ULTRASONIC INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH EB3200C, MODIFIED AS FOLLOWS:

4.5.5 ULTRASONIC INSPECTION. - ULTRASONIC INSPECTION FOR SOUNDNESS SHALL BE CONDUCTED IN TWO OPPOSITE CIRCUMFERENTIAL DIRECTIONS AND TWO OPPOSITE AXIAL DIRECTIONS BY THE SHEAR WAVE (ANGLE-BEAM) TECHNIQUE. THE METHOD SHALL BE IN ACCORDANCE WITH THE APPLICABLE SECTIONS OF MIL-STD-271, EXCEPT PARAGRAPHS 4.5.5.2
THROUGH 4.5.5.8 BELOW MODIFY THE REQUIREMENT FOR THE CIRCUMFERENTIAL TEST FOR PIPE OR TUBE HAVING AN OUTSIDE DIAMETER OF 5.563 INCHES OR LESS.

4.4.5.4 REFERENCE STANDARD. - THE CALIBRATION REFERENCE STANDARD SHALL BE MADE FROM A LENGTH OF ULTRASONICALLY SOUND TUBE OR PIPE OF THE SAME TYPE, WALL THICKNESS, AND OUTSIDE DIAMETER AS THAT TO BE TESTED AS DEFINED IN MIL-STD-271. THE STANDARD SHALL MEET THE STRAIGHTNESS REQUIREMENT SHOWN ON FIGURE 2 AND SHALL HAVE
TWO CIRCUMFERENTIAL NOTCHES AND TWO AXIAL NOTCHES. ONE OF EACH TYPE OF NOTCH SHALL BE ON THE INSIDE SURFACE AND ONE OF EACH TYPE SHALL BE ON THE OUTSIDE SURFACE. THE NOTCH DIMENSIONS SHALL BE WITHIN THE TOLERANCES SHOWN ON FIGURE 2 AND MAY BE MACHINED OR ELECTRO-DISCHARGED-MACHINED. THE NOTCHES SHALL HAVE A DEPTH OF 0.005 INCH OR 5 PERCENT OF THE MINIMUM WALL THICKNESS AS LISTED IN TABLE III
OR IV, WHICHEVER IS GREATER.
FIGURE 2. REFERENCE STANDARD DIMENSIONS AND TOLERANCES. (ADD THE FOLLOWING)
AXIAL NOTCH LENGTH - 1.0 INCH PLUS OR MINUS 1/16 INCH
CIRCUMFERENTIAL NOTCH LENGTH (MINIMUM) - 1.0 INCH OR 45 DEGREES OF THE CIRCUMFERENCE, WHICHEVER IS LESS.