

Non – destructive testing

SRB tubes (before ID machining) and Piston Rod tubes (before OD grinding) are Non-destructive tested as follows:

- SRB tubes, grades ART H355, ART H450, ART H460, ART H525, ART H560 and all grades for piston rods tubes are UT tested, if Option 4 is selected.
- All **IFR (Improved Fatigue Resistance)** SRB tubes and all grades ART H620, ART H690 are full length Ultrasonic tested, using as reference standard notch disposed in longitudinal and transversal direction, on both External and Internal surface, 3 % Wt depth (with a minimum 0.20 mm), notch length maximum 25 mm, notch width maximum 0.50 mm.

Option 4 - full length Ultrasonic testing, using as reference standard notch disposed in longitudinal and transversal direction, on both External and Internal surface, 3 % Wt depth (with a minimum 0.20 mm), notch length maximum 25 mm, notch width maximum 0.50 mm.

The SRB or Piston Rod tubes having indications over the acceptance level are dressed and re-inspected. The dressed area shall conform to specifications tolerances, contrary the tubes are rejected.