



Designation: E2478 – 11 (Reapproved 2022)

Standard Practice for Determining Damage-Based Design Stress for Glass Fiber Reinforced Plastic (GFRP) Materials Using Acoustic Emission¹

This standard is issued under the fixed designation E2478; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This practice details procedures for establishing the direct stress and shear stress damage-based design values for use in the damage-based design criterion for materials to be used in GFRP vessels and other GFRP structures. The practice uses data derived from acoustic emission examination of four-point beam bending tests and in-plane shear tests (see ASME Section X, Article RT-8).

1.2 The onset of lamina damage is indicated by the presence of significant acoustic emission during the reload portion of load/reload cycles. “Significant emission” is defined with historic index.

1.3 *Units*—The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units which are provided for information only and are not considered standard.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

¹ This practice is under the jurisdiction of ASTM Committee E07 on Nondestructive Testing and is the direct responsibility of Subcommittee E07.04 on Acoustic Emission Method.

Current edition approved Dec. 1, 2022. Published December 2022. Originally approved in 2006. Last previous edition approved in 2016 as E2478 – 11(2016). DOI: 10.1520/E2478-11R22.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard’s Document Summary page on the ASTM website.

D790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials

D4255/D4255M Test Method for In-Plane Shear Properties of Polymer Matrix Composite Materials by the Rail Shear Method

D3846 Test Method for In-Plane Shear Strength of Reinforced Plastics

E543 Specification for Agencies Performing Nondestructive Testing

E976 Guide for Determining the Reproducibility of Acoustic Emission Sensor Response

E1316 Terminology for Nondestructive Examinations

E2374 Guide for Acoustic Emission System Performance Verification

2.2 ASME Documents:³

ASME Section X, Article RT-8 Test Method for Determining Damage-Based Design Criterion

ASME Section V, Article 11 Acoustic Emission Examination of Fiber-Reinforced Plastic Vessels

2.3 Other Standards:

ANSI/ASNT-CP-189 Qualification and Certification of Nondestructive Testing Personnel⁴

SNT-TC-1A Recommended Practice for Personnel Qualification and Certification in Nondestructive Testing⁴

NAS-410 Certification and Qualification of Nondestructive Test Personnel⁵

3. Terminology

3.1 Definitions of terms related to conventional acoustic emission are in Terminology E1316, Section B.

3.2 Definitions of Terms Specific to This Standard:

³ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

⁴ Available from American Society for Nondestructive Testing (ASNT), P.O. Box 28518, 1711 Arlington Ln., Columbus, OH 43228-0518, <http://www.asnt.org>.

⁵ Available from Aerospace Industries Association of America, Inc. (AIA), 1000 Wilson Blvd., Suite 1700, Arlington, VA 22209-3928, <http://www.aia-aerospace.org>.

3.2.1 *historic index*—a measure of the change in MARSE (or other AE feature parameter such as AE Signal Strength) throughout an examination.

3.2.2 *knee in the curve*—a dramatic change in the slope of the cumulative AE (MARSE or Signal Strength) versus time curve.

3.2.3 *measured area of the rectified signal envelope (MARSE)*—a measure of the area under the envelope of the rectified linear voltage time signal from the sensor. (see ASME Section V, Article 11)

3.2.4 *significant emission*—a level of emission that corresponds to the first time during reloading that the historic index attains a value of 1.4.

4. Summary of Practice

4.1 This practice uses acoustic emission instrumentation and examination techniques during load/reloading of materials being examined, to determine the onset of significant acoustic emission. The onset of significant emission is related to the damage-based design stress by the Felicity ratio.^{6,7}

5. Significance and Use

5.1 The damage-based design approach will permit an additional method of design for GFRP materials. This is a very useful technique to determine the performance of different types of resins and composition of GFRP materials in order to develop a damage tolerant and reliable design. This AE-based method is not unique, other damage-sensitive evaluation methods can also be used.

5.2 This practice involves the use of acoustic emission instrumentation and examination techniques as a means of damage detection to support a destructive test, in order to derive the damage-based design stress.

5.3 This practice is not intended as a definitive predictor of long-term performance of GFRP materials (such as those used in vessels). For this reason, codes and standards require cyclic proof testing of prototypes (for example, vessels) which are not a part of this practice.

5.4 Other design methods exist and are permitted.

6. Basis of Application

6.1 The following items are subject to contractual agreement between the parties using or referencing this practice:

6.1.1 *Personnel Qualification*—If specified in the contractual agreement, personnel performing examinations to this practice shall be qualified in accordance with a nationally or internationally recognized NDT personnel qualification practice or standard such as ANSI/ASNT-CP-189, SNT-TC-1A, NAS-410, or a similar document and certified by the employer or certifying agency, as applicable. The practice or standard

used and its applicable revision shall be identified in the contractual agreement between the using parties.

6.1.2 *Qualification of Nondestructive Agencies*—If specified in the contractual agreement, NDT agencies shall be qualified and evaluated as described in Practice E543. The applicable revision of Practice E543 shall be specified in the contractual agreement.

6.1.3 *Procedure and Techniques*—The procedures and techniques to be utilized shall be as specified in the contractual agreement.

6.1.4 *Timing of Examination*—The timing of examination shall be in accordance with 12.4 unless otherwise specified.

6.1.5 *Extent of Examination*—The extent of examination shall be in accordance with Sections 9 and 10 unless otherwise specified.

6.1.6 *Reporting Criteria*—Reporting criteria for the examination results shall be in accordance with 15.1 unless otherwise specified.

7. Apparatus

NOTE 1—Refer to Fig. 1 for AE system block diagram showing key components of the AE system. It is recommended to use two AE sensors to monitor the specimen, evaluated on a per channel basis.

7.1 AE Sensors

7.1.1 AE sensors shall be resonant in a 100 to 300 kHz frequency band.

7.1.2 Sensors shall have a peak sensitivity greater than −77 dB (referred to 1 volt per microbar, determined by face-to-face ultrasonic examination) within the frequency range 100 to 300 kHz. Sensitivity within the 100 to 300 kHz range shall not vary more than 3 dB within the temperature range of intended use.

7.1.3 Sensors shall be shielded against electromagnetic interference through proper design practice or differential (anti-coincidence) element design, or both.

7.1.4 Sensors shall have omni-directional response, with variations not exceeding 2 dB from the peak response.

7.2 Couplant

7.2.1 Commercially available couplants for ultrasonic flaw detection may be used. Silicone-based high-vacuum grease has been found to be particularly suitable. Adhesives may also be used.

7.2.2 Couplant selection should be made to minimize changes in coupling sensitivity during a complete examination. Consideration should be given to the time duration of the examination and maintaining consistency of coupling throughout the examination.

7.3 Sensor-Preamplifier Cable

7.3.1 The cable connecting the sensor to the preamplifier shall not attenuate the sensor peak voltage in the 100 to 300 kHz frequency range more than 3 dB (6 ft (1.8 m) is a typical length). Integral preamplifier sensors meet this requirement. They have inherently short, internal, signal cables.

7.3.2 The sensor-preamplifier cable shall be shielded against electromagnetic interference. Standard low-noise coaxial cable is generally adequate.

7.4 Preamplifier

⁶ Ramirez, G., Ziehl, P., Fowler, T., 2004, “Nondestructive Evaluation of FRP Design Criteria with Primary Consideration to Fatigue Loading”, *ASME Journal of Pressure Vessel Technology*, Vol. 126, pp. 1–13.

⁷ Ziehl, P. and Fowler, T., 2003, “Fiber Reinforced Polymer Vessel Design with a Damage Approach”, *Journal of Composite Structures*, Vol. 61, Issue 4, pp. 395–411.