ABSTRACT

An ultrasonic flaw inspection method for a cast bar that uses a longitudinal wave as an incident wave for the inspection of the entire region of the cast bar circular in cross-section is provided. In performing ultrasonic flow inspection by arranging a plurality of phased array type probes 1 and 2 in a circumferential direction of the cast bar S circular in cross-section at a predetermined angle α, one of the phased array type probes 1 and the other phased array type probe 2 are arranged such that an uninspected region 1A and 1B by a longitudinal inclined angle wave and a longitudinal vertical wave of the one of the phased array type probes 1 is complemented with an inspected region by a longitudinal inclined angle wave and a longitudinal vertical wave of the other phased array type probe 2.