



Designation: E94/E94M – 22

Standard Guide for Radiographic Examination Using Industrial Radiographic Film¹

This standard is issued under the fixed 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 epsilon (ϵ) 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, Practice E1090/E1090M, and Practice E1032.

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, E2695, E2736, and E2737 for digital detector array (DDA) radiography and E2007, E2033, 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 guide. 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 1910.1095 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 *Personnel Qualification*—If specified in the contractual agreement, personnel performing examinations to this guide should be qualified in accordance with a nationally or internationally recognized NDT personnel qualification practice or standard and certified by the employer or certifying agency, as applicable.

1.9 *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.)

1.10 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.

¹ This guide is under the jurisdiction of ASTM Committee B60 on Nondestructive Testing and is the direct responsibility of Subcommittee B07.01 on Radiology (X and Gamma) Method.

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² For ASME Boiler and Pressure Vessel Code applications, see related Guide ME-94 in Section V of that Code.

*A Summary of Changes section appears at the end of this standard

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