ISO 20769-2:2018 (E)

Non-destructive testing — Radiographic inspection of corrosion and deposits in pipes by X- and gamma rays — Part 2: Double wall radiographic inspection

Contents

Foreword

1 Scope

2 Normative references

3 Terms and definitions

4 Classification of radiographic techniques

5 General

- 5.1 Protection against ionizing radiation
- 5.2 Personnel qualification
- 5.3 Identification of radiographs
- 5.4 Marking
- 5.5 Overlap of films or digital images
- 5.6 Types and positions of image quality indicators (IQI)
- 5.6.1 Single wire IQI
- 5.6.2 Duplex wire IQI (digital radiographs)

6 Recommended techniques for making radiographs

- 6.1 Test arrangements
- 6.1.1 General
- 6.1.2 Double wall single image (DWSI)
- 6.1.3 Double wall double image (DWDI)
- 6.1.4 Alignment of beam and film/detector
- 6.2 Choice of radiation source
- 6.3 Film systems and screens
- 6.4 Screens and shielding for imaging plates (computed radiography only)
- 6.5 Reduction of scattered radiation
- 6.5.1 Filters and collimators
- 6.5.2 Interception of back scattered radiation
- 6.6 Source-to-detector distance
- 6.6.1 Double wall single image
- 6.6.2 Double wall double image
- 6.7 Axial coverage and overlap
- 6.8 Circumference coverage
- 6.8.1 General
- 6.8.2 DWSI
- 6.8.3 DWDI
- 6.9 Selection of digital radiographic equipment
- 6.9.1 General
- 6.9.2 CR systems
- 6.9.3 DDA systems

7 Radiograph/digital image sensitivity, quality and evaluation

- 7.1 Minimum image quality values
- 7.1.1 Wire image quality indicators
- 7.1.2 Duplex wire IQIs (digital radiographs)
- 7.1.3 Minimum normalized signal to noise ratio (digital radiographs)
- 7.2 Density of film radiographs
- 7.3 Film processing
- 7.4 Film viewing conditions

8 Measurement of differences in penetrated thickness

8.1 Principle of technique
8.2 Measurement of attenuation coefficient
8.3 Source and detector positioning
8.4 Image grey level profiles
8.5 Validation
8.6 Key points

9 Digital image recording, storage, processing and viewing

9.1 Scan and read out of image
9.2 Calibration of DDAs
9.3 Bad pixel interpolation
9.4 Image processing
9.5 Digital image recording and storage
9.6 Monitor viewing conditions

10 Test report

Annex A (normative) Minimum image quality values

Annex B (normative) Penetrated thickness measurements from image grey levels

Annex C (normative) Determination of basic spatial resolution

Page count: 30