

Steel castings — Radiographic inspection

0 Introduction

For the interpretation of radiographs and the assignment of radiographic quality levels to a casting, it is necessary to use a standard set of reference radiographs. The reference radiographs available from ASTM (see clause 2) are the only internationally used and recognized documents that may be used for this purpose.

1 Scope and field of application

This International Standard specifies the general requirements for the radiography of steel castings by means of X rays or gamma rays in accordance with procedures given in ISO 5579 and ISO 1007.

2 References

ISO 1007, *Radiographic image quality indicators for non-destructive testing — Principles and identification*.

ISO 5579, *Non-destructive testing — Radiographic examination of metallic materials by X- and gamma rays — Basic rules*.

Adjunct to ASTM E446, *Standard reference radiographs for steel castings up to 2 in. (51 mm) in thickness*.¹⁾

Adjunct to ASTM E186, *Standard reference radiographs for heavy-walled (2 to 4 1/2-in. (51 to 114 mm)) steel castings*.¹⁾

Adjunct to ASTM E280, *Standard reference radiographs for heavy-walled (4 1/2 to 12-in. (114 to 306 mm)) steel castings*.¹⁾

Adjunct to ASTM E192, *Standard reference radiographs of investment steel castings of aerospace applications*.¹⁾

3 Basis of purchase

3.1 The request for radiographic examination and all pertinent information relating thereto, such as sensitivity, coverage and acceptance criteria, shall be indicated in the enquiry and order.

3.2 Unless otherwise specified in the enquiry and order, the radiographic coverage may be of two types, i.e. pilot or regular production inspection. For both types, the manufacturing plan shall show the area to be examined and the frequency of examination and shall be subject to agreement between the supplier and purchaser.

3.3 If requirements are imposed for which no accepted ISO or other standard or document is available, a detailed specification of such requirements shall be provided.

4 Time of examination

4.1 Unless otherwise requested in the enquiry and order, the radiographic examination may be performed at any point in the manufacturing cycle, before or after the final heat-treatment.

4.2 The surface shall be conditioned, if necessary, so that surface irregularities cannot mask or be confused with discontinuities.

4.3 Any type of penetrometer or image quality indicator may be used, provided that the sensitivity level indicated by the purchaser is achieved.

¹⁾ Reference radiographs may be purchased from:
American Society for Testing and Materials
1916 Race Street
Philadelphia, PA 19103, U.S.A.

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