



Designation: E94/E94M - 17

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 revisions, 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, Test Methods E1698, 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, E2446/E2446M, 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 - 02a (E94M-02). DOI: 10.1520/E094-17.

² For AASHTO, British and Present Naval Code applications, see related Guide E274 in Section 9 of this 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.

Astm E94

R. W. Nichols



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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

Introduction to Piping Quality Control Ram Babu Sao, 2025-03-23 The terms Quality Control and Quality Assurance are often used interchangeably but they are not synonymous Quality Assurance is a program executed by company management Quality Control is a task that takes place on the production floor Two aspects are quality control QC and quality assurance QA Understanding these programs and their roles is critical in making sure the respective engineer to carry out their duties effectively There are three most important criteria for evaluating the Quality Control of work such as Cost Time of delivery and Quality Quality is most important factor out of the three Quality isn't simply a cost It is a powerful tool that contributes to the economic success of the work Therefore there is need to control all three but quality is the most significant Many manufacturers recognize that quality leads to a higher customer retention rate and helps to build competitive boundaries However the term quality by itself isn't sufficient ISO 9000 definitions the QC is the operational techniques and activities that are utilized to fulfil requirements for quality and QA is all those planned and systematic activities implemented to provide adequate confidence that the entity will fulfil requirements for quality QC is a production line function The aim of QC is to offer the highest reasonable quality of product or service to the client thereby meeting or even exceeding the client's requirements The QA manager is interested in investigating technologies and processes that prevent defects QA is a staff function The aim of QA is to apply a planned and systematic production process establishing confidence that the process generates suitable products QC method is intended to provide regular product inspection thereby guaranteeing the output's correctness completeness and integrity It finds and addresses mistakes They file and record all the QC procedures The product or service needs to be suitable and fit for the intended purpose The methods and processes should decrease errors and shortcomings the first time through the manufacturing process QC is product oriented it focuses on tests and inspections carried out at various production line checkpoints QA is process oriented its concerns are process definitions proper selection of tools proper use of testing methods and operator training QC works at locating defects QA works at preventing them QC emphasizes testing of products to discover defects and reporting the results to management QA attempts to improve and stabilize production to minimize or prevent the conditions that trigger defects Typically quality control involves problem identification problem

analysis problem correction and feedback Quality assurance involves data collection problem trend analysis process identification process analysis and process improvement **Introduction to Engine Valvetrains** Yushu Wang, 2006-10-27 Many books have been written about the design construction and maintenance of valvetrains but until now information has been scattered and difficult to find This comprehensive book will serve as your single resource providing a systematic introduction to valvetrain systems and components Focusing on the fundamental concepts this book enables you to appreciate design and material considerations while at the same time understanding the difficulties in designing valvetrains to satisfy functional requirements and manufacturing challenges *Welding, Design, Procedures and Inspection* ,1985

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 [Introduction to Piping Engineering](#) RAM BABU SAO, 2025-03-23 It gives me great pleasure and sense of deep satisfaction to publish this book of Introduction to Piping Engineering 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 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 They carry out testing and inspection of the piping system Piping engineers are often exposed to hazardous or dangerous materials such as asbestos lead ammonia steam flammable gases various resins and solvents including benzene and various refrigerants Much progress was made in the 20th century toward eliminating or reducing hazardous materials exposures Many aspects of hazardous materials are now regulated by law in most countries including asbestos usage and removal and refrigerant selection and handling Other occupational hazards include exposure to

the weather heavy lifting crushing hazards lacerations and other risks normal to the construction industry This book has proved to be a friend and guide to many Piping engineer Contractors and Technicians working with any Construction or Consultants Companies who are responsible for Laying out assembling or installation of piping systems pipe supports applying their knowledge of construction experience following blueprints and select the type and size of pipe related materials and equipment such as supports hangers and hydraulic cylinders according to piping drawings and specifications Piping engineers are the main technical professionals who are responsible to deliver the quality job of piping work and they should have sufficient knowledge of Piping Engineering subject This will result in improving the general quality levels of a Piping engineer in this direction leading to a greater satisfaction in work This book is taking a lead in upgrading the awareness knowledge of various matters related with piping work benefiting Piping engineers working in the field of piping work The total practical approach of this book explodes the statistical data on mathematics physics chemistry and engineering that even the piping engineering subject is tough and difficult to understand a general reader or beginners willing to know about the subject will find the content very easy and simple to follow I hope that the excellence of this book will be appreciated by the readers from all parts of India and abroad

Testing and Inspection of Offshore and Marine Lifting Appliances Richard Rossi Ciampolini, Alexander Arnfinn Olsen, 2024-10-02 This book introduces details of inspection criteria and inspection techniques which are widely recognized by the marine construction industry as a reliable means of inspection of structure members and their welds during the construction of surface vessels and other related marine and offshore structures This text incorporates the criteria for phased array ultrasonic testing PAUT Since 2016 PAUT has become a common non destructive testing method in use in shipyards for marine and offshore structures across the world as it provides quicker examination than conventional UT technique for complex geometries Moreover this book includes guidance for time of flight diffraction TOFD ultrasonic inspection The TOFD ultrasonic examination technique provides improved detection and sizing capabilities of discontinuities compared to standard ultrasonic pulse echo techniques Both PAUT and TOFD produce a permanent record of the inspection in electronic format

Department Of Defense Index of Specifications and Standards Numerical Canceled Listing (APPENDIX) Part IV November 2005 , 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 **Index of Specifications and Standards** ,2005 *NDT Ultrasonic Testing Questions and Answers* Chetan Singh, Master the fundamentals of NDT ultrasonic testing with this comprehensive e book Packed with five hundreds above of questions and detailed answers this guide is perfect for both experienced technicians looking to refresh their knowledge and beginners just starting out With in depth explanations and real world examples this e book is the ultimate study tool for passing your certification exam with ease Available for immediate download you can start studying right away and achieve success in your non destructive testing NDT ultrasonic testing career *Introduction to Knowledge of Piping Engineering* Ram Babu Sao, It gives me great pleasure and a sense of deep satisfaction to publish this book

Introduction to Knowledge of Piping Engineering You can learn how to design material selection and test fabrication erect construct inspections and quality control 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 types of equipment being used in the piping construction work An engineer is a tradesperson who is busy in the fabrication installation assembly testing maintenance and repair of process piping systems Fresh Piping engineer usually begins as apprentices and deal 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 cupronickel and many different alloying metals fused through precise cutting threading grooving bending and welding Piping engineers plan and test piping and tubing layouts cut bend or fabricate 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 They do testing and inspection of the piping system Piping engineers are often exposed to hazardous materials such as asbestos lead ammonia steam flammable gases various resins and solvents including benzene and various refrigerants Much progress was made in the 20th century toward eliminating or reducing hazardous materials exposures Many aspects of hazardous materials are now regulated by law in most countries including asbestos usage and removal and refrigerant selection and handling **The Best Knowledge of Piping Engineering II** ,2025-11-15 It gives me great pleasure and sense of deep satisfaction to publish this book of *The Best Knowledge of Piping Engineering II* 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 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 They do testing and inspection of the piping system Piping engineers are often exposed to hazardous or dangerous materials such as asbestos lead ammonia steam flammable gases various resins and solvents including benzene and various refrigerants Much progress was made in the 20th century toward eliminating or reducing hazardous materials exposures Many aspects of hazardous materials are now regulated by law in most countries including asbestos usage and removal and refrigerant selection and handling Other occupational hazards include exposure to the weather heavy lifting crushing hazards lacerations and other risks normal to the construction industry This book has proved to be a friend and guide to many Piping engineer Contractors and Technicians working with any Construction or Consultants Companies who are responsible for Laying out assembling or installation of piping systems pipe supports applying their knowledge of construction experience following blueprints and select the type and size of pipe related materials and equipment such as supports hangers and hydraulic cylinders according to piping drawings and specifications

Fluoropolymer Applications in the Chemical Processing Industries Sina Ebnesajjad, Pradip R. Khaladkar, 2017-10-30 Fluoropolymer Applications in Chemical Processing Industries The Definitive User's Guide and Handbook Second Edition contains the most extensive collection of data and information on fluoropolymer applications in chemical processing industries Because of their superior properties fluoropolymers have been rapidly replacing metal alloys for corrosion inhibition in chemical processing equipment This book is a complete compendium of information about fluoropolymer lining materials and structural piping and tubing Fluoropolymer surfaces preserve purity of processing streams in the chemical processing plastics food pharmaceutical semiconductor and pulp and paper industries Updated to reflect major changes since 2004 this book contains practical problem solving tools for professionals in those industries Equipment manufacturers plant operators and product design and manufacturing engineers all will benefit from the in depth knowledge provided This new edition includes new fluoropolymer grades and new examples of the fluoropolymer role in preventing corrosion New fabrication techniques have been added and additional emphasis has been placed on adhesion and welding techniques New sections have been added on inspection of new linings and in service inspection including inspection frequency acceptance criteria fitness for service evaluation and reparability Includes extensive guidelines for the selection of fluoropolymers for corrosion control Features a detailed how to on processes that convert fluoropolymers into shapes and parts Discusses fabrication techniques to finish the fluoropolymer

components before exposure to harsh chemical environments Includes laboratory techniques to determine the cause of part failure and a modeling methodology to predict and analyze failure of fluoropolymer parts *Military Standard* United States. Dept. of Defense,1971

NONDESTRUCTIVE TESTING (NDT) Prabhu TL, Discover the cutting edge world of Nondestructive Testing NDT a fascinating discipline that guarantees the integrity and reliability of materials and structures without causing damage Nondestructive Testing is an all encompassing guide that delves into the innovative techniques and technologies that underpin this critical field ensuring the highest standards of quality and safety Safeguarding Integrity with NDT Step into the realm of NDT as this book unravels the principles and methodologies behind a wide array of non intrusive testing methods From flaw detection to material analysis this comprehensive guide equips you with the knowledge to make informed decisions in critical industries Key Themes Explored Ultrasonic Testing UT Embrace the power of ultrasonic waves to detect flaws and evaluate material properties Radiographic Testing RT Discover how X rays and gamma rays penetrate materials revealing internal defects Magnetic Particle Testing MT Harness magnetic fields to detect surface and near surface flaws in ferromagnetic materials Liquid Penetrant Testing PT Use capillary action to identify surface breaking defects in non porous materials Eddy Current Testing ECT Explore the application of electromagnetic induction to examine conductive materials Target Audience Nondestructive Testing caters to engineers technicians inspectors students and professionals in industries where safety and quality are paramount Whether you work in aerospace manufacturing construction or maintenance this book empowers you to excel in NDT practices Unique Selling Points Real Life Applications Engage with practical case studies and examples showcasing NDT applications in diverse industries Advanced Technologies Stay abreast of the latest advancements in NDT equipment and techniques Interdisciplinary Approach Unify the expertise of different NDT methods to solve complex inspection challenges Quality Assurance Emphasize the role of NDT in ensuring compliance and maintaining the highest standards Ensure Quality without Compromise Nondestructive Testing transcends conventional literature it s a gateway to safeguarding integrity and quality without sacrificing materials or structures Whether you conduct inspections lead NDT teams or aspire to enhance your skillset this guide empowers you to uphold the utmost standards of excellence Secure your copy of Nondestructive Testing and explore the fascinating world of advanced techniques that preserve safety and quality with precision and care

Quality Assurance: Guide to Specifying NDT in Materiel Life Cycle Applications United States. Army Materiel Command,1970

Modern Applied Fracture Mechanics Cameron Coates,Valmiki Sooklal,2022-08-02 Modern Applied Fracture Mechanics presents a practical accessible guide to understanding and applying basic linear elastic fracture mechanics LEFM techniques to problems commonly seen in industry including fatigue analysis failure analysis and damage tolerance Including applications for several software programs AFGROW MATLAB ABAQUS and a web based FM calculator the book discusses appropriate models assumptions and typical input output parameters It provides a framework that will enable readers to quickly learn and use fracture

mechanics FM software packages and or write their own code to solve unique or standard FM problems The book covers the fundamental concepts needed to successfully execute routine applications or conduct experimental investigations End of chapter problems are included along with real world examples to enhance student understanding The textbook is appropriate for undergraduate students preparing them for the industry and for advanced studies in fracture mechanics at the graduate level Industry professionals and researchers will find this book a valuable resource for understanding basic fracture mechanics principles and methods Features include Provides broad accessible coverage of common fracture mechanics concepts and applications Focuses on applications real world examples and numerical methods in fracture analysis Integrates and explains current end user software coverage for fracture mechanics Includes numerous sample problems software examples and end of chapter problems Includes a Solutions Manual for adopting instructors

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