

Tests and Inspections

Designation: ISO 4144:2003(E)

Table 1 Minimum test duration

Thread size	Minimum test duration s
≤ 2	15
$\geq 2 \frac{1}{2}$	60

1 The following inspections shall be performed visually:

A) Inner and outer surfaces of fitting are smooth, with no cracks, harmful scratches, burrs, sand marks or other defects;

B) Fully threaded parts of fittings are sound, with no thinned and nicked or other defects.

2 Inspections of threads of fittings shall be in accordance with ISO 7-2 or shall be carried out by other suitable means.

3 The axes of screw threads shall be accurate within 0.5° of the specified angle.

4 When inspecting the fittings in production, the following test shall be performed on each fitting to ensure that no leakage occurs. To test fittings, threaded ends are sealed and, after pressurizing the inside of the fittings to air pressure of 6 bar, the fittings shall be observed for the time indicated in Table 1 while maintaining the pressure.

5 A hydraulic test may be performed at 30 bar, instead of an air pressure test. The test method and test duration should be in accordance with 4.

6 A leakage inspection is not required for fittings made from materials such as forgings, rolled bars or extruded tubes.

7 Fittings shall be capable of passing an intergranular corrosion test performed in accordance with ISO 4990:-,B.9.1. When testing is performed, one fitting from each heat treatment charge shall be tested.