



Standard Test Method for Radioscopic Examination of Weldments¹

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1. Scope

1.1 This test method covers a uniform procedure for radioscopic examination of weldments. Requirements expressed in this test method are intended to control the quality of the radioscopic images and are not intended for controlling acceptability or quality of welds.

1.2 This test method applies only to the use of equipment for radioscopic examination in which the image is finally presented on a television monitor for operator evaluation. The examination may be recorded for later review. It does not apply to fully automated systems where evaluation is automatically performed by computer.

1.3 The radioscopic extent, the quality level, and the acceptance criteria to be applied shall be specified in the contract, purchase order, product specification, or drawings.

1.4 This test method can be used for the detection of discontinuities. This test method also facilitates the examination of a weld from several directions, such as perpendicular to the weld surface and along both weld bevel angles. The radioscopic techniques described in this test method provide adequate assurance for defect detectability; however, it is recognized that, for special applications, specific techniques using more stringent requirements may be needed to provide additional detection capability. The use of specific radioscopic techniques shall be agreed upon between purchaser and supplier.

1.5 The values stated in inch-pound units are to be regarded as the standard. The SI units given in parentheses are for information only.

1.6 *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 and health practices and determine the applicability of regulatory limitations prior to use. Specific precautionary statements are given in Section 7.*

2. Referenced Documents

2.1 ASTM Standards:

E 94 Guide for Radiographic Testing²

E 543 Practice for Agencies Performing Nondestructive Testing²

E 747 Practice for Design, Manufacture, and Material Grouping Classification of Wire Image Quality Indicators (IQI) Used for Radiology²

E 1000 Guide for Radioscopy²

E 1025 Practice for Design, Manufacture, and Material Grouping Classification of Hole-Type Image Quality Indicators (IQI) Used for Radiology²

E 1255 Practice for Radioscopy²

E 1316 Terminology for Nondestructive Examinations²

2.2 ASNT Standards:

ASNT Recommended Practice No. SNT-TC-1A Personnel Qualification and Certification in Nondestructive Testing³

ANSI/ASNT CP-189-ASNT Standard for Qualification and Certification of Nondestructive Testing Personnel³

2.3 Military Standard:

MIL STD 410 Nondestructive Testing Personnel Qualification and Certification (Eddy Current, Liquid Penetrant, Magnetic Particle, Radiographic, Ultrasonic)⁴

3. Terminology

3.1 Definitions:

3.1.1 Definitions of terms applicable to this test method may be found in Terminology E 1316.

4. Apparatus

4.1 *Radiation Source (X-Ray or Gamma-Ray)*—Selection of the appropriate source is dependent upon variables regarding the weld being examined, such as material composition and thickness. The suitability of the source shall be demonstrated by attainment of the required image quality and compliance

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²Annual Book of ASTM Standards, Vol 03.03.

³Available from ANST, 1711 Arlingate Plaza, PO Box 28518, Columbus, OH 43228-0518.

⁴Available from the Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.

with all other requirements stipulated herein. Guidance on the selection of the radiation source may be found in Guide E 1000 and Practice E 1255.

4.2 *Manipulation System*—Selection of the appropriate manipulation system (where applicable) is dependent upon variables such as the size and orientation of the object being examined and the range of motions, speed of manipulation, and smoothness of motion. The suitability of the manipulation system shall be demonstrated by attainment of the required image quality and compliance with all other requirements stipulated herein. Guidance on the selection of the manipulation system may be found in Practice E 1255.

4.3 *Imaging System*—Selection of the appropriate imaging system is dependent upon variables such as the size of the object being examined and the energy and intensity of the radiation used for the examination. The suitability of the imaging system shall be demonstrated by attainment of the required image quality and compliance with all other requirements stipulated herein. Guidance on the selection of an imaging system may be found in Guide E 1000 and Practice E 1255.

4.4 *Image Processing System*—Where agreed between purchaser and supplier, image processing systems may be used for noise reduction through image integration or averaging, contrast enhancement and other image processing operations.

4.5 *Collimation*—Selection of appropriate collimation is dependent upon the geometry of the object being examined. It is generally useful to select collimation to limit the primary radiation beam to the weld and the immediately adjacent base material in order to improve radioscopic image quality.

4.6 *Filters and Masking*—Filters and masking may be used to improve image quality from contrast reductions caused by low-energy scattered radiation. Guidance on the use of filters and masking can be found in Guide E 94.

4.7 *Image Quality Indicators (IQI)*—Unless otherwise specified by the applicable job order or contract, image quality indicators shall comply with the design and identification requirements specified in Practices E 747 or E 1025.

4.8 *Shims, Separate Blocks, or Like Sections*—Shims, separate blocks, or like sections made of the same or radioscopically similar materials (as defined in Practice E 1025) may be used to facilitate image quality indicator positioning as described in 9.10.3. The like section should be geometrically similar to the object being examined.

4.9 *Location and Identification Markers*—Lead numbers and letters should be used to designate the part number and location number. The size and thickness of the markers shall depend on the ability of the radioscopic technique to discern the markers on the images. As a general rule, markers from 0.06 to 0.12 in. (1.5 to 3 mm) thick will suffice for most low energy (less than 1 MeV) X-ray and iridium¹⁹² radioscopy. For higher energy (greater than 1 MeV and cobalt⁶⁰) radioscopy, it may be necessary to use markers that are thicker (0.12 in. (3 mm) thick or more). In cases where the system being used provides a display of object position within the image, this shall be acceptable as identification of object location.

5. Materials

5.1 *Recording Media*—Recording media for storage of images shall be in a format agreed by the purchaser and supplier. This may include either analog or digital media.

6. Basis of Application

6.1 *Personnel Qualification*—NDT personnel shall be qualified in accordance with a nationally recognized NDT personnel qualification practice or standard such as ANSI/ASNT-CP-189, SNT-TC-1A, MIL STD 410, or a similar document. The practice or standard used and its applicable revision shall be specified in the contractual agreement between the using parties.

6.2 *Qualification of Nondestructive Testing Agencies*—If specified in the contractual agreement, NDT agencies shall be qualified and evaluated as described in Practice E 543. The applicable edition of Practice E 543 shall be specified in the contractual agreement.

6.3 *Time of Examination*—The time of examination shall be in accordance with 9.1 unless otherwise specified.

6.4 *Procedures and Techniques*—The procedures and techniques to be utilized shall be as described in this test method unless otherwise specified. Specific techniques may be specified in the contractual agreement.

6.5 *Extent of Examination*—The extent of examination shall be in accordance with 8.3 unless otherwise specified.

6.6 *Reporting Criteria/Acceptance Criteria*—Reporting criteria for the examination results shall be in accordance with Section 10 unless otherwise specified. Acceptance criteria shall be specified in the contractual agreement.

6.7 *Reexamination of Repaired/Reworked Items*—Reexamination of repaired/reworked items is not addressed in this test method and if required shall be specified in the contractual agreement.

7. Safety

7.1 Radioscopic procedures shall comply with applicable city, state, and federal safety regulations.

8. Requirements

8.1 *Procedure Requirement*—Unless otherwise specified by the applicable job order or contract, radioscopic examination shall be performed in accordance with a written procedure. Specific requirements regarding the preparation and approval of the written procedures shall be as agreed by purchaser and supplier. The production procedure shall address all applicable portions of this test method and shall be available for review during interpretation of the images. The written procedure shall include the following:

8.1.1 Material and thickness range to be examined,

8.1.2 Equipment to be used, including specifications of source parameters (such as tube voltage, current, focal spot size) and imaging equipment parameters (such as detector size, field of view, electronic magnification, camera black level, gain),

8.1.3 Examination geometry, including source-to-object distance, object-to-detector distance and orientation,

8.1.4 Image quality indicator designation and placement,

8.1.5 Test-object scan plan, indicating the range of motions and manipulation speeds through which the test object shall be manipulated in order to ensure satisfactory results (see description in 5.2.1.2 of Practice E 1255),

8.1.6 Image-processing parameters,

8.1.7 Image-display parameters, and

8.1.8 Image storage.

8.2 *Radioscopic Coverage*—Unless otherwise specified by purchaser and supplier agreement, the extent of radioscopic coverage shall include 100 % of the volume of the weld and the adjacent base metal.

8.3 *Examination Speed*—For dynamic examination, the speed of object motion relative to the radiation source and detector shall be controlled to ensure that the required radioscopic quality level is achieved.

8.4 *Radioscopic Image Quality*—All images shall be free of marks or other blemishes that could mask or be confused with the image of any discontinuity in the area of interest. It may be possible to prevent blemishes from masking discontinuities or being confused with discontinuities by moving the object being examined relative to the imaging device. If any doubt exists as to the true nature of an indication exhibited in the image, the image shall be rejected and a new image of the area shall be made.

8.5 *Radioscopic Quality Level*—Radioscopic quality level shall be determined upon agreement between the purchaser and supplier and shall be specified in the applicable job order or contract. Radioscopic quality shall be specified in terms of equivalent penetrameter (IQI) sensitivity and shall be measured using image quality indicators conforming to Practices E 747 or E 1025.

8.6 *Acceptance Level*—Accept and reject levels shall be stipulated by the applicable contract, job order, drawing, or other purchaser and supplier agreement.

8.7 *Image-Viewing Facilities*—Viewing facilities shall provide subdued background lighting of an intensity that will not cause troublesome reflection, shadows, or glare on the image.

8.8 *Storage of Images*—When storage is required by the applicable job order or contract, the images should be stored in a format stipulated by the applicable contract, job order, drawing, or other purchaser and supplier agreement. The image-storage duration and location shall be as agreed between purchaser and supplier.

9. Procedure

9.1 *Time of Examination*—Unless otherwise specified by the applicable job order or contract, perform radioscopy prior to heat treatment.

9.2 *Surface Preparation*—Unless otherwise agreed upon, remove the weld bead ripple or weld-surface irregularities on both the inside and outside (where accessible) by any suitable process so that the image of the irregularities cannot mask, or be confused with, the image of any discontinuity. Interpretation can be optimized if surface irregularities are removed such that the image of the irregularities is not discernible.

9.3 *Source to Detector Distance*—Unless otherwise specified in the applicable job order or contract, geometric unsharpness (U_g) shall not exceed the following:

Material Thickness	U_g , max, in. (mm)
under 2 in. (50 mm)	0.020 (0.50)
2 through 3 in. (50 through 75 mm)	0.030 (0.75)
over 3 through 4 in. (75 through 100 mm)	0.040 (1.00)
greater than 4 in. (100 mm)	0.070 (1.75)

Determine geometric unsharpness values as specified in Guide E 94.

9.4 *Examination Speed*—For dynamic examination, determine the speed of object motion relative to the radiation source and detector upon agreement between the purchaser and supplier. Base this determination upon the achievement of the required radioscopic quality level at that examination speed.

9.5 *Direction of the Radiation*—Direct the central beam of radiation perpendicularly toward the center of the effective area of the detector or to a plane tangent to the center of the image, to the maximum extent possible, except for double-wall exposure-double-wall viewing elliptical projection techniques, as described in 9.14.2.

9.6 *Scattered Radiation*—Scattered radiation (radiation scattered from the test object and from surrounding structures) reduces radioscopic contrast and may produce undesirable effects on radioscopic quality. Use precautions such as collimation of the source, collimation of the detector, and additional shielding as appropriate to minimize the detrimental effects of this scattered radiation.

9.7 *Image Quality Indicator Selection*—For selection of the image quality indicator, the thickness on which the image quality indicator is based is the single-wall thickness plus the lesser of the actual or allowable reinforcement. Backing strips or rings are not considered as part of the weld or reinforcement thickness for image quality indicator selection. For any thickness, an image quality indicator acceptable for thinner materials may be used, provided all other requirements for radioscopy are met.

9.8 *Number of Image Quality Indicators:*

9.8.1 Place at least one image quality indicator (Practices E 747 or E 1025) in the area of interest representing an area in which the brightness is relatively uniform. The degree of brightness uniformity shall be agreed upon between purchaser and supplier. If the image brightness in an area of interest differs by more than the agreed amount, use two image quality indicators. Use one image quality indicator to demonstrate acceptable image quality in the darkest portion of the image and use one image quality indicator to demonstrate acceptable image quality in the lightest portion of the image.

9.8.2 When a series of images are made under identical conditions, it is permissible for the image quality indicators to be used only on the first and last images in the series, provided this is agreed upon between the purchaser and supplier. In this case, it is not necessary for the image quality indicators to appear in each image.

9.8.3 Always retain qualifying images, on which one or more image quality indicators were imaged during exposure, as part of the record to validate the required image quality indicator sensitivity and placement.

9.9 *Image Quality Indicator Placement:*

9.9.1 Place the image quality indicator on the source side adjacent to the weld being examined. Where the weld metal is

not radioscopically similar to the base material or where geometry precludes placement adjacent to the weld, place the image quality indicator over the weld or on a separate block, as described in 9.10.

9.9.2 Detector-Side Image Quality Indicators—In those cases where the physical placement of the image quality indicators on the source side is not possible, place the image quality indicators on the detector side. The applicable job order or contract shall specify the applicable detector-side quality level. The accompanying documents shall clearly indicate that the image quality indicators were located on the detector side.

9.10 Separate Block—When configuration or size prevents placing the image quality indicators on the object being examined, use a shim, separate block or like section conforming to the requirements of 4.8 provided the following conditions are met:

9.10.1 The image quality indicator is no closer to the detector than the source side of the object being examined (unless otherwise specified).

9.10.2 The radioscopic brightness in the area of the image quality indicator including the shim, separate block, or like section and IQI where applicable are similar to the brightness in the area of interest.

9.10.3 The shim, separate block, or like section is placed as close as possible to the object being examined.

9.10.4 When hole-type image quality indicators are used, the shim, separate block, or like section dimensions shall exceed the image quality indicator dimensions such that the outline of at least three sides of the image quality indicator image is visible on the image.

9.11 Shim Utilization—When a weld reinforcement or backing ring and strip is not removed, place a shim of material that is radioscopically similar to the backing ring and strip under the image quality indicators to provide approximately the same thickness of material under the image quality indicator as the average thickness of the weld reinforcement plus the wall thickness, backing ring and strip.

9.11.1 Shim Dimensions and Location—When hole-type image quality indicators are used, the shim dimensions and location shall exceed the image quality indicator dimensions by at least 0.12 in. (3 mm) on at least three sides. At least three sides of the image quality indicator shall be discernible in accordance with 9.10.4 except that only the two ends of the image quality indicator need to be discernible when located on piping less than 1 in. (25 mm) nominal pipe size. Place the shim so as not to overlap the weld image including the backing strip or ring.

9.11.2 Shim Image Brightness—The image brightness of the shim image shall be similar to the image brightness of the area of interest.

9.12 Location Markers—Place location markers outside the weld area. The radioscopic image of the location markers for the identification of the part location with the image shall appear on the image without interfering with the interpretation and with such an arrangement that it is evident that complete coverage was obtained.

9.12.1 Double-Wall Technique—When using a technique in which radiation passes through two walls and the welds in both

walls are simultaneously viewed for acceptance, and the entire image of the object being examined is displayed, only one location marker is required in the image.

9.12.2 Series of Images—For welds that require a series of images to cover the full length or circumference of the weld, apply the complete set of location markers at one time, wherever possible. A reference or zero position for each series must be identified on the component. A known feature on the object (for example, keyway, nozzle, and axis line) may also be used for establishment of a reference position. Indicate this feature on the radioscopic record.

9.12.3 Similar Welds—On similar type welds on a single component, the sequence and spacing of the location markers must conform to a uniform system that shall be positively identified in the radioscopic procedure or interpretation records. In addition, reference points on the component will be shown on the sketch to indicate the direction of the numbering system.

9.13 Image Identification—Provide a system of positive identification of the image. As a minimum, the following shall appear on the image: the name or symbol of the company performing radioscopy, the date, and the weld identification number traceable to part and contract. Identify subsequent images made of a repaired area with the letter “R”.

9.14 Radioscopic Techniques:

9.14.1 Single-Wall Technique—Except as provided in 9.14.2-9.14.4, perform radioscopy using a technique in which the radiation passes through only one wall.

9.14.2 Double-Wall Technique for Circumferential Welds—For circumferential welds 4 in. (100 mm) outside diameter (3.5 in. nominal pipe size) or less, use a technique in which the radiation passes through both walls and both walls are viewed for acceptance on the same image. Unless otherwise specified, either elliptical or super imposed projections may be used. A sufficient number of views should be taken to examine the entire weld. Where design or access restricts a practical technique from examining the entire weld, agreement between contracting parties must specify necessary weld coverage.

9.14.3 For circumferential welds greater than 4 in. (100 mm) outside diameter (3.5 in. nominal pipe size), use a technique in which only single-wall viewing is performed. A sufficient number of views should be taken to examine the entire-weld. Where design or access restricts a practical technique from examining the entire weld, agreement between contracting parties must specify necessary weld coverage.

9.14.4 For radioscopic techniques that prevent single-wall exposures due to restricted access, such as jacketed pipe or ship hull, the technique should be agreed upon in advance between the purchaser and supplier. It should be recognized that image quality indicator sensitivities based on single-wall thickness may not be obtainable under some conditions.

10. Records

10.1 Maintain the following radioscopic records as agreed between purchaser and supplier:

10.1.1 Radioscopic standard shooting sketch, including examination geometry, source-to-object distance, object-to-detector distance and orientation,

10.1.2 Material and thickness range examined,

10.1.3 Equipment used, including specification of source parameters (such as tube voltage, current, focal spot size) and imaging equipment parameters (such as detector size, field of view, electronic magnification, camera blacklevel, gain, etc.) and display parameters,

10.1.4 Image quality indicator (and shim, if used) placement,

10.1.5 Test-object scan plan, including ranges of motion and manipulation speeds,

10.1.6 Image processing parameters,

10.1.7 Image-storage data,

10.1.8 Weld repair documentation, and

10.1.9 *Image*—Interpretation record shall contain as a minimum the following information:

10.1.9.1 Disposition of each image (acceptable or rejectable),

10.1.9.2 If rejectable, cause for rejection (slag, crack, porosity, etc.),

10.1.9.3 Surface indication verified by visual examination (grinding marks, weld ripple, spatter, etc), and

10.1.9.4 Signature of the image interpreter, including level.

11. Precision and Bias

11.1 No statement is made about either precision or bias of this test method since the result merely states whether there is conformance to the criteria of success specified in the procedure.

12. Keywords

12.1 gamma ray; nondestructive testing; radioscopic examination; radioscopy; weldments; x-ray

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