

Technical Specifications

Probe specifications	
PA probe	32 elements (6x6 array without corner elements), nominal frequency 13 MHz, flexible delay line to adapt to spot weld surface (weld indentation)
Probe dimensions	ø17 x 34 mm (excluding flexible delay line)
Probe cable length	3 m
Inspection area	7.5 x 7.5 mm
Intelligent probes ensure the correct probe is used for inspection and part and serial number are documented	
Inspection	Manual
Typical screen refresh rate	10 Hz
Sheet combinations	2T / 3T
Plate thickness range	0.6 – 3.5 mm
Spot weld diameter range	2.0 – 6.0 mm
Material types	Mild steel, high strength steel (HSS), dual phase ultra-high strength steel <i>Contact our Solution Experts for different materials, such as aluminum.</i>
Coatings	Bare, zinc coating (galvanized, galvanized), e-coating, paint
DB Manager	Defining inspection plan, analyzing, analytics and archiving. Import of legacy inspection plans
Image based spot weld diameter reconstruction	
Algorithm using	TFM and FMC
A-scans per measurement	1024
Reconstruction resolution	0.25 mm
Accuracy	±0.5 mm
Repeatability	±0.5 mm in accordance with VDA5
A-Scan based weld quality identification	
Legacy algorithm based on	A-Scan evaluation
	A-Scan evaluation criteria I
	A-Scan evaluation criteria II
	A-Scan evaluation criteria IV