

Steel castings — Radiographic inspection

0 Introduction

For the interpretation of radiographs and the assignment of radiographic quality levels to a casting, it is necessary to use a standard set of reference radiographs. The reference radiographs available from ASTM (see clause 2) are the only internationally used and recognized documents that may be used for this purpose.

1 Scope and field of application

This International Standard specifies the general requirements for the radiography of steel castings by means of X rays or gamma rays in accordance with procedures given in ISO 5579 and ISO 1007.

2 References

ISO 1007, *Radiographic image quality indicators for non-destructive testing — Principles and identification.*

ISO 5579, *Non-destructive testing — Radiographic examination of metallic materials by X- and gamma rays — Basic rules.*

Adjunct to ASTM E446, *Standard reference radiographs for steel castings up to 2 in. (51 mm) in thickness.*¹⁾

Adjunct to ASTM E186, *Standard reference radiographs for heavy-walled (2 to 4 1/2-in. (51 to 114 mm)) steel castings.*¹⁾

Adjunct to ASTM E280, *Standard reference radiographs for heavy-walled (4 1/2 to 12-in. (114 to 306 mm)) steel castings.*¹⁾

Adjunct to ASTM E192, *Standard reference radiographs of investment steel castings of aerospace applications.*¹⁾

3 Basis of purchase

3.1 The request for radiographic examination and all pertinent information relating thereto, such as sensitivity, coverage and acceptance criteria, shall be indicated in the enquiry and order.

3.2 Unless otherwise specified in the enquiry and order, the radiographic coverage may be of two types, i.e. pilot or regular production inspection. For both types, the manufacturing plan shall show the area to be examined and the frequency of examination and shall be subject to agreement between the supplier and purchaser.

3.3 If requirements are imposed for which no accepted ISO or other standard or document is available, a detailed specification of such requirements shall be provided.

4 Time of examination

4.1 Unless otherwise requested in the enquiry and order, the radiographic examination may be performed at any point in the manufacturing cycle, before or after the final heat-treatment.

4.2 The surface shall be conditioned, if necessary, so that surface irregularities cannot mask or be confused with discontinuities.

4.3 Any type of penetrometer or image quality indicator may be used, provided that the sensitivity level indicated by the purchaser is achieved.

¹⁾ Reference radiographs may be purchased from:
American Society for Testing and Materials
1916 Race Street
Philadelphia, PA 19103, U.S.A.

Radiographic Inspection Iso 4993

John E. Bringas



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BS ISO 4993. Steel and Iron Castings. Radiographic Testing British Standards Institution, 2023

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 can 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 the 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 a 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 defines QC as the operational techniques and activities that are utilized to fulfill requirements for quality, and QA is all those planned and systematic activities implemented to provide adequate confidence that the entity will fulfill 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.

Precision Metal Additive Manufacturing Richard Leach, Simone Carmignato, 2020-09-21

Additive manufacturing (AM) is a fast-growing sector with the ability to evoke a revolution in manufacturing due to its almost unlimited design freedom and its capability to produce personalised parts locally and with efficient material use. AM companies, however, still face technological challenges such as limited precision due to shrinkage, built-in stresses, and limited process stability and robustness. Moreover, often post-processing is needed due

to high roughness and remaining porosity Qualified trained personnel are also in short supply In recent years there have been dramatic improvements in AM design methods process control post processing material properties and material range However if AM is going to gain a significant market share it must be developed into a true precision manufacturing method The production of precision parts relies on three principles Production is robust i e all sensitive parameters can be controlled Production is predictable for example the shrinkage that occurs is acceptable because it can be predicted and compensated in the design Parts are measurable as without metrology accuracy repeatability and quality assurance cannot be known AM of metals is inherently a high energy process with many sensitive and inter related process parameters making it susceptible to thermal distortions defects and process drift The complete modelling of these processes is beyond current computational power and novel methods are needed to practicably predict performance and inform design In addition metal AM produces highly textured surfaces and complex surface features that stretch the limits of contemporary metrology With so many factors to consider there is a significant shortage of background material on how to inject precision into AM processes Shortage in such material is an important barrier for a wider uptake of advanced manufacturing technologies and a comprehensive book is thus needed This book aims to inform the reader how to improve the precision of metal AM processes by tackling the three principles of robustness predictability and metrology and by developing computer aided engineering methods that empower rather than limit AM design Richard Leach is a professor in metrology at the University of Nottingham and heads up the Manufacturing Metrology Team Prior to this position he was at the National Physical Laboratory from 1990 to 2014 His primary love is instrument building from concept to final installation and his current interests are the dimensional measurement of precision and additive manufactured structures His research themes include the measurement of surface topography the development of methods for measuring 3D structures the development of methods for controlling large surfaces to high resolution in industrial applications and the traceability of X ray computed tomography He is a leader of several professional societies and a visiting professor at Loughborough University and the Harbin Institute of Technology Simone Carmignato is a professor in manufacturing engineering at the University of Padua His main research activities are in the areas of precision manufacturing dimensional metrology and industrial computed tomography He is the author of books and hundreds of scientific papers and he is an active member of leading technical and scientific societies He has been chairman organiser and keynote speaker for several international conferences and received national and international awards including the Taylor Medal from CIRP the International Academy for Production Engineering

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. *Kempe's Engineers Year-book*, 2002 **Handbook of Comparative World Steel Standards**, 2004

Steel Castings Handbook, 6th Edition Malcolm Blair, Thomas L. Stevens, 1995-01-01 *Handbook of Comparative World Steel Standards* John E. Bringas, 2002 *Engineer's Year-book of Formulae, Rules, Tables, Data & Memoranda*, 1999

Catalogue International Organization for Standardization, 2005 ISO Catalogue International Organization for Standardization, 1997 **Kempe's Engineer's Year-book**, 1996 *Catalogue* Bureau of Indian Standards, 2008

Engineers' Data Book Clifford Matthews, 1998. The objective of this pocketbook is to provide a concise and useful source of up to date information for the student or practising engineer. **British Journal of Non-destructive Testing**, 1986

World Translations Index, 1989 Lawyers Desk Reference, 2001 □□□□, 1988 *Thomas Register of American Manufacturers and Thomas Register Catalog File*, 2002. Vols for 1970-71 includes manufacturers catalogs

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