

DIN EN 13100-2:2019-11 (E)

Non-destructive testing of welded joints in thermoplastics semi-finished products - Part 2: X-ray radio graphic testing

Contents		Page
European foreword		3
1	Scope	4
2	Normative references	4
3	Terms and definitions	4
4	Symbols and abbreviations	5
5	General	6
5.1	Security measures	6
5.2	Surface preparation and stage of manufacture	6
5.3	Location of the weld in the radiograph	6
5.4	Identification of radiographs	6
5.5	Marking	7
5.6	Overlap of films	7
5.7	Types and position of image quality indicators (IQI)	7
5.8	Evaluation of image quality	7
5.9	Minimum image quality values	8
5.10	Personnel qualification	8
6	Recommended techniques for making radiographs	8
6.1	Test arrangements	8
6.2	Choice of tube voltage	11
6.3	Film systems and screens	11
6.4	Alignment of beam	11
6.5	Source-to-object distance	12
6.6	Maximum area for a single exposure	12
6.7	Density of radiograph	12
6.8	Processing	12
6.9	Film viewing conditions	13
7	Examination report	13
Annex A (normative) Minimum image quality values		15
Annex B (informative) Recommended number of exposures when using the perpendicular, double- wall, single-image and single-wall off-centre techniques for a circumferential butt weld ...		18
Bibliography		20