



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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WJ Hussar



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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,2011-09-19 Construction Calculations is a manual that provides end users with a comprehensive guide for many of the formulas mathematical vectors and conversion factors that are commonly encountered during the design and construction stages of a construction project It offers readers detailed calculations applications and examples needed in site work cost estimation piping and pipefitting and project management The book also serves as a refresher course for some of the formulas and concepts of geometry and trigonometry The book is divided into sections that present the common components of construction The first section of the books starts with a refresher discussion of unit and systems measurement its origin and evolution the standards of length mass and capacity terminology and tables and notes of metric U S and British units of measurements The following concepts are presented and discussed throughout the book Conversion tables and formulas including the Metric Conversion Law and conversion factors for builders and design professionals Calculations and formulas of geometry trigonometry and physics in construction Rudiments of excavation classification use of material measurement and payment Soil classification and morphology including its physicochemical properties Formulas and calculations needed for soil tests and evaluations and for the design of retaining structures Calculations relating to concrete and masonry Calculations of the size weight of structural steel and other metals Mechanical properties of wood and processing of wood products Calculations relating to sound and thermal transmission Interior finishes plumbing and HVAC calculations Electrical formulas and calculations Construction managers and engineers architects contractors and beginners in engineering architecture and construction will find this practical guide useful for managing all aspects of construction Work in and convert between building dimensions including metric Built in right angle solutions Areas volumes square ups Complete stair layouts Roof rafter and framing solutions Circle arcs circumference segments **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.

Perfect Knowledge of Piping Engineering and Construction III Ram Babu Sao, 2026-03-02. It gives me great pleasure and sense of deep satisfaction to publish this book of Perfect Knowledge of Piping Engineering and Construction III. You can learn how to design material selection and testing fabrication erection construction inspections and quality control of pipe along with weld joints detail joint preparation pipe cutting joints fit up welding of pipe pipe supports and steel structural platforms fabrication and installation etc and teach yourself to be a master of the process piping construction with the step by step instructions and quality control. It provides all the information about tools and equipments being used in the piping construction work. An engineer is the tradesperson who is busy in fabrication installation assembly testing maintenance and repair of process piping systems. Measures Weights Units Conversion of Unit Physics Hydraulic engineering Chemistry Mathematics Abbreviations Codes and Standards Piping Materials Corrosion of Metal Piping Design and Engineering Piping Components Piping Project Management Piping Fabrication and Assembly Piping Welding and Weld Specification Piping Quality Control and Inspection Piping Heat Tracing Lined Piping Fabrication and Assembly Jacketed Piping Fabrication and Assembly Piping Painting Piping Coating and Wrapping Piping Cathodic Protection Piping Insulation Non Metallic Piping Fabrication and Assembly. Fresh Piping engineer usually begins as apprentices and deals with industrial commercial marine piping and process piping systems. Typical industrial process pipe works under high pressure and temperature and requires metals such as carbon steel stainless steel alloy steel cupronical and many different alloying metals fused together through precise cutting threading grooving bending and welding. Piping engineer plan and test piping and tubing layouts cut bend or fabricated pipe or tubing segments and joints of those segments by threading welding brazing

cementing or soldering them together They check the installation of manual pneumatic hydraulic and electric operated valves on pipes to control the flow through the pipes or tubes **Specification for Wellhead Surface Safety Valves and Underwater Safety Valves for Offshore Service** American Petroleum Institute. Production Department,1988

Specification for Subsurface Safety Valve Equipment American Petroleum Institute. Production Department,1988

Steel Casting Design Engineering Data File: Specifications. Rev Steel Founders' Society of America,1964 New York Court of Appeals. Records and Briefs. New York (State)., **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 Materials Evaluation ,1998 **Nondestructive Test Methods for Structural Composites** Raymond F. Wegman,1989 Metals Handbook: Nondestructive inspection and quality control ,1961 **Metals Handbook** American Society for Metals,1976

Standards and Practices for Instrumentation Instrument Society of America,1966 *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 **Canadian Chemical Processing** ,1978

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