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Non-destructive testing of welds — Radiographic testing —

Part 1: X- and gamma-ray techniques with film

Essais non destructifs des assemblages soudés — Contrôle par radiographie —

Partie 1: Techniques par rayons X ou gamma à l'aide de film



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Foreword

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This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 5, *Testing and inspection of welds*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This second edition cancels and replaces the first edition (ISO 17636-1:2013), which has been technically revised.

The main changes are as follows:

- the normative references have been updated;
- the Figures have been updated;
- references to [Figures 1](#) to [19](#) have been updated throughout the document;
- in [6.7](#) the use of ASTM wires and other image quality indicators (IQIs) by agreement of contracting parties has been added;
- in [6.7](#) a) the acceptance of a shorter wire visibility than 10 mm for pipes with an external diameter < 50 mm has been added;
- in [6.7](#), [6.8](#) and [6.9](#) a clarification for the IQI usage for the double-wall double-image (DWDI) technique has been added;
- in [6.9](#) and [7.2.2](#) the lower thickness limit for Se 75 applications has been deleted;
- measurement of optical density in the root of the weld has been clarified;
- IQI use for the DWDI technique has been clarified.

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