

JIS

JAPANESE INDUSTRIAL STANDARD

**Standard Qualification Procedure
for Radiographic Testing
Technique of Welds**

JIS Z 3861 —1979

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JAPANESE INDUSTRIAL STANDARD

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Standard Qualification Procedure for Radiographic
Testing Technique of Welds Z 3861-19791. Scope

This Japanese Industrial Standard specifies the standard qualification procedure for radiographic testing technique of welds of such materials as steel, stainless steel, aluminum and titanium.

2. Types of Tests and Testing Method

The types of tests and the test specimens shall conform to Table 1. The testing method shall consist of radiography, observation on radiographs and classification.

Table 1. Types of Tests and Test Specimens

Type	Object of photographing	Test specimen
Type B ⁽¹⁾	Butt weld zone of flat plates	Flat plate test specimen (4 mm thick.)
Type F	Fillet weld zone	Fillet weld test specimen (6 mm thick.)
Type T	Butt weld zone of pipes	Pipe test specimen (wall thickness 6 mm, external diameter 100 mm)

Note ⁽¹⁾ Type B shall be regarded as the standard of radiographic testing technique.

Applicable Standards:

JIS H 4000-Aluminium and Aluminium Alloy Sheets and Plates, Strip and Coiled Sheets

JIS H 4080-Aluminium and Aluminium Alloy Seamless Pipes and Tubes

JIS H 4160-Aluminium and Aluminium Alloy Foils

JIS Z 3104-Methods of Radiographic Test and Classification of Radiographs for Steel Welds

JIS Z 3105-Methods of Radiographic Test and Classification of Radiographs for Aluminium Welds

JIS Z 3108-Methods of Radiographic Test for Circumferential Butt Welds of Aluminium Pipes and Tubes

Reference Standards:

JIS Z 3106-Method of Radiographic Test and Classification of Radiographs for Stainless Steel Welds

JIS Z 3107-Methods of Radiographic Test and Classification of Radiographs for Titanium Welds