



Designation: E94/E94M - 17

Standard Guide for Radiographic Examination Using Industrial Radiographic Film¹

This standard is issued under the final designation E94/E94M; 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 approval. A superscript plus sign (+) indicates an editorial change since the last revision or approval.

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

1. Scope

1.1 This guide² covers satisfactory X-ray and gamma-ray radiographic examination as applied to industrial radiographic film recording. It includes statements about preferred practice without discussing the technical background which justifies the preference. A bibliography of several textbooks and standard documents of other societies is included for additional information on the subject.

1.2 This guide covers types of materials to be examined; radiographic examination techniques and production methods; radiographic film selection, processing, viewing, and storage; maintenance of inspection records; and a list of available reference radiograph documents.

Note 1—Further information is contained in Guide E999, Practice E1025, Test Methods E1098, and E2052.

1.3 The use of digital radiography has expanded and follows many of the same general principles of film based radiography but with many important differences. The user is referred to standards for digital radiography [E2597, E2698, E2736, and E2737 for digital detector array (DDA) radiography and E2067, E2653, E2445/E2445M, and E2446 for computed radiography (CR)] if considering the use of digital radiography.

1.4 Interpretation and Acceptance Standards—Interpretation and acceptance standards are not covered by this guide, beyond listing the available reference radiograph documents for castings and welds. Designation of accept-reject standards is recognized to be within the cognizance of product specifications and generally a matter of contractual agreement between producer and purchaser.

1.5 Safety Practices—Problems of personnel protection against X rays and gamma rays are not covered by this

document. For information on this important aspect of radiography, reference should be made to the current document of the National Committee on Radiation Protection and Measurement, Federal Register, U.S. Energy Research and Development Administration, National Bureau of Standards, and to state and local regulations, if such exist. For specific radiation safety information refer to NIST Handbook ANSI 43.3, 21 CFR 1020.40, and 29 CFR 1910.1096 or state regulations for agreement states.

1.6 Units—The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system should be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.7 If an NDT agency is used, the agency should be qualified in accordance with Specification E543.

1.8 This standard does not purport to address all of the safety problems, 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. (See 1.5.)

1.9 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:³

E543 Specification for Agencies Performing Nondestructive Testing

E746 Practice for Determining Relative Image Quality Response of Industrial Radiographic Imaging Systems

¹ This guide is under the jurisdiction of ASTM Committee E27 on Nondestructive Testing and is the direct responsibility of Subcommittee E27.01 on Radiology (X and Gamma Rays).

Current edition approved June 1, 2017. Published August 2017. Originally approved in 1992. Last previous edition approved in 2002 as E94 - (Designation E94M 02-1120/E94M 0200094-1).

² For ASME Boiler and Pressure Vessel Code applications, see related Guide E94M in Section V of that Code.

³ For approved 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 in the ASTM website.

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F. C. Campbell



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Handbook of Engineering Practice of Materials and Corrosion Jung-Chul (Thomas) Eun, 2020-09-04 This handbook is an in depth guide to the practical aspects of materials and corrosion engineering in the energy and chemical industries The book covers materials corrosion welding heat treatment coating test and inspection and mechanical design and integrity A central focus is placed on industrial requirements including codes standards regulations and specifications that practicing material and corrosion engineers and technicians face in all roles and in all areas of responsibility The comprehensive resource provides expert guidance on general corrosion mechanisms and recommends materials for the control and prevention of corrosion damage and offers readers industry tested best practices rationales and case studies *Index of Specifications and Standards*, 2005 **Department Of Defense Index of Specifications and Standards Numerical Canceled Listing**

Part IV July 2005, Construction Calculations Manual Sidney M Levy, 2011-09-23 The National Institute of Standards and Testing NIST Conversion tables and conversion formulas Calculations and formulas geometry trigonometry and physics in construction Site work Calculations relating to concrete and masonry Calculating the size weight of structural steel and miscellaneous metals Lumber calculations to select framing and trim materials Fasteners for wood and steel calculations for selection Calculations to determine the effectiveness and control of thermal and sound transmission Interior finishes Plumbing and HVAC calculations Electrical formulas and calculations Heat Exchangers Kuppan Thulukkanam, 2024-02-29 Heat Exchangers Mechanical Design Materials Selection Nondestructive Testing and Manufacturing Methods Third Edition covers mechanical design of pressure vessels and shell and tube heat exchangers including bolted flange joint design as well as selection of a wide spectrum of materials for heat exchanger construction their physical properties corrosion behavior and fabrication methods like welding Discussing the basics of quality control the book includes ISO Standards for QMS and references modern quality concepts such as Kaizen TPM and TQM It presents Six Sigma and Lean tools for heat exchangers manufacturing industries The book explores heat exchanger manufacturing methods such as fabrication of shell and tube heat exchangers and brazing and soldering of compact heat exchangers The book serves as a useful reference for researchers graduate students and engineers in the field of heat exchanger design including pressure vessel manufacturers

Inspection of Metals F. C. Campbell, 2013-04-01 This book covers the technology of inspection of metals the main emphasis on final part inspection at the manufacturing facility or on receipt at the user s facility The unique feature of this book is that it provides an intermediate level introduction to the different methods used to inspect metals and finished parts and a more detailed review of the specific inspection methods for important metal product forms The book is divided into two parts Part I gives the basics of the most important methods used for inspection and testing while Part II covers the types of methods used to inspect different classes of metallic parts The advantages and limitations of each method are discussed including when other methods may be warranted In particular the chapters on specific product forms e g castings compare

the different inspection methods and why they are used Specification for Wellhead Surface Safety Valves and Underwater Safety Valves for Offshore Service American Petroleum Institute. Production Department,1991 **Specification for Subsurface Safety Valve Equipment** American Petroleum Institute. Production Department,1988 **New York Court of Appeals. Records and Briefs.** New York (State)., **ASME Boiler and Pressure Vessel Code** American Society of Mechanical Engineers. Boiler and Pressure Vessel Committee,1980 **Nondestructive Test Methods for Structural Composites** Raymond F. Wegman,1989 Materials Evaluation ,1998 **Pressure Vessel Engineering Technology** R. W. Nichols,1971 **Industrial X-ray Interpretation** Justin G. Schneeman,1968 TEXTBOOK PRACTICAL ORIENTATION CONTENTS INCLUDE INTRODUCTION HISTORY INTERPRETATION SCIENCE THE RADIOGRAPH THE X RAY MACHINE RADIOISOTOPES X RAY TUBES X RAY SYSTEMS X RAY POSITIONING X RAY ABSORPTION SECONDARY RADIATION INTENSIFYING SCREENS FILM PROCESSING PERFECT RADIOGRAPHS X RAY ILLUMINATION CASTING INTERPRETATION HONEYCOMB INTERPRETATION BRAZING AND SOLDERING WELD INTERPRETATION ELECTRONIC ITEMS SPECIALTY ITEMS FILMLESS INTERPRETATION MOTION RADIOGRAPHY 3 D RADIOGRAPHY XERORADIOGRAPHY IMAGE QUALITY INDICATORS RADIATION AND HIGH VOLTAGE SAFETY X RAY FILM TYPES AND SIZES INTERPRETATION A PROFESSION THE X RAY REPORT INDEX NO BIBLIOGRAPHY ONE REFERENCE *Metals Handbook: Nondestructive inspection and quality control* ,1961 **Metals Handbook** American Society for Metals,1976 **Steel Casting Design Engineering Data File: Specifications. Rev** Steel Founders' Society of America,1964 **Heating, Piping, and Air Conditioning** ,1960 Vols for May 1929 Dec 1958 include the Journal of the American Society of Heating and Air Conditioning Engineers called in 1929 54 American Society of Heating and Ventilating Engineers in Journal section *The Production Engineer* ,1963 *Canadian Chemical Processing* ,1978

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