



Standard Reference Radiographs for Inspection of Aluminum and Magnesium Castings¹

This standard is issued under the fixed designation E155; 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.

These Reference Radiographs have been developed in cooperation with the Quality Control Committee and Aerospace Research and Testing Committee of the Aerospace Industries Association.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 These reference radiographs illustrate the types and degrees of discontinuities that may be found in aluminum-alloy and magnesium-alloy castings. The castings illustrated are in thicknesses of ¼ in. (6.35 mm) and ¾ in. (19.1 mm). The reference radiograph films are an adjunct to this document and must be purchased separately from ASTM International if needed.

1.2 These film reference radiographs are not intended to illustrate the types and degrees of discontinuities found in aluminum-alloy and magnesium-alloy castings when performing digital radiography. If performing digital radiography of aluminum-alloy castings, refer to Digital Reference Image Standard E2422. If performing digital radiography of magnesium-alloy castings, refer to Digital Reference Image Standard E2869.

1.3 This document may be used where no other applicable document exists, for other material thicknesses for which it has been found to be applicable and for which agreement has been reached between the purchaser and the manufacturer.

1.4 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered 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 and health practices and determine the applicability of regulatory limitations prior to use.*

NOTE 1—Vol I: The set of reference radiographs consists of 13 plates covering discontinuities in aluminum-alloy castings and 10 plates covering discontinuities in magnesium-alloy castings. Each plate is held in an

8½ by 11-in. (216 by 279-mm) cardboard frame and each plate illustrates eight grades of severity for the discontinuity in approximately a 2 by 2-in. (51 by 51-mm) area. The cardboard frames are contained in a 10½ by 11½-in. (267 by 292-mm) ring binder. The reference radiographs are not impacted by this revision. There have been no revisions to the adjunct reference radiographs since original issue. The adjunct reference radiographs of any issue remain valid and may be used to this standard.

Vol. II: The set of reference radiographs consists of four plates covering discontinuities in magnesium-alloy castings only. Each plate is held in an 8½ by 11-in. (216 by 279-mm) cardboard frame and illustrates eight grades of severity for the discontinuity (with the exception of discrete discontinuities, where only one example of each discontinuity is given).

NOTE 2—Reference radiographs applicable to aluminum and magnesium die castings up to 1 in. (25 mm) in thickness are contained in Reference Radiographs E505.

2. Referenced Documents

2.1 ASTM Standards:²

E94 Guide for Radiographic Examination

E505 Reference Radiographs for Inspection of Aluminum and Magnesium Die Castings

E1316 Terminology for Nondestructive Examinations

E2422 Digital Reference Images for Inspection of Aluminum Castings

E2869 Digital Reference Images for Magnesium Castings

2.2 ASTM Adjuncts:

Reference Radiographs for Inspection of Aluminum and Magnesium Castings:

Volume I, Aluminum and Magnesium Castings³

Volume II, Magnesium Castings⁴

3. Terminology

3.1 *Definitions*—Definitions of terms used in this standard may be found in Terminology E1316.

3.2 *Definitions of Terms Specific to This Standard:*

¹ These reference radiographs are under the jurisdiction of ASTM Committee E07 on Nondestructive Testing and are the direct responsibility of Subcommittee E07.02 on Reference Radiological Images.

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

³ Available from ASTM International Headquarters. Order Reference Radiograph No. RRE015501.

⁴ Available from ASTM International Headquarters. Order Reference Radiograph No. RRE015502.

3.2.1 The terms relating to discontinuities used in these reference radiographs are described based upon radiographic appearance.

3.2.2 *foreign materials*—appear as isolated, irregular, or elongated variations of film density, not corresponding to variations in thickness of material, nor to cavities. They may be due to the presence of sand, slag, oxide or dross, or metal of different density.

3.2.3 *gas holes*—appear as round or elongated, smooth-edged dark spots, occurring individually, in clusters, or distributed throughout the casting.

3.2.4 *gas porosity*—represented by round or elongated dark spots corresponding to minute voids usually distributed through the entire casting.

3.2.5 *microshrinkage (feathery type)*—microshrinkage having an elongated appearance resembling feather-like streaks.

3.2.6 *microshrinkage (sponge type)*—microshrinkage having a spongelike appearance, and more massive and equiaxed than the feathery type.

3.2.7 *reacted sand inclusions*—appear on radiograph as “spotty segregation,” that is, sharply defined round light areas, about 1 mm in diameter, and often with the rim lighter than the center. They are entrapped sand particles that underwent reaction with molten magnesium alloys containing zirconium (Note 3).

3.2.8 *segregations*—appear as variations in film density which can be explained by segregation of elements of atomic numbers different from that of the matrix.

3.2.8.1 *gravity segregation*—appears white on radiograph and may range from a mottling-type effect through white-diffused spots blending with the matrix, to a cloud-like appearance in more severe cases. They are agglomerations of particles precipitated at temperatures above liquidus (Note 3).

3.2.8.2 *eutectic segregation*—type of segregation is generally represented when a defect or discontinuity develops during solidification and is fed with a near eutectic residual liquid rich with alloying elements that have a high X-ray attenuation. One exception to this enrichment as illustrated in Reference Radiographs E155 is flow line (or eutectic depletion), where there is a local impoverishment of the alloying elements that have a high X-ray attenuation (Note 3).

(1) *eutectic segregation—microshrinkage type*—type of segregation develops when a microshrinkage develops during solidification, and is fed with residual liquid rich in dense alloying elements such as thorium. The area will show light on a radiograph (Note 3).

(2) *eutectic segregation—pipe-shrink type*—type of segregation develops during solidification when a pipe shrink forms and is immediately filled with eutectic liquid rich in high X-ray attenuation alloying elements. The area shows light on a radiograph as a feathery or dendritic feature (Note 3).

(3) *eutectic segregation—hot-tear type*—type of segregation develops during solidification when the hot tear that takes place is immediately filled with liquid rich in alloying elements high in X-ray attenuation. The defect shows as white or light irregular defined lines (Note 3).

(4) *eutectic depletion—flow line*—type of segregation develops when a section of a mold is filled by liquid and solidifies at the front before liquid from another feed meets the solid front. A portion of the solid front then partially melts; otherwise, the discontinuity would be a cold shut. Solidification begins after this remelt and the initial crystals are of high purity and contain fewer high-density alloying elements than the melt average. Since the metal is still flowing across these crystals, the composition ahead of this solidifying front is depleted. This depletion of the eutectic shows on the radiograph as a dark diffused line (Note 3).

(5) *oxide inclusions in magnesium alloys containing zirconium*—show on a radiograph as well defined light area of irregular shape and size resembling a radiograph of a compacted fine steel wool. It is composed of complex magnesium oxide film with high zirconium content, and, if present, rare earths and thorium oxides also. It is often associated with zirconium-rich particles.

NOTE 3—More detailed descriptions of these discontinuities can be found in the article, “New Reference Radiographs for Magnesium Alloy Castings,” by B. Lagowski, published in the *Journal of Testing and Evaluation*, Vol 2, No. 4, July 1974.

3.2.9 *shrinkage cavity*—appears as a dendritic, filamentary, or jagged darkened area.

3.2.10 *shrinkage porosity or sponge (nonferrous alloys)*—a localized lacy or honeycombed darkened area.

4. Significance and Use

4.1 These radiographs are intended for reference only but are so designed that acceptance standards, which may be developed for particular requirements, can be specified in terms of these radiographs. The illustrations are radiographs of castings that were produced under conditions designed to develop the discontinuities. The radiographs of the ¼-in. (6.35-mm) castings are intended to be used in the thickness range up to and including ½ in. (12.7 mm). The radiographs of the ¾-in. (19.1-mm) castings are intended to be used in the thickness range of over ½ in. to and including 2 in. (51 mm). The grouping and system of designations are based on considerations of the best practical means of making these reference radiographs of the greatest possible value.

4.2 *Film Deterioration*—Radiographic films are subject to wear and tear from handling and use. The extent to which the image deteriorates over time is a function of storage conditions, care in handling and amount of use. Reference radiograph films are no exception and may exhibit a loss in image quality over time. The radiographs should therefore be periodically examined for signs of wear and tear, including scratches, abrasions, stains, and so forth. Any reference radiographs which show signs of excessive wear and tear which could influence the interpretation and use of the radiographs should be replaced.

5. Basis for Application

5.1 The reference radiographs may be applied as acceptance standards tailored to the end use of the product. Application of these reference radiographs as acceptance standards should be

based on the intended use of the product and the following considerations (see [Note 4](#)).

5.1.1 Compare the production radiographs of the casting submitted for evaluation with the reference radiographs applicable to designated wall thickness in accordance with the written acceptance criteria.

5.1.2 An area of like size to that of the reference radiograph shall be the unit area by which the production radiograph is evaluated, and any such area shall meet the requirements as defined for acceptability.

5.1.3 Any combination or portion of these reference radiographs may be used as is relevant to the particular application. Different grades or acceptance limits may be specified for each discontinuity type. Furthermore, different grades may be specified for different regions or zones of a component.

5.1.4 Special considerations may be required where more than one discontinuity type is present in the same area. Any modifications to the acceptance criteria required on the basis of multiple discontinuity types must be specified.

5.1.5 Where the reference radiographs provide only an ungraded illustration of a discontinuity, acceptance criteria may be specified by referencing a maximum discontinuity size, or percentage of the discontinuity size illustrated.

5.1.6 Production radiographs showing porosity, gas, shrinkage, or inclusions shall be evaluated by the overall condition with regard to size, number, and distribution. The aggregate size of discontinuities shall not exceed the total accumulation in area of the discontinuities of the reference radiograph. It is not the intent that the maximum size of the illustrated discontinuity shall be the limiting size for a single production radiographic discontinuity, or that the number of discontinuities shown on the reference radiograph shall be the limiting number for production radiographs. Also, caution should be exercised in judging a large discontinuity against a collection of small discontinuities on the basis of size alone. Each of the factors of size, number, and distribution must be considered in balance. The purchaser may provide documented specific methods of evaluation.

5.1.7 When the severity level of discontinuities per unit in the production radiograph being evaluated is equal to or better than the severity level in the specified reference radiograph, that part of the casting represented by the production radiograph shall be acceptable. If the production radiograph shows discontinuities per unit area of greater severity than the reference radiograph, that part of the casting shall not be accepted.

5.1.8 As a minimum the acceptance criteria should contain information addressing: zoning of the part (if applicable), the acceptable severity level for each discontinuity type, and the specified area to which the reference radiographs are to be applied.

NOTE 4—Caution should be exercised in specifying the acceptance criteria to be met in a casting. Casting design coupled with foundry practice should be considered. It is advisable to consult with the manufacturer/foundry before establishing the acceptance criteria to ensure the desired quality level can be achieved.

6. Description

6.1 The radiographs listed in [Table 1](#) illustrate each type of

TABLE 2 Reference Radiographs for Magnesium Castings—Volume II

Discontinuity	Casting Thickness, in. ^A	Applicable Casting Thickness, in. ^A
Eutectic segregation (discrete discontinuities)—pipeshrink, flow line, hot tears, oxide inclusions	1/4	all thicknesses
Reacted sand inclusion	1/4	all thicknesses
Eutectic segregation (microshrinkage type)	1/4	all thicknesses
Gravity segregation	1/4	all thicknesses

^A 1 in. = 25.4 mm.

discontinuity in eight grades. The radiographs listed in [Table 2](#) illustrate each type of discontinuity in eight grades, with the exception of pipe shrink, flow line, hot tear and oxide inclusion, where a single ungraded illustration is given for each. Although eight grades of each discontinuity are shown (with the above exceptions), a numerically smaller graded set of discontinuities based on these reference radiographs could be used for acceptance standards. Each grade is illustrated in approximately a 2 by 2-in. (51 by 51-mm) area. The radiographic technique used is in agreement with [Guide E94](#), and produced a desired density of 2.0 to 2.25.

6.2 The alloys used to reproduce the various discontinuities were as listed in [Table 3](#).

NOTE 5—Misruns, core shift, cold shut, and surface irregularities are not illustrated, as they are readily identifiable by surface inspection or by

TABLE 1 Reference Radiographs for Aluminum and Magnesium Castings—Volume I

Discontinuity	Casting Thickness, in. ^A	Applicable Casting Thickness, in. ^A
Aluminum-Alloy Castings		
Gas holes	1/4	up to 1/2, incl
Gas holes	3/4	over 1/2 to 2, incl
Gas porosity (round)	1/4	up to 1/2, incl
Gas porosity (round)	3/4	over 1/2 to 2, incl
Gas porosity (elongated)	1/4	up to 1/2, incl
Gas porosity (elongated)	3/4	over 1/2 to 2, incl
Shrinkage cavity	1/4	All thicknesses
Shrinkage (sponge)	1/4	up to 1/2, incl
Shrinkage (sponge)	3/4	over 1/2 to 2, incl
Foreign material (less dense)	1/4	up to 1/2, incl
Foreign material (less dense)	3/4	over 1/2 to 2, incl
Foreign material (more dense)	1/4	up to 1/2, incl
Foreign material (more dense)	3/4	over 1/2 to 2, incl
Magnesium-Alloy Castings		
Gas holes	1/4	up to 1/2, incl
Gas holes	3/4	over 1/2 to 2, incl
Microshrinkage (feathery)	1/4	up to 1/2, incl
Microshrinkage (feathery)	3/4	over 1/2 to 2, incl
Microshrinkage (sponge)	1/4	up to 1/2, incl
Microshrinkage (sponge)	3/4	over 1/2 to 2, incl
Foreign material (less dense)	1/4	up to 1/2, incl
Foreign material (less dense)	3/4	over 1/2 to 2, incl
Foreign material (more dense)	1/4	up to 1/2, incl
Foreign material (more dense)	3/4	over 1/2 to 2, incl

^A 1 in. = 25.4 mm.

TABLE 3 Actual Alloys Used to Reproduce Discontinuities

Discontinuity	Alloy Used
Aluminum	
Gas holes	356
Gas porosity (round)	356
Gas porosity (elongated)	195
Shrinkage cavity	356
Shrinkage (sponge)	356
Foreign material (less dense)	356
Foreign material (more dense)	356
Magnesium	
Gas holes	ZK51A
Eutectic segregation and flow line	EZ33A
Gravity segregation	ZK91
Microshrinkage (feathery)	AZ91C
Microshrinkage (sponge)	AZ91C
Foreign material (less dense)	AZ91C
Foreign material (more dense)	AZ91C
Reacted sand inclusions	HK31A
Oxide inclusion in magnesium alloys containing zirconium	HZ11

other means of nondestructive testing.

6.3 All of these references are original radiographs; they should be viewed by transmitted light.

7. Keywords

7.1 aluminum; castings; discontinuities; magnesium; reference radiographs; X-ray

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