

ISO 17636-2:2022-09 (E)

Non-destructive testing of welds - Radiographic testing - Part 2: X- and gamma-ray techniques with digital detectors

Contents		Page
Foreword		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	2
4	Symbols and abbreviated terms	6
5	Classification of radiographic techniques and compensation principles	8
5.1	Classification	8
5.2	Compensation principles, CP I, CP II or CP III	8
5.2.1	General	8
5.2.2	Compensation principle I (CP I)	8
5.2.3	Compensation principle II (CP II)	8
5.2.4	Compensation principle III (CP III)	8
5.2.5	Theoretical background	9
6	General preparations and requirements	9
6.1	Protection against ionizing radiation	9
6.2	Surface preparation and stage of manufacture	9
6.3	Location of the weld in the radiograph	9
6.4	Identification of radiographs	9
6.5	Marking	9
6.6	Overlap of digital images	10
6.7	Types and positions of image quality indicators (IQIs)	10
6.7.1	General	10
6.7.2	Duplex wire IQIs	10
6.7.3	Single wire or step-hole IQIs	10
6.8	Evaluation of image quality	11
6.9	Minimum image quality values	12
6.10	Personnel qualification	12
7	Recommended techniques	13
7.1	Test arrangements	13
7.1.1	General	13
7.1.2	Single-wall penetration of plane objects (see Figure 1)	14
7.1.3	Single-wall penetration of curved objects with the source outside the object (see Figures 2 to 4)	14
7.1.4	Single-wall penetration of curved objects with the source inside the object for panoramic exposure (see Figures 5 to 7)	15
7.1.5	Single-wall penetration of curved objects with the source located off- centre and inside the object (see Figures 8 to 10)	16
7.1.6	Double-wall penetration and double-image evaluation (DWDI) of pipes with the elliptic technique and the source and the detector outside the object (see Figure 11)	17
7.1.7	Double-wall penetration and double-image evaluation (DWDI) with the perpendicular technique and source and detector outside the object (see Figure 12)	17
7.1.8	Double-wall penetration and single-image evaluation (DWSI) of curved objects for evaluation of the wall next to the detector (see Figures 13 to 16)	18
7.1.9	Penetration of objects with different material thicknesses (see Figure 17 to 19)	19

7.2	Choice of tube voltage and radiation source	20
7.2.1	X-ray devices up to 1 000 kV	20
7.2.2	Other radiation sources	21
7.3	Detector systems and metal screens	22
7.3.1	Minimum normalized signal-to-noise ratio (SNRN)	22
7.3.2	Compensation principle II	25
7.3.3	Metal screens for IPs and shielding	25
7.4	Alignment of beam	25
7.5	Reduction of scattered radiation	26
7.5.1	Metal filters and collimators	26
7.5.2	Interception of backscattered radiation	26
7.6	Source-to-object distance	26
7.7	Geometric magnification technique	33
7.8	Maximum area for a single exposure	34
7.9	Processing	34
7.9.1	Scan and read-out of images	34
7.9.2	Correction of acquired DDA images	35
7.9.3	Bad pixel interpolation	35
7.9.4	Image processing	35
7.10	Monitor viewing conditions and storage of digital radiographs	36
8	Test report	36
Annex A (normative) Number of exposures for acceptable testing of a circumferential butt weld		38
Annex B (normative) Minimum image quality values		43
Annex C (normative) Determination of basic spatial resolution		51
Annex D (informative) Determination of minimum grey values for CR practice		53
Annex E (informative) Grey values -- General remarks		58
Annex F (informative) Considering the detector unsharpness for f_{min}		60
Annex G (informative) Calculation of recommended X-ray tube voltages from Figure 20		63
Bibliography		64