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ADDENDUM 1

Page 1, **Section 2**, *the following reference shall be added:*

ANSI/ASNT CP-106, *Nondestructive Testing—Qualification and Certification of Personnel*

Page 2, **Section 2**, *the following reference shall be deleted:*

EN 473 *Non-destructive testing—Qualification and certification of NDT Personnel—General Principles*

Page 3, **Section 3.9**, *the following NOTE shall be added after the definition:*

NOTE The term NDE may be known as NDT or NDI in other standards.

Page 4, **Section 4** *shall be replaced with the following:*

The NDE service supplier shall ensure that it:

- performs all examinations in accordance with specified standards or quality control criteria, or both;
- performs only examinations for which it is equipped and staffed;
- performs only examinations for which its employees are qualified;
- ensures that equipment is calibrated and personnel are certified in accordance with service supplier's written procedure;
- ensures that all equipment is maintained in accordance with service supplier's written procedure;
- informs the purchaser of any discrepancy or limitation imposed on the testing accuracy by such factors as surface finish, form, shape, or procedure;
- calls to the attention of the purchaser at once any irregularity or deficiency noted in the documents;
- submits promptly to the purchaser formal reports of all examinations that indicate compliance or noncompliance of the material. The NDE service supplier shall substantiate examination results when required by the purchaser;
- develops and qualifies procedures.

Page 4, **Section 5**, *the first sentence shall read:*

Personnel performing NDE shall be qualified in accordance with the manufacturer's documented training program that is based on the requirements specified in ISO 9712, ASNT CP-106, or SNT-TC-1A.

Page 7, **Section 9.2.4**, *the second sentence shall read:*

One or more of the following shall be used to demonstrate discontinuity detection:

Page 10, **Section 9.3.4**, *the second sentence shall read:*

One or more of the following shall be used to demonstrate discontinuity detection:

Page 11, **Section 9.3.7**, *the second sentence shall read:*

The check shall be performed by processing a known defect standard (comparator block) conforming to 9.3.4 through the system using in-use penetrant, emulsifier (if used), developer and required processing parameters.

Page 11, **Section 9.3.7**, *the fourth sentence shall read:*

This comparison shall be made with records of previously obtained indications or with a similar known defect standard processed with unused material.

Page 13, **Section 9.4.2** *shall read:*

UT shall be performed in accordance with a written procedure, which shall as a minimum contain the requirements listed in Table 8.

Page 13, **Section 9.4.3**, *the second sentence shall read:*

One or more of the following shall be used to demonstrate discontinuity detection:

Page 14, **Section 9.4.6**, *the first sentence shall read:*

UT shall be performed using the following contact and/or immersion techniques:

Page 14, **Section 9.4.7.4.1**, *the last sentence shall read:*

Calibration blocks shall be serialized and certified to recognized industry, national, or international standards.

Page 14, **Section 9.4.7.4.2**, *the first sentence shall read:*

The material from which the block is fabricated shall be of the same product form, material specification, or shall be acoustically similar in velocity and attenuation to the material being examined.

Page 14, **Section 9.4.7.4.2**, *the last sentence shall read:*

The application of a transfer correction, as addressed in the written procedure, shall be applied to the scanning surface when its surface is not representative of the reference standard surface.

Page 19, **Section 9.5.5.2**, *the first sentence shall read:*

X-ray equipment shall contain voltage and amperage controls (when applicable) and meters, a timer to time the length of the exposure, or other approved controls, and provisions for positioning the tube head and the part being X-rayed (when applicable).

Page 22, **Bibliography** *shall be added with the following references:*

[1] ASTM A388, *Standard Practice for Ultrasonic Examination of Steel Forgings*

[2] ASTM E164, *Standard Practice for Contact Ultrasonic Testing of Weldments*

[3] ASTM E1001, *Standard Practice for Detection and Evaluation of Discontinuities by the Immersed Pulse-Echo Ultrasonic Method Using Longitudinal Waves*

[4] ASTM E1444, *Standard Practice for Magnetic Particle Testing*

[5] ASTM E2375, *Standard Practice for Ultrasonic Testing of Wrought Products*