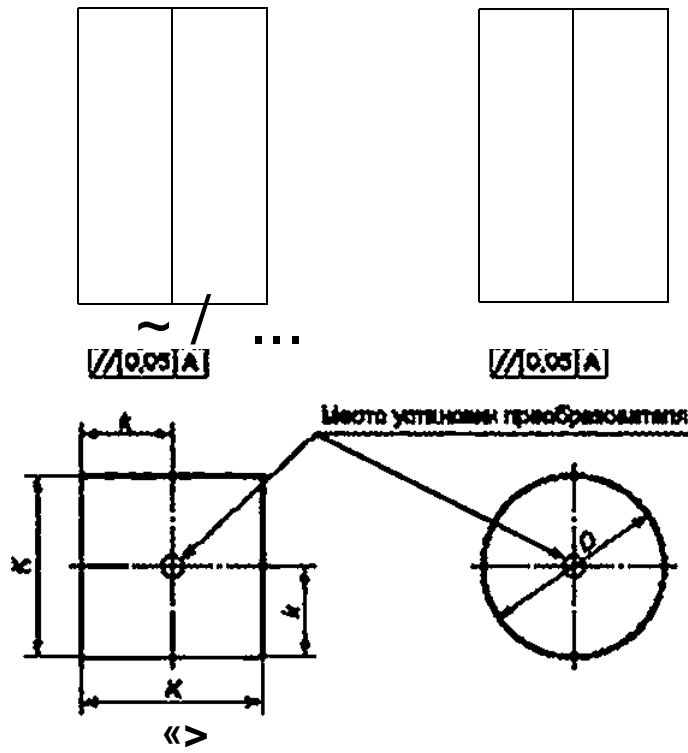
6.11.5

6.11.6

6.11.7

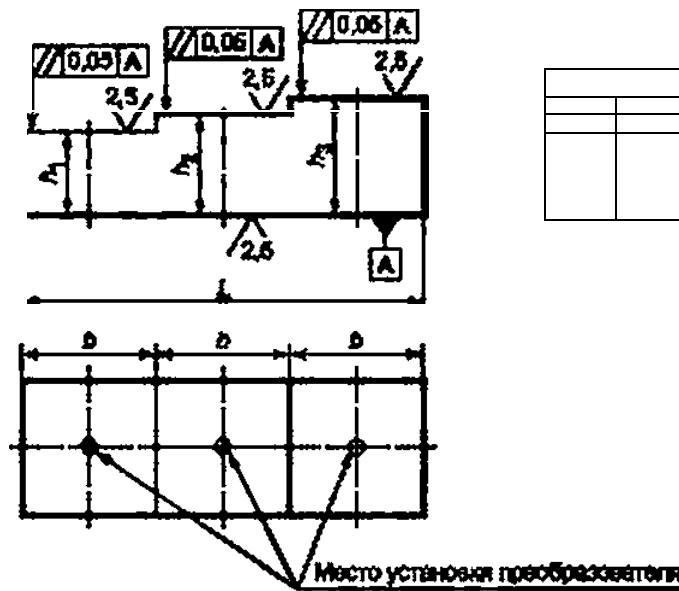
L ±1.0
 110,0%
 D d—
 ±10,0%
 ±0.02
 11.0
 ±0.05
 ±1.0





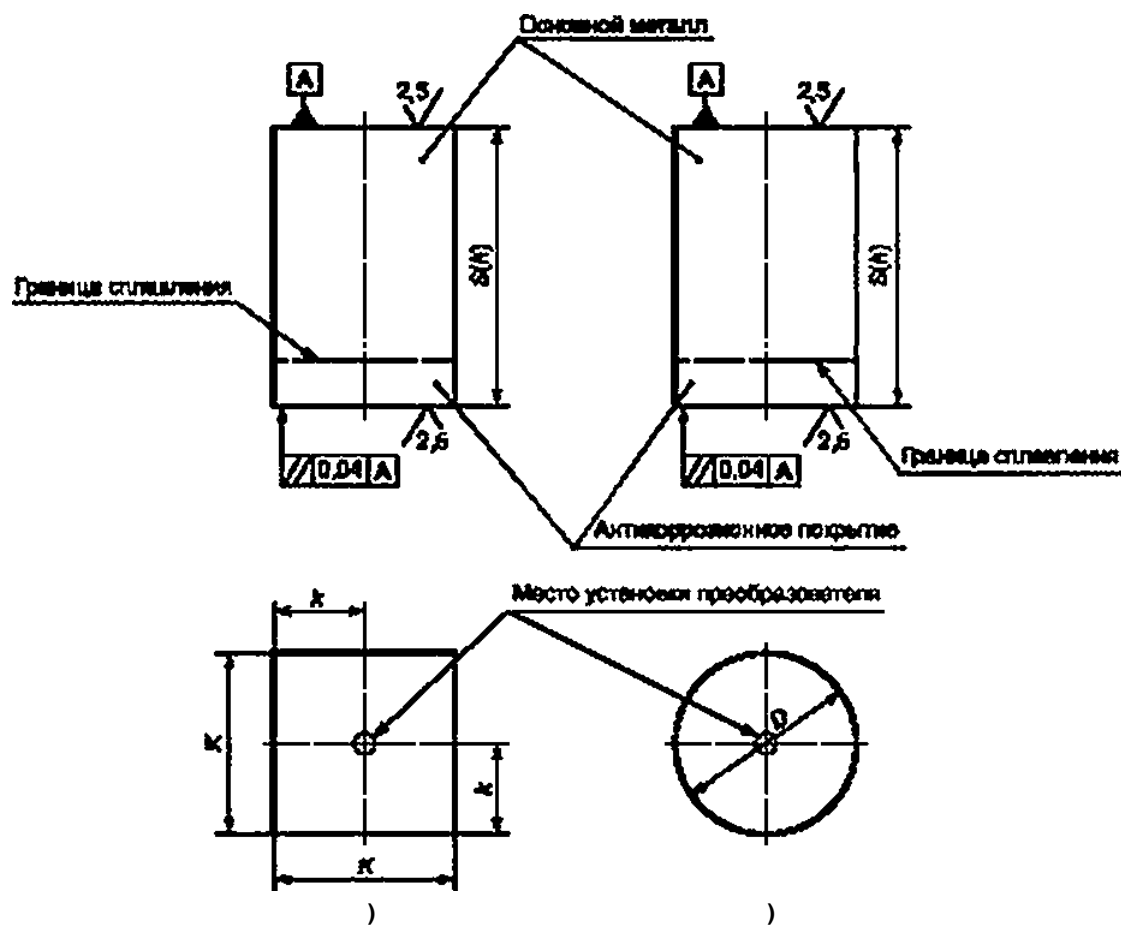
42 —

(2)



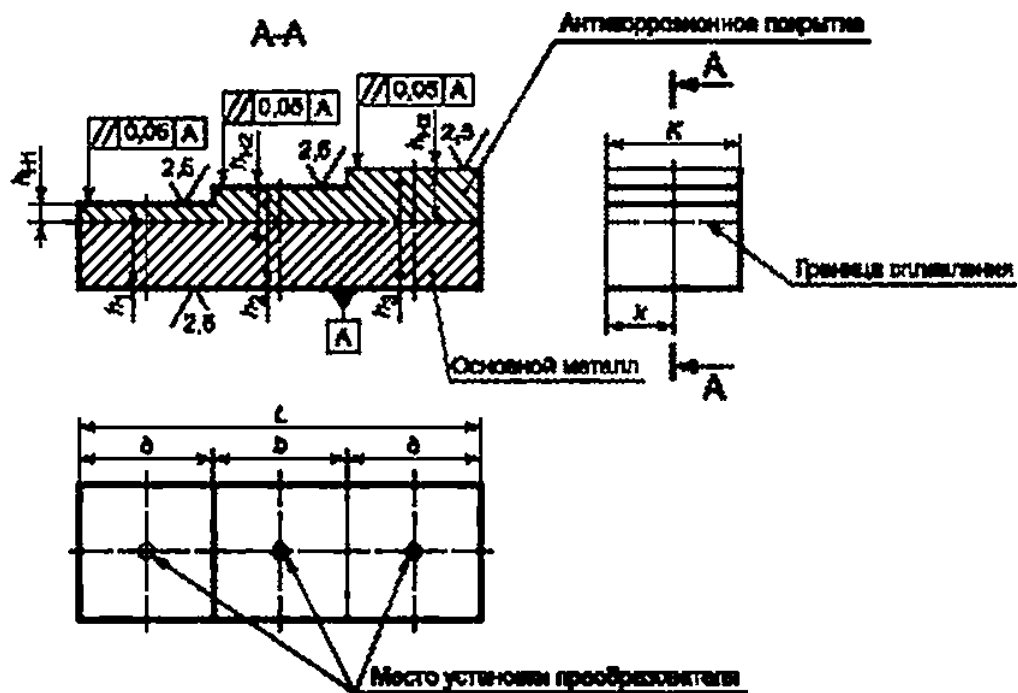
43 —

(-1)

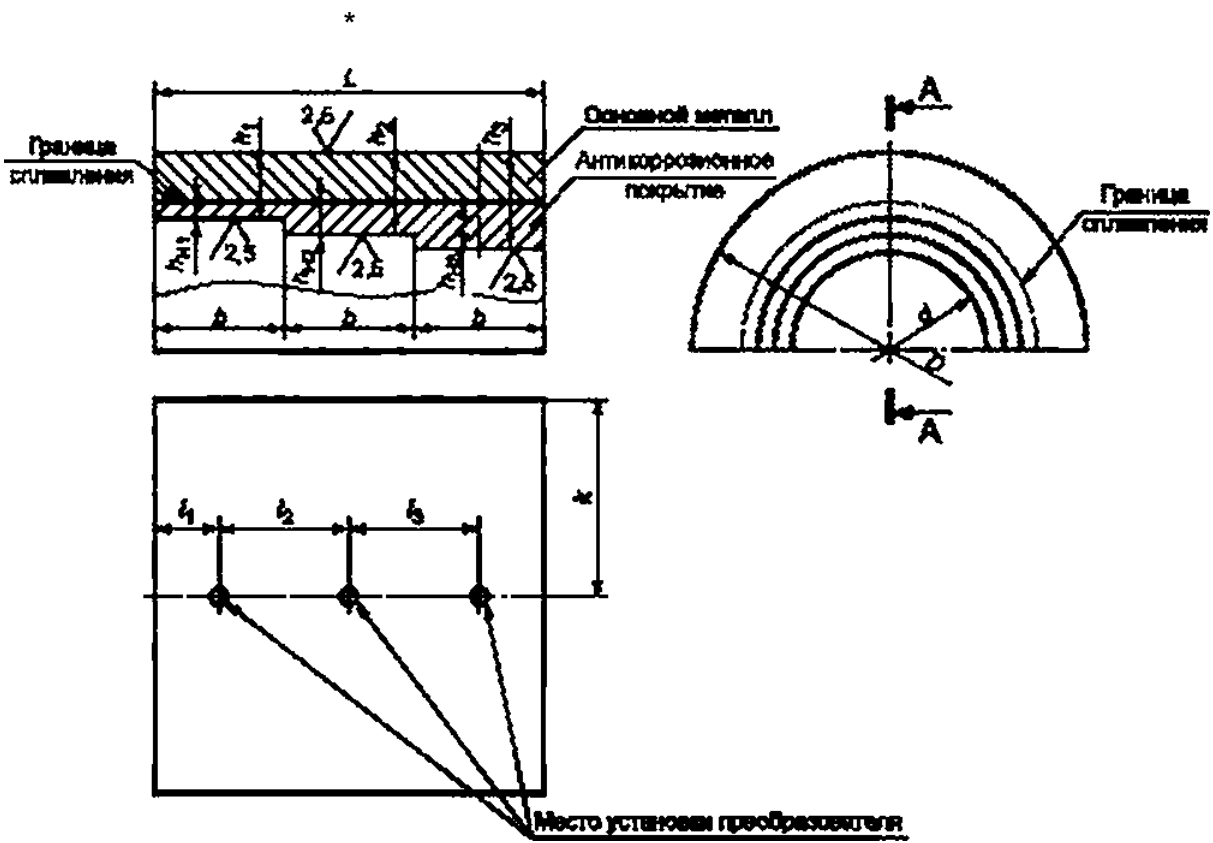


44 —

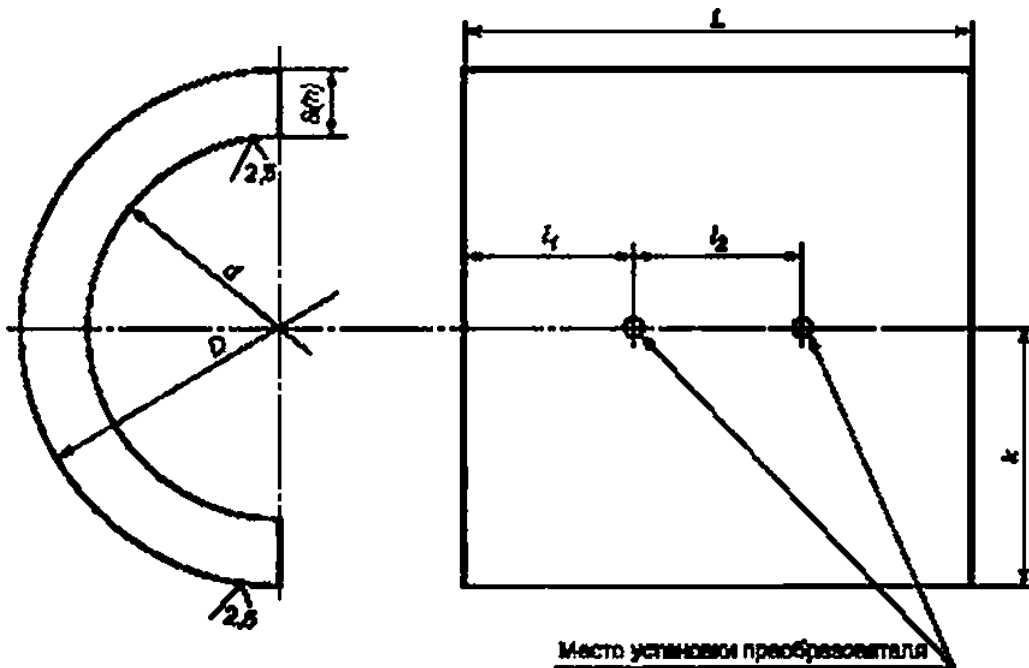
(-1)



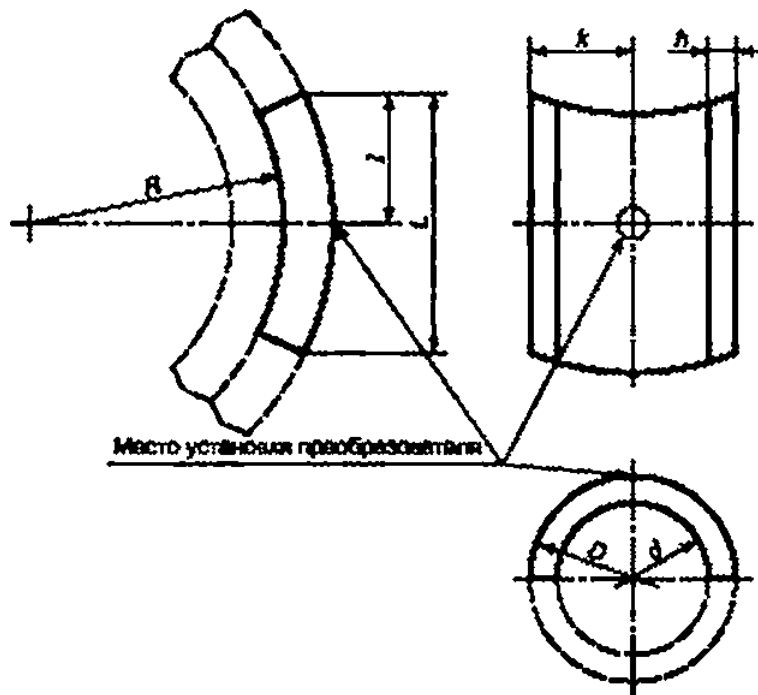
45 —



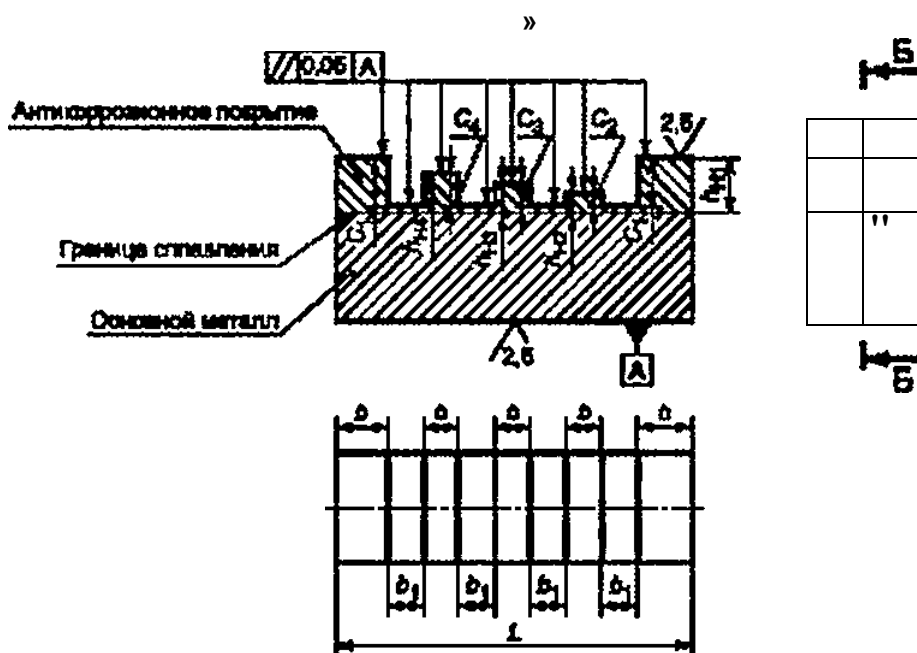
46 —



47 —

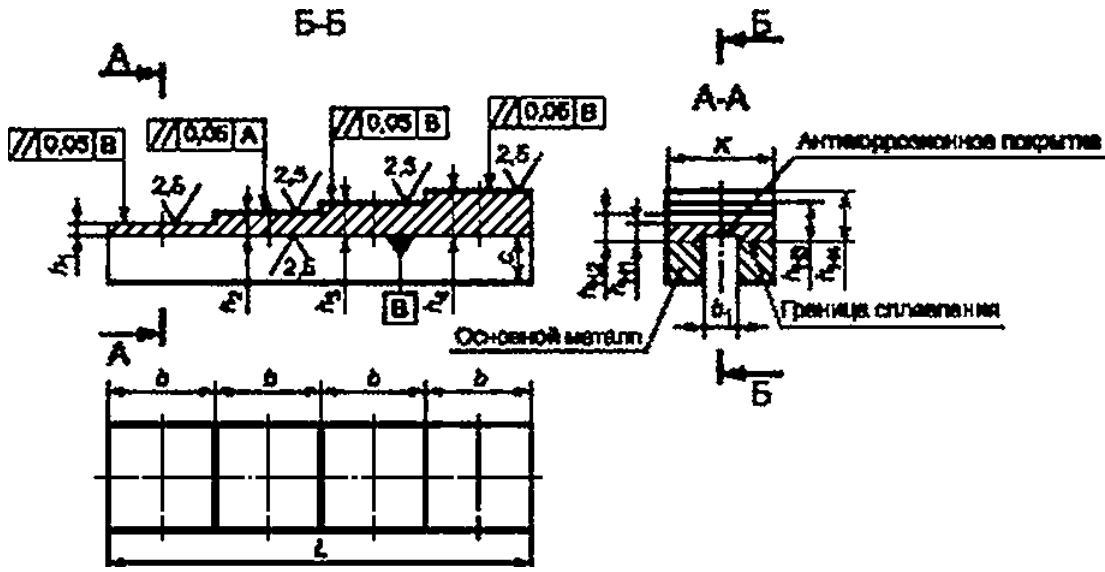


48 —



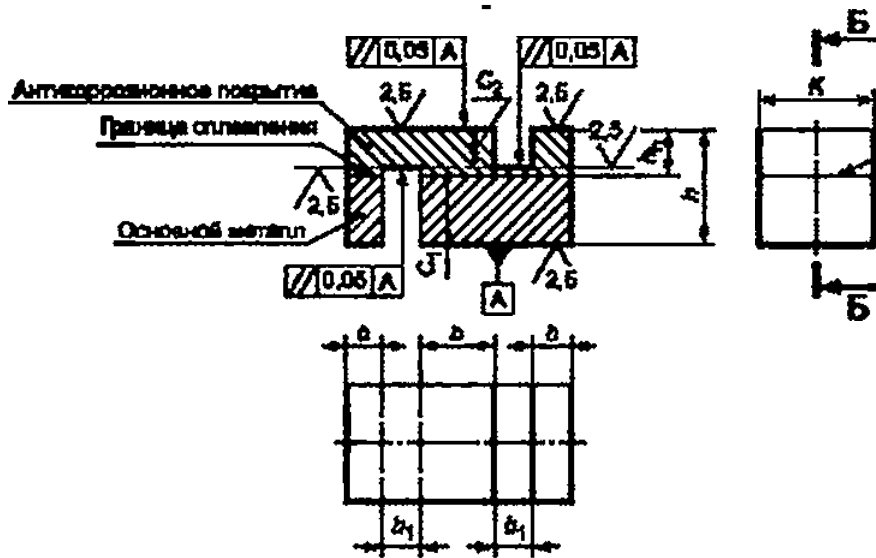
49 —

(TH 1)



50 —

(2)



51 —

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6.12

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(,)

- 2 (52).

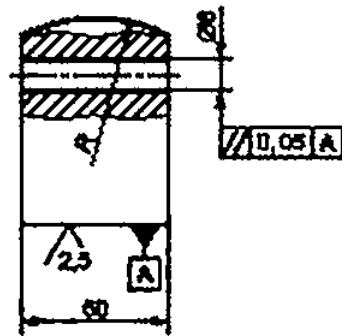
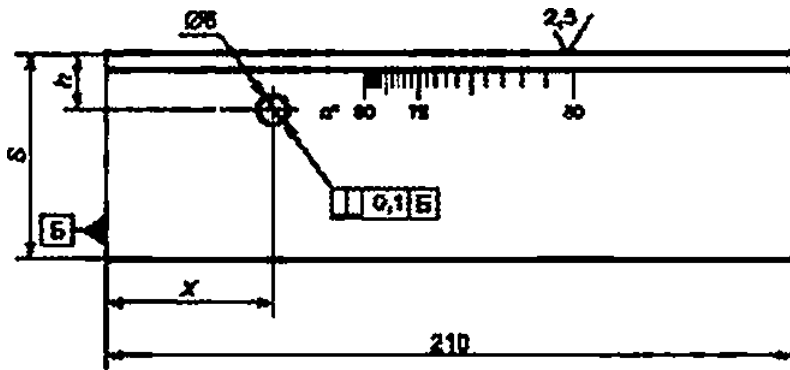
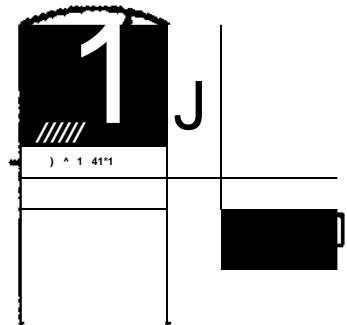
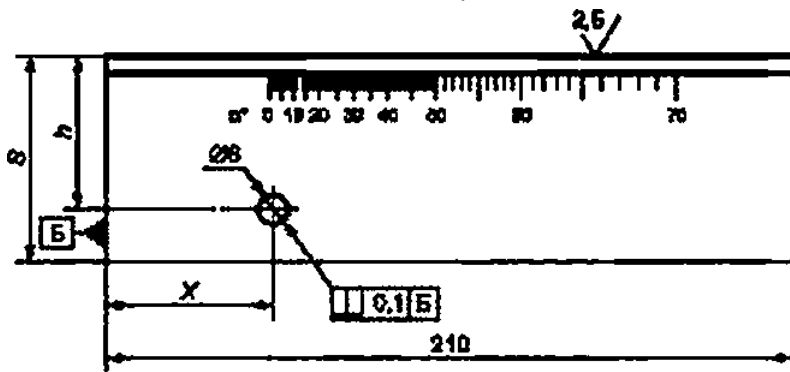
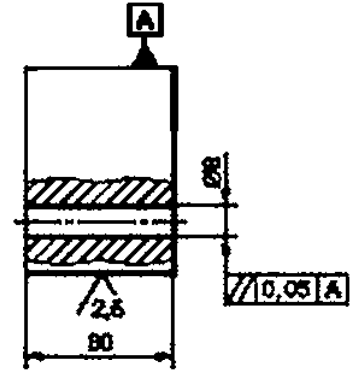
- 2

52

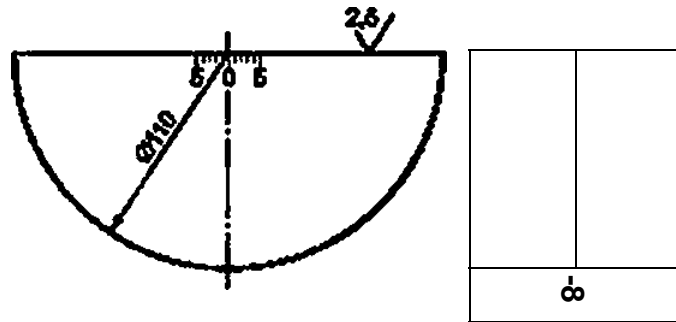
- * S —
- * h —
- * X —

20 3,

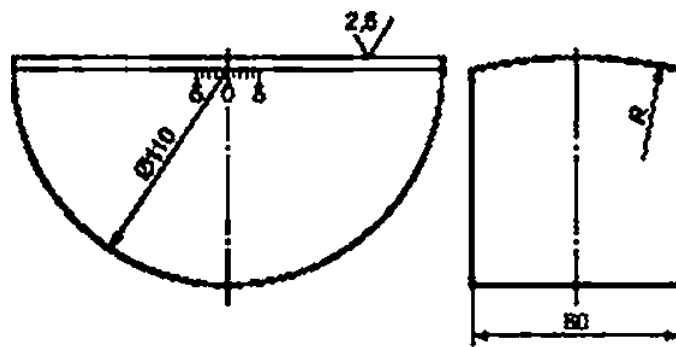
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| | | «• 9 W3C ® « W ® |
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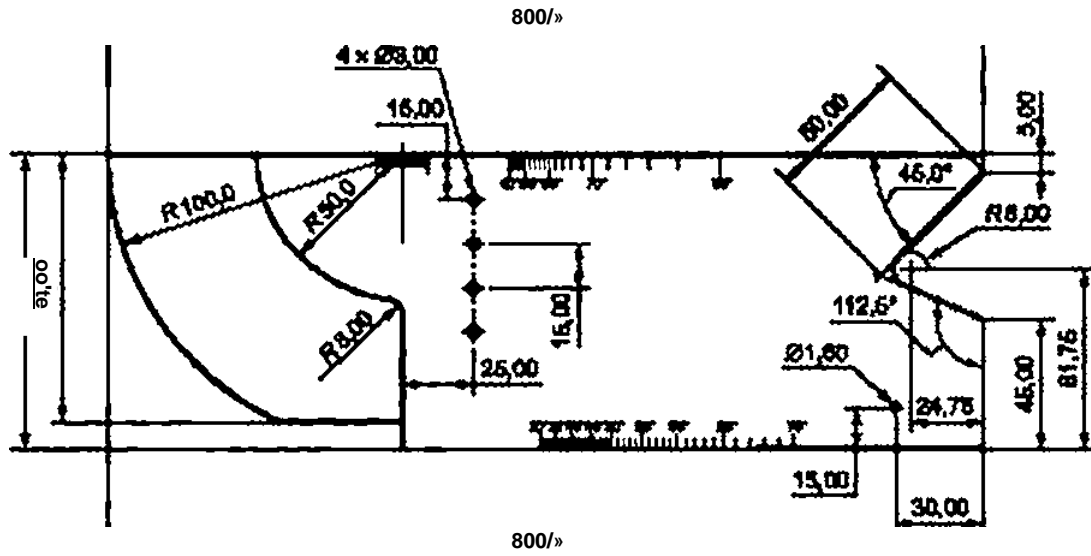


б) С радиусом наружной поворота

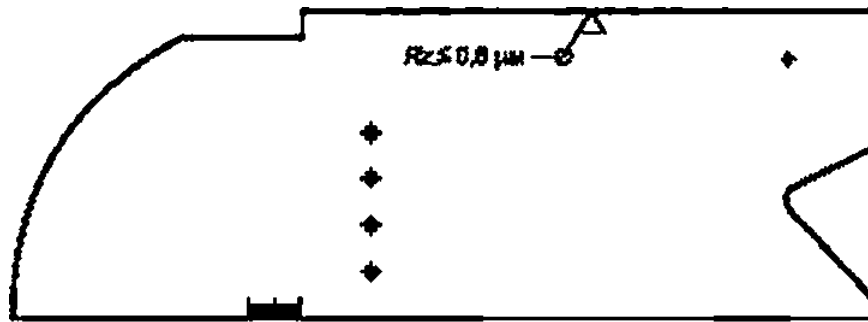
53 — . . .

6.13

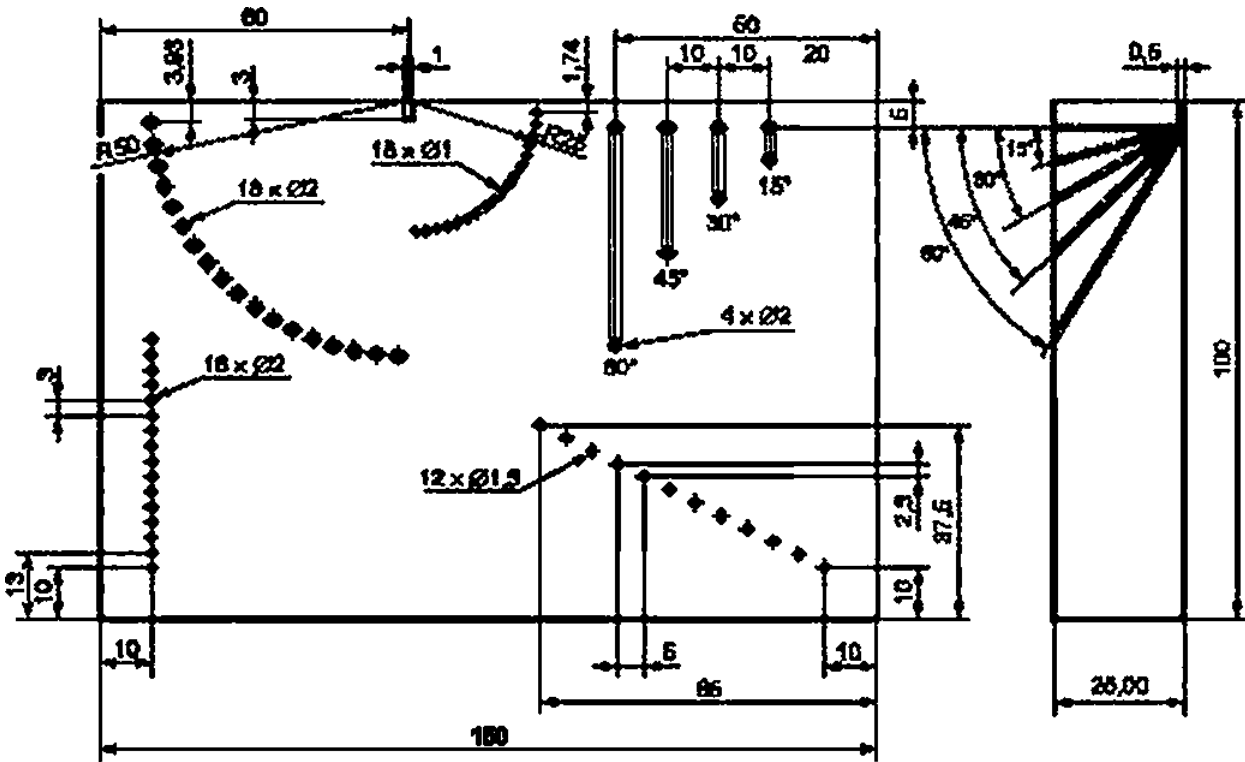
54—56.



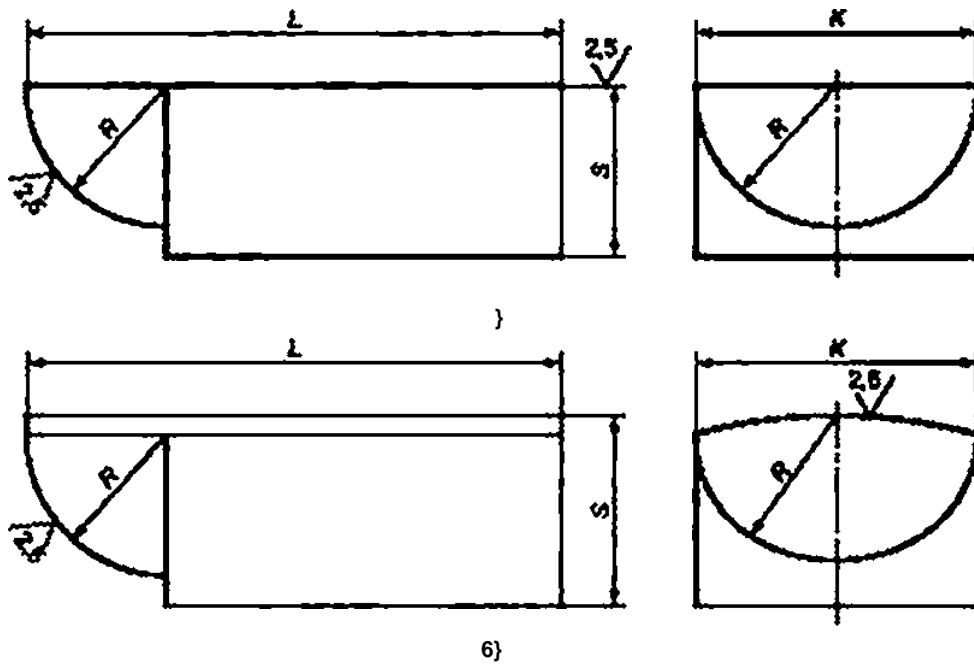
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б) Elvaci qanqan



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6.14

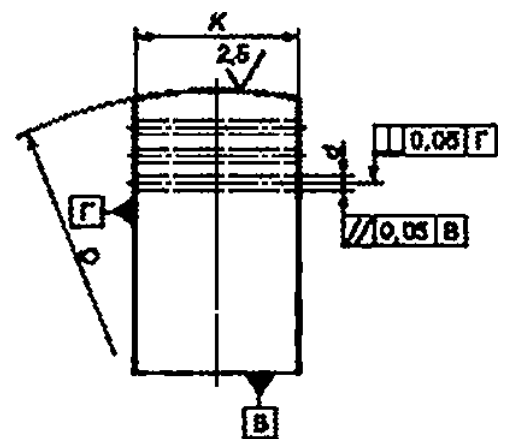
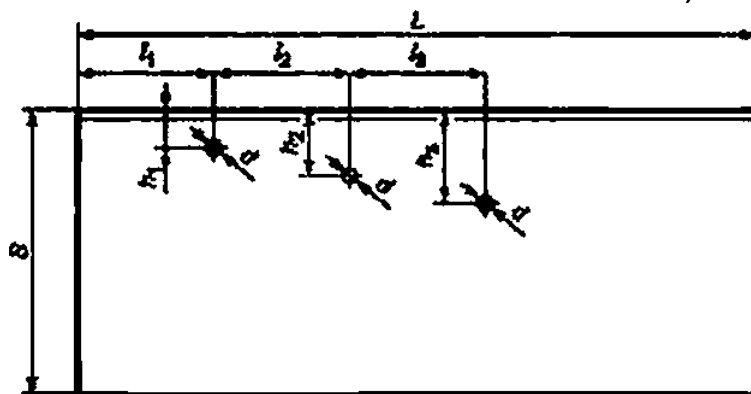
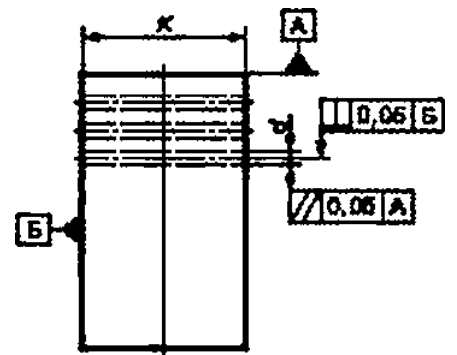
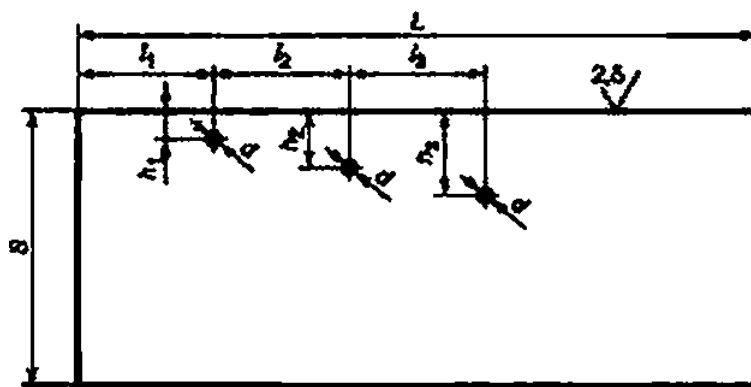
(57).

- L—
- X—
- S—
- h—
- —
- d—
- l—

6.14.1

6.14.2

8



6.15

58—59.

- L—
- —
- S—
- X—
- —

* D —

* d —

* d_y —

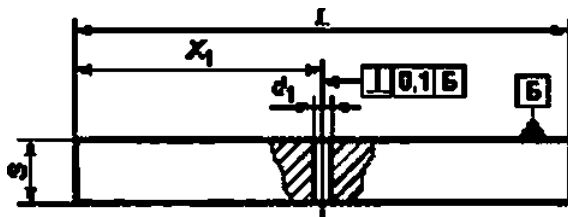
6.15.1

S—

6.15.2

6.15.3

6.15.4



± 1.0

110,0 %

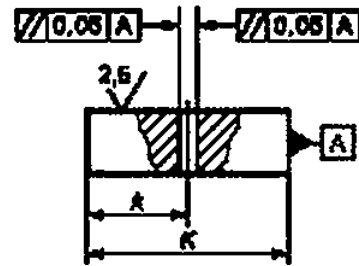
± 0.05

± 0.05

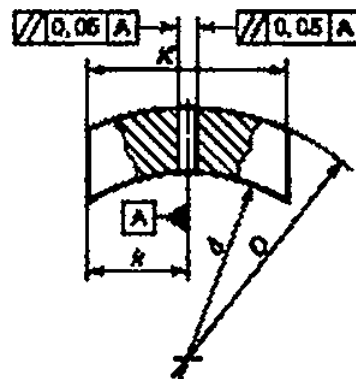
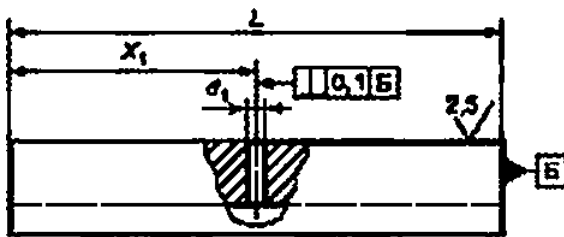
D

d

$\pm 10.0 \%$



58 —



59 —

8

6.16

60.

* L —

* S —

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* ϵ —

* d —

* l —

6.16.1

S—

6.16.2

l —

± 0.05

()! 1,0

110,0 %

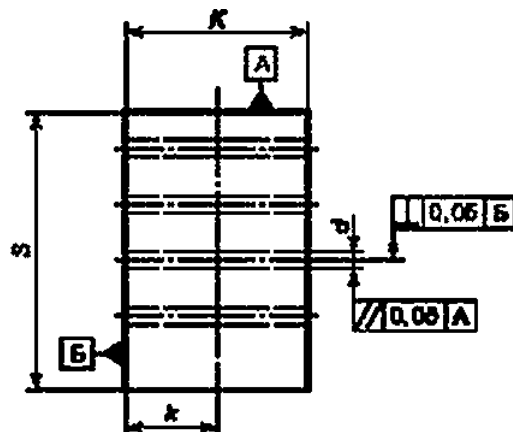
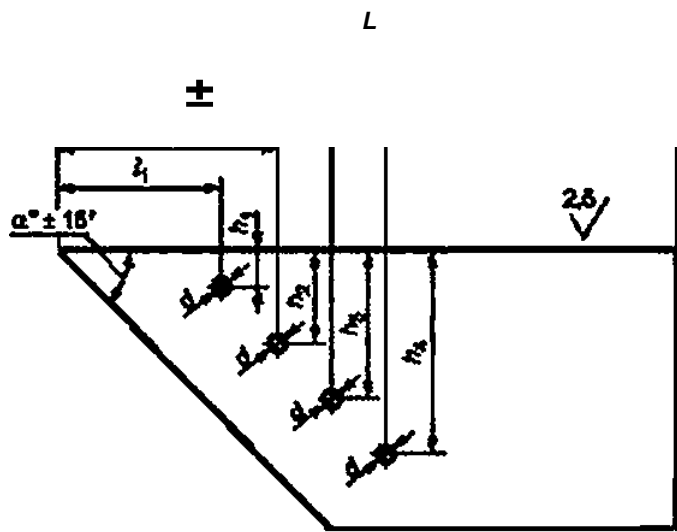
h .

6.16.3

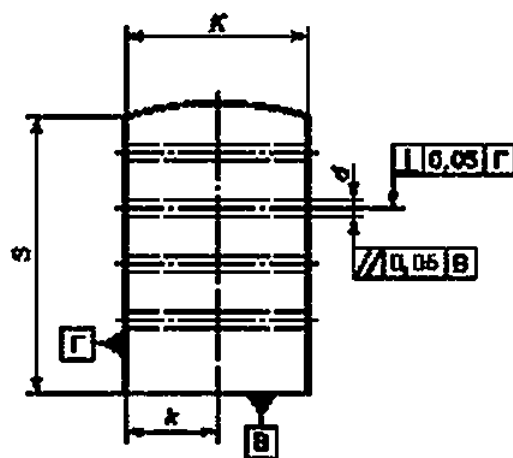
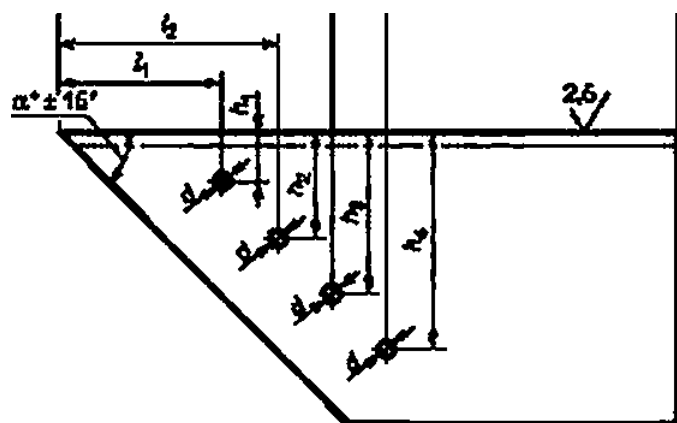
d_x — ± 0.05

6.16.4

±10,0 %.



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- [2] « » 31 2013 . 1/10- « -
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