



Standard Reference Radiographs for Heavy-Walled (4½ to 12-in. [114 to 305-mm]) Steel Castings¹

This standard is issued under the fixed designation E 280; 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.

This standard has been approved for use by agencies of the Department of Defense.

^{ε1} NOTE—Editorial changes were made throughout in January 2004.

1. Scope

1.1 These reference radiographs² for heavy-walled steel castings are applicable to nominal section thicknesses of 4½ to 12 in. [114 to 305 mm] and consists of two sets as follows:

1.1.1 *2-MV X rays and Cobalt-60*—This includes cobalt-60 or equivalent isotope radiation and from 2 MV up to 4 MV X rays. Set of 28 plates in 8½ by 11 in. [216 by 279 mm] ring binders.

1.1.2 4-MV to 30-MV X rays.

1.1.3 Each set consists of three categories of graded discontinuities in increasing severity levels, and three categories of ungraded discontinuities furnished as examples only, as follows:

1.1.3.1 *Category A*—Gas porosity; severity levels 1 through 5.

1.1.3.2 *Category B*—Sand and slag inclusions; severity levels 1 through 5.

1.1.3.3 *Category C*—Shrinkage; 3 types:

(1) *Type 1*—Severity levels 1 through 5.

(2) *Type 2*—Severity levels 1 through 5.

(3) *Type 3*—Severity levels 1 through 5.

1.1.3.4 *Category D*—Crack; one illustration D5 in pre-1972 documents.

1.1.3.5 *Category E*—Hot tear; one illustration D3 in pre-1972 documents.

1.1.3.6 *Category F*—Insert; one illustration EB2 in pre-1972 documents.

1.2 *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 appro-*

priate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. Referenced Documents

2.1 *ASTM Standards:*³

E 94 Guide for Radiographic Examination

E 1316 Terminology for Nondestructive Examinations

2.2 *ASTM Adjuncts:*⁴

Reference Radiographs for Heavy-Walled (4½ to 12-in. [114 to 305-mm]) Steel Castings:

Volume I, 2-MV X Rays and Cobalt-60⁵

Volume II, 4-MV to 30-MV X Ray⁶

3. Terminology

3.1 *Definitions*—for definitions of terms used in this document, see Terminology E 1316, section D.

4. Significance and Use

4.1 These reference radiographs are reproductions of original radiographs and are supplied as a means for establishing the categories and severity levels of discontinuities in steel castings that may be revealed by radiographic examination. They may be used in accordance with contractual specifications.

4.2 Radiographs for evaluation are to be compared with these reference radiographs for classification on the basis of the category and severity level of the discontinuity.

4.3 The use of this document is not intended to be restricted to the specific energy level or to the absolute thickness limits that are contained in the document title. The title is intended to be descriptive, not restrictive. The document may be used where there is no other applicable document, for other energy

¹ These reference radiographs are under the jurisdiction of ASTM Committee E07 on Nondestructive Testing and are the direct responsibility of Subcommittee E07.02 on Reference Radiographs.

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² For ASME Boiler and Pressure Vessel Code applications see related Reference Radiographs SE 280 in Section V of that Code.

³ 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.

⁴ Available from ASTM Headquarters.

⁵ Order RRE028001.

⁶ Order RRE028002.

levels or thicknesses, or both, for which agreement has been reached between purchaser and manufacture.

5. Method of Preparation

5.1 The original radiographs used to prepare the accompanying reference radiographs were produced on high contrast, fine grain film by the respective use of radiation energies stated in 1.1.1 and 1.1.2. The radiographs were made with a penetrometer sensitivity as determined by ASTM penetrameters (see Guide E 94) of 2-2T. The reproductions have been prepared to an optical density of 2.00 to 2.25 and they have retained substantially the contrast of the original radiographs.

5.2 *Film Deterioration*—Radiographic films are subject to wear and tear from handling and use. The extent to which the image deteriorates over time is a function of storage conditions, care in handling and amount of use. Reference radiograph films are no exception and may exhibit a loss in image quality over time. The radiographs should therefore be periodically examined for signs of wear and tear, including scratches, abrasions, stains, and so forth. Any reference radiographs which show signs of excessive wear and tear which could influence the interpretation and use of the radiographs should be replaced.

6. Determination of Radiographic Classification

6.1 For purposes of evaluation of castings, a determination must be made of the radiographic classification to be assigned to individual castings or specific areas of castings. The determination of the applicable radiographic-severity classification shall be based on an evaluation of the casting applications, design, and service requirements. In these evaluations, consideration shall be given to such factors as pressure, temperature, section thickness, applicable design safety factor, vibration, shock, resistance to corrosion, involvement of penetrating radiations or radiation products, and involvement of dangerous gases or liquids.

7. Classification Specifications

7.1 The applicable radiographic severity level should be designated for each discontinuity type by the contracting agency in formal specifications or drawings and in the specific contract or order. For each casting, the level should be separately specified for each discontinuity type. For example, in the same casting. Severity Level 2 might be specified for shrinkage defects Type 3 and Severity Level 4 for gas porosity defects (Category A). The specifications, drawings, contract, or order should also designate the sampling plan for the castings to be radiographed and the extent of radiographic coverage.

8. Procedure for Evaluation

8.1 Compare the production radiographs of the casting submitted for evaluation with the reference radiographs of similar thickness that were exposed at an equivalent energy range.

8.2 When the severity level of discontinuities in the production radiograph being evaluated is equal to or better than the severity level in the specified reference radiograph, that part of the casting represented by the production radiograph shall be acceptable. If the production radiograph shows discontinuities

of greater severity than the reference radiograph, that part of the casting shall be rejected.

8.3 An area of like size to the reference radiograph shall be the unit area by which the production radiograph is evaluated, and any such area or any area that shares a discontinuity with an adjacent film area shall meet the requirements as defined for acceptability. When the area of interest of a production radiograph is less than the unit area, such area of interest shall be prorated to the reference radiographic area.

8.4 When two or more categories of discontinuity are present in the same production radiograph, the predominating discontinuities, if unacceptable, shall govern without regard to the other categories of discontinuities, and the casting rejected until satisfactorily repaired.

8.5 When two or more categories of discontinuity are present to an extent equal to the maximum permissible level as shown in the pertinent standards for each category, then that part of the casting shall be judged unacceptable until satisfactorily repaired.

8.6 Reference radiographs are provided showing a variety of forms of shrinkage cavities. Production radiographs showing shrinkage shall be judged by the most representative reference radiograph.

8.7 Production radiographs showing porosity, gas, or inclusions shall be evaluated by the overall condition with regard to size, number, and distribution. The aggregate size of discontinuities shall not exceed the total accumulation in area of the discontinuities of the reference radiograph. It is not the intent that the maximum size of the illustrated discontinuity shall be the limiting size for a single production radiographic discontinuity, or that the number of discontinuities shown on the reference radiograph shall be the limiting number of production radiographs. Also, caution should be exercised in judging a large discontinuity against a collection of small discontinuities on the basis of size alone. Each of the factors of size, number, and distribution must be considered in balance.

8.8 Reference radiographs in this standard do not illustrate elongated or “worm hole” type of gas discontinuities. When this condition occurs in a production radiograph, it shall be evaluated by comparison with the most representative reference radiograph.

8.8.1 When the source has been placed perpendicular to the length of the gas hole, evaluate the production radiograph with a shrinkage reference radiograph.

8.8.2 When the source has been placed diametrically or “into” the diameter of the gas hole, evaluate the production radiograph with a gas reference radiograph.

8.9 A diffraction mottling pattern can occur on radiographs of parts and sections where the grain size is large enough to be an appreciable fraction of the material thickness. However, diffraction mottling is not likely to occur in materials within the thickness range of this standard.

8.10 Hot tears and cracks exhibited on production radiographs may at times resemble linear type shrinkage. When doubt exists whether such indications are cracks or tears, or are linear shrinkage, all surfaces in the area of interest shall be ground and magnetic particle or liquid penetrant inspected as applicable. The extent and depth of grinding may require

engineering judgment. If the indication does not appear on the surface, it shall be considered to be shrinkage.

8.11 The radiographic density of discontinuities in comparison with background density is a variable dependent on technical factors. It shall not be used as a criterion for acceptance or rejection in comparison with reference radiographs.

9. Keywords

9.1 castings; discontinuities; gamma ray; reference radiographs; steel; x-ray

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