



Designation: E1032 – 25

Standard Practice for Radiographic Examination of Weldments Using Industrial X-Ray Film¹

This standard is issued under the fixed designation E1032; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This practice provides a uniform procedure for radiographic examination of weldments using industrial radiographic film. Requirements expressed in this practice are intended to control the quality of the radiographic images and are not intended for controlling acceptability or quality of welds.

1.2 The radiographic extent, the quality level, and the acceptance criteria to be applied shall be specified in the contract, purchase order, product specification, or drawings.

1.3 The radiographic techniques stated herein provide adequate assurance for defect detectability; however, it is recognized that, for special applications, specific techniques using more or less stringent requirements may be required than those specified. In these cases, the use of alternative radiographic techniques shall be as agreed upon between purchaser and supplier (also see Section 4).

1.4 The values stated in inch-pound units are to be regarded as standard.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.* (For more specific safety precautionary information, see Section 9.)

1.6 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

¹ This practice is under the jurisdiction of ASTM Committee E07 on Nondestructive Testing and is the direct responsibility of Subcommittee E07.01 on Radiography (X and Gamma) Method.

Current edition approved Sept. 1, 2025. Published September 2025. Originally approved in 1985. Last previous edition approved in 2019 as E1032 – 19. DOI: 10.1520/E1032-25.

2. Referenced Documents

2.1 ASTM Standards:²

E94/E94M Guide for Radiographic Examination Using Industrial Radiographic Film

E242 Reference Radiographs for Appearances of Radiographic Images as Certain Parameters are Changed

E390 Reference Radiographs for Steel Fusion Welds

E543 Specification for Agencies Performing Nondestructive Testing

E747 Practice for Design, Manufacture and Material Grouping Classification of Wire Image Quality Indicators (IQI) Used for Radiography

E999 Guide for Controlling the Quality of Industrial Radiographic Film Processing

E1025 Practice for Design, Manufacture, and Material Grouping Classification of Hole-Type Image Quality Indicators (IQI) Used for Radiography

E1079 Practice for Calibration of Transmission Densitometers

E1254 Guide for Storage of Radiographs and Unexposed Industrial Radiographic Films

E1316 Terminology for Nondestructive Examinations

E1742/E1742M Practice for Radiographic Examination

E1815 Test Method for Classification of Film Systems for Industrial Radiography

2.2 Other Standards:

ISO 5579 Non-destructive testing—Radiographic testing of metallic materials using film and X- or gamma rays—Basic rules³

ISO 17636 Non-destructive testing of welds—Radiographic testing³

3. Terminology

3.1 *Definitions*—For definitions of terms used in this practice, see Terminology E1316.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at www.astm.org/contact. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from American National Standards Institute (ANSI), 1180 Avenue of the Americas, 10th Floor, New York, NY 10036, <http://www.ansi.org>.

*A Summary of Changes section appears at the end of this standard

3.2 With issuance of this practice, the terms *film density* and *radiographic density* have been replaced with the term *optical density*.

4. Basis of Application

4.1 *Personnel Qualification*—If specified in the contractual agreement, personnel performing examinations to this practice shall be qualified in accordance with a nationally or internationally recognized NDT personnel qualification practice or standard and certified by the employer or certifying agency, as applicable. The practice or standard used shall be identified in the contractual agreement between the using parties.

4.2 *Qualification of Nondestructive Agencies*—If specified in the contractual agreement, NDT agencies shall be qualified and evaluated in accordance with Specification E543. The applicable edition of Specification E543 shall be specified in the contractual agreement.

4.3 *Time of Examination*—The time of examination shall be in accordance with 8.1 unless otherwise specified.

4.4 *Procedures*—The procedures to be utilized shall be as described in 7.1.

4.5 *Extent of Examination*—The extent of the examination shall be in accordance with 7.2.

4.6 *Reporting Criteria/Acceptance Criteria*—Reporting criteria of the examination results shall be in accordance with Section 11.

4.7 *Reexamination of Repaired or Reworked Items*—Reexamination of repaired or reworked items is not addressed in this practice and if required shall be specified in the contractual agreement.

4.8 *Radiographic Quality Level*—The radiographic quality level shall be in accordance with 7.4.

5. Materials

5.1 *Film Systems*—Only film systems having cognizant engineering organization (CEO) approval or meeting the requirements of Test Method E1815 shall be used to meet the requirements of this standard.

6. Apparatus

6.1 *Radiation Source (X-Ray or Gamma-Ray)*—Selection of the appropriate source is dependent upon variables regarding the weld being examined (material composition and thickness). The suitability of the source shall be demonstrated by attainment of the required IQI sensitivity and compliance with all other requirements stipulated herein (optical density and area of interest density tolerances, etc.).

6.2 *Film Holders and Cassettes*—Film holders and cassettes shall be light tight and shall be handled properly to reduce the likelihood that they may be damaged. They may be flexible vinyl, plastic, or other durable material, or they may be made from metallic materials. In the event that light leaks into the film holder and produces images on the radiograph, the radiograph need not be rejected unless the images encroach on the radiographic area of interest. If the film holder exhibits light leaks, it shall be repaired before reuse or discarded. Film holders and cassettes should be routinely examined to minimize the likelihood of light leaks.

6.3 *Intensifying Screens:*

6.3.1 *Lead-Foil Screens:*

6.3.1.1 Intensifying screens of the lead-foil type are generally used for production radiography. Lead-foil screens shall be of the same approximate dimensions as the film being used and shall be in direct contact with the film during exposure.

6.3.1.2 Unless otherwise specified in the purchaser-supplier agreement, the lead-foil screens shown in Table 1 shall be used, except as provided within the tabular notes below it.

6.3.2 *Fluorescent, Fluorometallic, or Other Metallic Screens*—Such screens may be used with CEO approval as described under 5.1; however, they must be capable of demonstrating the required IQI sensitivity. Fluorescent or fluorometallic screens may cause limitations in image quality (see Guide E94/E94M, Appendix X1).

6.3.3 *Screen Care:*

6.3.3.1 All screens should be handled carefully to avoid dents, scratches, grease, or dirt on active surfaces. Screens that render nonrelevant indications on radiographs shall be visually examined and discarded if physical damage is observed.

TABLE 1 Lead-Foil Screens

keV Range	Front Screen ^A	Back Screen Minimum
0 keV to 150 keV ^B	0.000 in. to 0.001 in. (0 mm to 0.025 mm)	0.005 in. (0.127 mm) ^C
151 keV to 200 keV	0.001 in. to 0.005 in. (0.025 mm to 0.127 mm)	0.005 in. (0.127 mm)
201 keV to 320 keV	0.001 in. to 0.010 in. (0.025 mm to 0.254 mm)	0.005 in. (0.127 mm)
Se-75	0.001 in. to 0.010 in. (0.025 mm to 0.254 mm)	0.005 in. (0.127 mm)
321 keV to 450 keV	0.005 in. to 0.015 in. (0.127 mm to 0.381 mm)	0.010 in. (0.254 mm)
Ir-192	0.005 in. to 0.015 in. (0.127 mm to 0.381 mm)	0.010 in. (0.254 mm)
451 keV to 2 MeV	0.005 in. to 0.020 in. (0.127 mm to 0.508 mm)	0.010 in. (0.254 mm)
Co-60	0.005 in. to 0.020 in. (0.127 mm to 0.508 mm)	0.010 in. (0.254 mm)
Over 2 MeV to 4 MeV	0.010 in. to 0.020 in. (0.254 mm to 0.508 mm)	0.010 in. (0.254 mm)
Over 4 MeV to 10 MeV	0.010 in. to 0.030 in. (0.254 mm to 0.762 mm)	0.010 in. (0.254 mm)
Over 10 MeV to 25 MeV	0.010 in. to 0.050 in. (0.254 mm to 1.27 mm)	0.010 in. (0.254 mm)

^A The lead screen thickness listed for the various voltage ranges are recommended thicknesses and not required thicknesses. Other thicknesses and materials may be used provided the required radiographic quality level, contrast, and density are achieved.

^B Prepacked film with lead screens may be used from 80 keV to 150 keV. No lead screens are recommended below 80 keV. Prepacked film may be used at higher energy levels provided the contrast, density, radiographic quality level, and backscatter requirements are achieved. Additional intermediate lead screens may be used for reduction of scattered radiation at higher energies.

^C No back screen is required provided the backscatter requirements of 8.5 are met.