



Designation: E94/E94M – 22

## Standard Guide for Radiographic Examination Using Industrial Radiographic Film<sup>1</sup>

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 reappraisal. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reappraisal.

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

### 1. Scope\*

1.1 This guide<sup>2</sup> 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 E1030/E1030M, 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, E2698, E2736, and E2737 for digital detector array (DDA) radiography and E2007, E2033, E2443/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.

<sup>1</sup> This guide is under the jurisdiction of ASTM Committee E07 on Nondestructive Testing and is the direct responsibility of Subcommittee E07.01 on Radiology (X and Gamma) Method.

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<sup>2</sup> For ASME Boiler and Pressure Vessel Code applications, see related Guide SE-94 in Section V of that Code.

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 1910.1096 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 *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.*

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

# Industrial Radiography Exam Study Guide

**Marco Cascella**



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## **Table of Contents Industrial Radiography Exam Study Guide**

1. Understanding the eBook Industrial Radiography Exam Study Guide
  - The Rise of Digital Reading Industrial Radiography Exam Study Guide
  - Advantages of eBooks Over Traditional Books
2. Identifying Industrial Radiography Exam Study Guide
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Industrial Radiography Exam Study Guide
  - User-Friendly Interface
4. Exploring eBook Recommendations from Industrial Radiography Exam Study Guide
  - Personalized Recommendations
  - Industrial Radiography Exam Study Guide User Reviews and Ratings
  - Industrial Radiography Exam Study Guide and Bestseller Lists
5. Accessing Industrial Radiography Exam Study Guide Free and Paid eBooks

- Industrial Radiography Exam Study Guide Public Domain eBooks
  - Industrial Radiography Exam Study Guide eBook Subscription Services
  - Industrial Radiography Exam Study Guide Budget-Friendly Options
6. Navigating Industrial Radiography Exam Study Guide eBook Formats
    - ePub, PDF, MOBI, and More
    - Industrial Radiography Exam Study Guide Compatibility with Devices
    - Industrial Radiography Exam Study Guide Enhanced eBook Features
  7. Enhancing Your Reading Experience
    - Adjustable Fonts and Text Sizes of Industrial Radiography Exam Study Guide
    - Highlighting and Note-Taking Industrial Radiography Exam Study Guide
    - Interactive Elements Industrial Radiography Exam Study Guide
  8. Staying Engaged with Industrial Radiography Exam Study Guide
    - Joining Online Reading Communities
    - Participating in Virtual Book Clubs
    - Following Authors and Publishers Industrial Radiography Exam Study Guide
  9. Balancing eBooks and Physical Books Industrial Radiography Exam Study Guide
    - Benefits of a Digital Library
    - Creating a Diverse Reading Collection Industrial Radiography Exam Study Guide
  10. Overcoming Reading Challenges
    - Dealing with Digital Eye Strain
    - Minimizing Distractions
    - Managing Screen Time
  11. Cultivating a Reading Routine Industrial Radiography Exam Study Guide
    - Setting Reading Goals Industrial Radiography Exam Study Guide
    - Carving Out Dedicated Reading Time
  12. Sourcing Reliable Information of Industrial Radiography Exam Study Guide
    - Fact-Checking eBook Content of Industrial Radiography Exam Study Guide
    - Distinguishing Credible Sources
  13. Promoting Lifelong Learning
    - Utilizing eBooks for Skill Development

- Exploring Educational eBooks

### 14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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