

# JIS

**JAPANESE INDUSTRIAL STANDARD**

**Methods of radiographic  
examination for welded  
joints in steel**

**JIS Z 3104**<sup>—1995</sup>

**Translated and Published**

**by**

**Japanese Standards Association**

In the event of any doubt arising,  
the original Standard in Japanese is to be final authority.

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Methods of radiographic examination  
for welded joints in steel

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1. Scope This Japanese Industrial Standard specifies the methods of radiographic examination for welded joints in steel by the direct radiography by X-ray or  $\gamma$ -ray (hereafter referred to as "radiation") using X-ray films for industrial use.

Remarks 1. The standards cited in this Standard are as follows:

- JIS G 3101 Rolled steel for general structure
- JIS G 4304 Hot rolled stainless steel plates, sheets and strip
- JIS G 4305 Cold rolled stainless steel plates, sheets and strip
- JIS K 7652 Photography – Density measurements - Part 2: Geometric conditions for transmission density [ISO 5-2: 1991]
- JIS K 7653 Photography – Density measurements - Part 3: Spectral conditions [ISO 5-3: 1984]
- JIS Z 2300 Glossary of terms used in nondestructive testing
- JIS Z 2306 Radiographic image quality indicators for non-destructive testing
- JIS Z 3861 Standard qualification procedure for radiographic testing technique of welds
- JIS Z 4560 Industrial  $\gamma$ -ray apparatus for radiography
- JIS Z 4561 Viewing illuminators for industrial radiograph
- JIS Z 4606 Industrial X-ray apparatus for radiographic testing

2. The corresponding International standards of this standard are given in the following:

- ISO 1106/1 : 1984 Recommended practice for radiographic examination of fusion welded joints – Part 1: Fusion welded butt joints in steel plates up to 50 mm thick
- ISO 1106/2 : 1985 Recommended practice for radiographic examination of fusion welded joints – Part 2: Fusion welded butt joints in steel plates thicker than 50 mm and up to and including 200 mm in thickness
- ISO 1106/3 : 1984 Recommended practice for radiographic examination of fusion welded joints – Part 3: Fusion welded circumferential joints in steel pipes of up to 50 mm wall thickness
- ISO 5579 : 1984 Non-destructive testing – Radiographic examination of metallic materials by X- and gamma rays – Basic rules