

Revision A1

Foreword

This company standard contains amendments to [SN 200-4:2022-06](#) which have proven necessary in the application of the standard.

Revision

Section 9.3 Scope of inspection on fluid-carrying components

Table 11 shall be replaced by the following table. The amendments made are highlighted in grey.

Table 11 – Scope of inspection on weld seams on fluid-carrying components

Limits for imperfections according to DIN EN ISO 5817		Required for pressure stage	Required examinations ^{a)}			
Quality level	No.		Visual check (VT)	Radiographic testing ^{b)} (RT)	Pressure test	Leak testing
B (high)	all	^{d)}	100%	≥ 25%	^{e)}	
C (medium)		> 2.5 MPa		≥ 10%		
D (low)	all ^{c)}	≤ 2.5 MPa		--		

^{a)} The percentage indication refers to the number of welds with 100% weld inspection.

^{b)} Radiographic testing can be replaced by equivalent testing methods for testing the internal condition. These examinations are required only if the contracting workshop has not secured and documented the qualification of its personnel by suitable statistical methods and procedures. Approval by SMS group must be obtained before the beginning of manufacture.

^{c)} Except for no. 2.13 according to quality level C, see Annex A (normative), Table A.1

^{d)} Quality level B shall be applied in case of particular requirements irrespective of the pressure stage.

^{e)} Only in exceptional cases. Pressure or leak tests are compulsory if:

- components consist of two or more separate chambers or hollows. Testing shall be made on every individual chamber or hollow.
- machining of weld seams has taken place. Upon previous consultation with and written approval by the SMS group department of quality inspection, crack detection can be used instead of leak tightness testing. A drawing indication is required.

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