



**CERTIFICATION SCHEME FOR PERSONNEL**

**DOCUMENT No. CSWIP-ISO-NDT-11/93-R**  
**Requirements for the Certification of Personnel Engaged in Non-Destructive Testing in accordance with the requirements of EN 473 and ISO 9712**

**APPENDIX 1**

**Examination Format and Syllabuses for the Certification of Personnel Engaged in Non-Destructive Testing of Welded Joints and General Engineering Components**

**PART 8: Eddy Current Inspector, Level 1, 2 and 3**

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These syllabi are applicable to candidates seeking certification in accordance with Document CSWIP-ISO-NDT-11/93R 'Requirements for the Certification of Personnel Engaged in Non-Destructive Testing.

## **EDDY CURRENT INSPECTOR – EXAMINATION FORMAT**

### **1 Level 1**

#### **1.1 General theory examination**

- 40 multiple choice questions
- Time allowed 60 minutes
- Pass mark 70%.

#### **1.2 Specific theory examination**

- 20 multiple choice questions
- Time allowed 30 minutes
- Pass mark 70%.

#### **1.3 General practical examination**

In the practical part, the candidate is required to set up and conduct operational and function checks on equipment and probes and record function check data as required by the examiner.

- Time allowed 30 minutes
- Pass mark 70%.

#### **1.4 Specific practical**

Candidates for certification in eddy current inspection can seek qualification in either the welding or general engineering sectors. The latter of these encompasses welds, castings and wrought products. The specific practical examinations in these two sectors are as shown below.

##### **1.4.1 Welds**

The candidate is required to carry out inspections, following written instructions, on two specimens selected by the examiner and report his findings on pro-forma report sheets.

- Time allowed 2 hours
- Pass mark 70%

##### **1.4.2 General engineering**

The candidate is required to carry out inspections, following written instructions, on two specimens selected by the examiner and report his findings on pro-forma report sheets.

- Time allowed 2 hours
- Pass mark 70%

### **2 Level 2 Welds**

#### **2.1 General theory examination**

- 40 multiple choice questions
- Time allowed 60 minutes
- Pass mark 70%.

## **2.2 Specific theory examination**

- 20 multiple choice questions
- Time allowed 30 minutes
- Pass mark 70 %.

## **2.3 General Practical Examination**

In the practical part, the candidate is required to choose the necessary probes and equipment to conduct the test; conduct operational and function checks on equipment and probes and record the results.

- Time allowed 30 minutes
- Pass mark 70%.

## **2.4 Instruction writing**

To write an NDT instruction suitable for Level 1 personnel.

- Time allowed 1 hour
- Pass mark 70%

## **2.5 Specific practical examination**

Candidates for certification in eddy current inspection can seek certification in: welds; wrought products including forgings; or tubular wrought products. The specific practical examinations are shown below.

### **2.5.1 Welds**

To test three specimens selected by the examiner, the tests shall be conducted in accordance with procedures and/or instructions. Reports shall be produced for each sample on supplied report formats

- Time allowed 6 hours
- Pass mark 70%.

### **2.5.2 Wrought products including forgings**

To test three specimens selected by the examiner, the tests shall be conducted in accordance with procedures and/or instructions. Reports shall be produced for each sample on supplied report formats

- Time allowed 6 hours
- Pass mark 70%.

### **2.5.3 Tubular wrought products**

To test three specimens selected by the examiner, the tests shall be conducted in accordance with procedures and/or instructions. Reports shall be produced for each sample on supplied report formats

- Time allowed 6 hours
- Pass mark 70%.

### **3 Level 3 – Eddy Current Inspection**

#### **3.1 Basic examination (exempt if already holding Level 3)**

##### **Section A1 Material Science and Processes**

- 30 multiple choice questions
- Time allowed 45 minutes
- Pass mark 70%.

##### **Section A2 Knowledge of the Certification Scheme**

- 10 multiple choice questions
- Time allowed 15 minutes
- Pass mark 70%

This section of the examination shall be open book.

##### **Section B - Level 2 Knowledge of other NDT Methods**

- 60 multiple choice questions
- Time allowed 90 minutes
- Pass mark 70%

Exemptions for holders of Level 2 certification in the main NDT methods may be available for this section of the examination.

#### **3.2 Main method examination**

The candidate shall select the category of certification required from:

- Welds
- Wrought Products including forgings

##### **Section C1 - Level 3 Theory of the NDT Method**

- 30 multiple choice questions
- Time allowed 45 minutes
- Pass mark 70%.

##### **Section C2 – Application of the NDT Method**

- 20 multiple choice questions
- Time allowed 30 minutes
- Pass mark 70%.

This section of the examination may be open book with respect to Codes, standards and specifications

##### **Section C3 - NDT Procedure Writing**

- Time allowed 4 hours
- Pass mark 70%

## **4 Ten Year Renewal**

Level 1 and Level 2 candidates whose certificates expire at the end of the maximum ten year period of validity will be required to undertake a renewal examination comprising practical tests only as detailed below.

Level 3 candidates should refer to CSWIP-ISO-NDT-11/93R, Section 7.5.3.

### **4.1 Level 1**

#### **4.1.1 Welds**

The candidate is required to carry out inspections, following written instructions on a specimen selected by the examiner and report their findings on pro-forma sheets.

- Time allowed 1 hour
- Pass mark 70%

#### **4.1.2 General engineering**

The candidate is required to carry out inspections, following written instructions on a specimen selected by the examiner and report their findings on pro-forma sheets.

- Time allowed 1 hour
- Pass mark 70%

### **4.2 Level 2**

#### **4.2.1 Welds**

The candidate is required to test two specimens selected by the examiner, the tests shall be conducted in accordance with procedures and/or instructions. Reports shall be produced for each sample on supplied report formats.

- Time allowed 4 hours
- Pass mark 70%.

#### **4.2.2 Wrought products including forgings**

The candidate is required to test two specimens selected by the examiner, the tests shall be conducted in accordance with procedures and/or instructions. Reports shall be produced for each sample on supplied report formats.

- Time allowed 4 hours
- Pass mark 70%

#### **4.2.3 Tubular wrought products**

The candidate is required to test two specimens selected by the examiner, the tests shall be conducted in accordance with procedures and/or instructions. Reports shall be produced for each sample on supplied report formats.

- Time allowed 4 hours
- Pass mark 70%.

## **5 Level 1 Eddy Current Inspector**

### **5.1 General Theory**

#### **a. Overview of NDT techniques.**

History of electromagnetic testing  
Visual inspection; MPI.

#### **b. Electricity**

Formation of AC and DC electrical current; voltage; resistance and Ohm's law; alternating current and skin effects.

#### **c. Eddy current Principles**

Impedance; eddy current fields; coils and coil constructions; simple circuitry for absolute and differential eddy current fields; geometrical effects and eddy currents; resonance.

#### **d. Signal Display and Analysis**

Amplitude display and analysis; phase display and analysis; impedance diagrams; effects of high and low frequency.

#### **e. Eddy Current Applications**

Eddy current induced in ferromagnetic and non – ferromagnetic materials; conductivity testing; tube testing; corrosion detection; weld testing and automated systems.

### **5.2 Specific Eddy Current Theory**

#### **a. Equipment Type and Operation**

Selection of equipment; special purpose equipment; method of analysis; frequency selection; probe selection and construction; advantages and disadvantages of probe types.

#### **b. Pre – Inspection Requirements**

Surface preparation and methods; effects of surface condition on lift-off and detection; preparation of probes for scanning.

#### **c. Testing Procedures**

Use of test instructions; non-compliance; scanning, probe handling and its effects on testing; false indications; fault finding and rectification; reporting; methods of presentation and storing of results.

#### **d. Standards**

The standards and specifications used in eddy current testing.

### **5.3 Specific Theory – General Engineering**

#### **a. Welding technology**

Terminology for welds, types of defects in welds and parent metals detectable by eddy current inspection methods.

**b. Wrought Product Processes**

Definition of rolling and how it works; types of defects in rolled material; definition of forging and how it works; types of defect in forged products; tube manufacture and the types of defect encountered when eddy current testing.

**6 Level 2 Eddy Current Syllabus**

**6.1 General Theory**

As for level 1 but the examination questions will be more complex.

**6.2 Specific Theory**

As for Level 1, plus:

**a. Pre – Test procedures**

Surface preparation; characteristics of coatings and their effects. Minimum levels of tube cleaning.

**b. Safety Precautions**

Risk assessment; fire hazards; electrical safety and confined space entry.

**c. Conduct of tests**

Test procedures and reasons for NDT instructions; briefing of the remote probe operator and the supervision of level 1 personnel; probe selection; chart recording and computer file handling; selection of manual equipment and probes; coating types and methods of compensation.

**d. Defect Detection**

Probability of detection; defect characteristics; lift off and probe movement; effects of heat treatment and metallurgical changes on detection.

**e. Signal Interpretation**

Types of defects and their identification; relevant and non-relevant indications and their causes; capabilities and limitations of other NDT methods in terms of detection; characterisation and confirmation of defect

**f. Reporting**

Responsibilities for reporting; origination and authentication of NDT reports; content and layout of report; presentation of the inspection results of an NDT report; hard copy and computer generated reports; maintenance and retention of records

**6.3 Specific Theory – General Engineering**

As for Level 1 plus:

**a. Welding and Wrought Product Technology**

Basic principles of fusion welding processes; methods of producing welds including, MMA, TIG, MAG and Submerged Arc.

Basic types of welds including, fillet welds, butt welds. Variable configuration welds including, 'T's nozzles and nodes

Terminology for wrought products including, forging, hammer forging and press forging, closed die and drop forging. Extrusion and tube making processes.

Influence on techniques of non-conductive and conductive coatings and weld repairs

#### **b. Equipment maintenance**

Probe care; trouble shooting; instrument and battery care

## **7 Level 3 Eddy Current Inspector Syllabus**

### **7.1 General theory**

#### **7.1.1 Section A1**

##### **1 Materials, Processes and Product Technology**

###### **Material Technology**

Properties of materials, origin of discontinuities and failure modes, statistical process control and probability of detection.

###### **Basic Production – Crude and Finished Products**

Ingot types narrow end up and wide end up, concast methods (continuous casting process). Definition used in the production of ingots and casting.

Difference between ingot and concast production processes.

Ingot casting further hot working, rolling, forging and extrusion.

###### **Basic Casting Production Methods – Finished Products**

Methods of casting: sand casting, die casting, investment casting. Basic defects associated with cast products, their appearance and how they are formed: shrinkage, inks, cold shuts, porosity, laps, hot tears, cracks

###### **Wrought Production Processes**

Rolling process: primary rolling – blooms and slabs, secondary rolling, billets, sections and plates, cold rolling, sheets and strips, basic rolling defects, appearance and how they are formed

Forging: open die forging and press forging, closed die forging

Basic forging defects, their appearance and how they are formed: forging bursts, laps, seams, cracks

Extrusion: definition of and how it works, why extrusion is used instead of rolling or forging and methods of tube manufacture.

###### **Heat Treatment Processes**

Annealing. How annealing is carried out and the results obtained, full anneal and definitions, sub critical anneal and definition

Normalising: how it is carried out and the results obtained.

Stress relieving. What stress relieving is and why it is carried out.

## **Machining and material removal**

Turning, boring, milling, grinding and electrochemical.

## **Surface finishing and corrosion protection.**

Shot peening, grit blasting, painting, plating, chemical conversion coatings.

## **Non-metals and composite materials processing**

### **Dimensional Metrology**

#### **7.1.2 Other NDT Methods:**

##### **Electromagnetic Testing**

Principles, properties of ACFM testing, effect of varying frequency, equipment, application and test results interpretation.

##### **Magnetic Particle Inspection**

Principles, technique selection, equipment, application and test results interpretation.

##### **Liquid Penetrant Inspection**

Principles, technique selection, equipment, application and test results interpretation.

##### **Radiographic Inspection**

Principles, technique selection, equipment, application and test results interpretation.

##### **Ultrasonic Inspection**

Principles, technique selection, equipment, application and test results interpretation.

##### **Visual and Optical Inspection**

Principles, technique selection, equipment, application and test results interpretation.

#### **7.1.3 Standards and Documentation Relating to the Certification of NDT Operators**

ISO 9712, EN 473, EN 4179 & SNT-TC-1A

#### **7.2 Section B**

Candidates for Level 3 examinations will be questioned on the contents of the syllabus for Levels 1 and 2, the questions will however be of a more complex nature.

#### **7.3 Section C3 – Procedure Writing**

Candidates are expected to produce a procedure for a component, selected by the examiner and relevant to the category of certification sought.

## **8 Reference Literature**

Product Technology Classroom Training Handbook – The British Institute of NDT 1995

‘Basic Metallurgy for Non – Destructive Testing’ edited by J L Taylor. British Institute of NDT

'Principles and practice of non-destructive testing' edited by Dr J H Lamble. Heywood and Company, London, 1962.

Non-Destructive Testing (second edition, 1991) by R Halmshaw. Edward Arnold, London 1991 ISBN 0340545216.

ASNT Question and Answer Supplement to SNT-TC-1A – Electromagnetic Testing

ASNT Level III Study Guide.

NDT Handbook, volume 4 Electromagnetic Testing ASNT 1991, Columbus, Ohio ISBN 0931403049.

Classroom Training Handbook CT-6-5 ASNT

Programmed Instruction Handbook PI-4-5 ASNT

Materials and Processes for NDT Technology ASNT