BS EN ISO 10675-1:2021

BSI Standards Publication

Non-destructive testing of welds - Acceptance levels for radiographic testing

Part 1: Steel, nickel, titanium and their alloys

Documents
Document Sharing Hub

Full document details: BS EN ISO 10675-1:2021

National foreword

This British Standard is the UK implementation of EN ISO 10675-1:2021. It is identical to ISO 10675-1:2021. It supersedes BS EN ISO 10675-1:2016, which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee WEE/46/5, Radiographic Testing.

A list of organizations represented on this committee can be obtained on request to its committee manager.

Contractual and legal considerations

This publication has been prepared in good faith, however no representation, warranty, assurance or undertaking (express or implied) is or will be made, and no responsibility or liability is or will be accepted by BSI in relation to the adequacy, accuracy, completeness or reasonableness of this publication. All and any such responsibility and liability is expressly disclaimed to the full extent permitted by the law.

This publication is provided as is, and is to be used at the recipient's own risk.

The recipient is advised to consider seeking professional guidance with respect to its use of this publication.

This publication is not intended to constitute a contract. Users are responsible for its correct application.

© The British Standards Institution 2022
Published by BSI Standards Limited 2022

ISBN 978 0 539 06855 9

ICS 25.160.40

Compliance with a British Standard cannot confer immunity from legal obligations.

This British Standard was published under the authority of the Standards Policy and Strategy Committee on 31 January 2022.

Amendments/corrigenda issued since publication

Date	Text affected

Documents
Document Sharing Hub

Full document details: BS EN ISO 10675-1:2021

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN ISO 10675-1

December 2021

ICS 25.160.40

Supersedes EN ISO 10675-1:2016

English Version

Non-destructive testing of welds - Acceptance levels for radiographic testing - Part 1: Steel, nickel, titanium and their alloys (ISO 10675-1:2021)

Essais non destructifs des assemblages soudés - Niveaux d'acceptation pour évaluation par radiographie - Partie 1: Acier, nickel, titane et leurs alliages (ISO 10675-1:2021)

Zerstörungsfreie Prüfung von Schweißverbindungen - Zulässigkeitsgrenzen für die Durchstrahlungsprüfung - Teil 1: Stahl, Nickel, Titan und deren Legierungen (ISO 10675-1:2021)

This European Standard was approved by CEN on 5 December 2021.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.

EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

© 2021 CEN All rights of exploitation in any form and by any means reserved worldwide for CEN national Members.

Ref. No. EN ISO 10675-1:2021 E

Documents
Document Sharing Hub

Full document details: BS EN ISO 10675-1:2021

European foreword

This document (EN ISO 10675-1:2021) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 “Welding and allied processes” the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 2022, and conflicting national standards shall be withdrawn at the latest by June 2022.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 10675-1:2016.

Any feedback and questions on this document should be directed to the users’ national standards body/national committee. A complete listing of these bodies can be found on the CEN website.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Endorsement notice

The text of ISO 10675-1:2021 has been approved by CEN as EN ISO 10675-1:2021 without any modification.

Documents
Document Sharing Hub

Full document details: BS EN ISO 10675-1:2021

Contents

Page

Foreword ..... **iv**
1 Scope **1**
2 Normative references **1**
3 Terms and definitions **1**
4 Symbols and abbreviations **1**
5 Radiographic technique **2**
6 General **2**
7 Acceptance levels **3**
Annex A (informative) **Guidance to the limitations of radiographic testing** **6**
Annex B (informative) **Examples for determination of area percentage (%) of imperfections** **7**
Annex C (informative) **Calculation of the sum of acceptable areas** **9**
Bibliography **14**

© ISO 2021 – All rights reserved

Documents
Document Sharing Hub
Full document details: BS EN ISO 10675-1:2021

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

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 third edition cancels and replaces the second edition (ISO 10675-1:2016), which has been technically revised.

The main changes compared to the previous edition are as follows:

— new Table 1 added with abbreviations;

— old Table 1 has been split into Table 2 and Table 3;

— in Table 4 (former Table 2), acceptance levels for maximum permissible pore sizes of porosity, clustered porosity, linear porosity and for lack of fusion have been added;

— the acceptance levels in Clause 6 have been extended (General and tables);

— the captures of Figure B.1 to B.9 have been revised to conform with ISO 5817:2014;

— Figures C.1 and C.2 and the text have been revised to conform with ISO 5817:2014;

— the document has been editorially revised.

A list of all parts of the ISO 10675 series can be found on the ISO website.

Official interpretations of ISO/TC 44 documents, where they exist, are available from this page: https://committee.iso.org/sites/tc44/home/interpretation.html.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

© ISO 2021 – All rights reserved
Documents
Document Sharing Hub
Full document details: BS EN ISO 10675-1:2021

Non-destructive testing of welds — Acceptance levels for radiographic testing —

Part 1:
Steel, nickel, titanium and their alloys

1 Scope

This document specifies acceptance levels for indications from imperfections in butt welds of steel, nickel, titanium and their alloys detected by radiographic testing. If agreed, the acceptance levels can be applied to other types of welds (such as fillet welds, etc.) or materials.

The acceptance levels can be related to welding standards, application standards, specifications or codes. This document assumes that the radiographic testing has been carried out in accordance with ISO 17636-1 for RT-F (F = film) or ISO 17636-2 for RT-S (S = radioscopy) and RT-D (D = digital detectors).

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 5817, *Welding — Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) — Quality levels for imperfections*

ISO 6520-1, *Welding and allied processes — Classification of geometric imperfections in metallic materials — Part 1: Fusion welding*

ISO 17636-1, *Non-destructive testing of welds — Radiographic testing — Part 1: X- and gamma-ray techniques with film*

ISO 17636-2, *Non-destructive testing of welds — Radiographic testing — Part 2: X- and gamma-ray techniques with digital detectors*

ISO 17637, *Non-destructive testing of welds — Visual testing of fusion-welded joints*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 5817 apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at https://www.electropedia.org/

4 Symbols and abbreviations

For the purposes of this document, the symbols given in Table 1 apply

© ISO 2021 – All rights reserved

Documents
Document Sharing Hub
Full document details: BS EN ISO 10675-1:2021