



GUIDE TO ASTM E446

REFERENCE RADIOGRAPHS FOR STEEL CASTINGS UP TO 2 In.(50.8 mm) IN THICKNESS

MEET 2020

E. Hosami
Quality Control Department

Category A—Gas porosity; severity levels 1 through 5.



Source : ASTM E446

Gas porosity
A

Level 1

Level 2

Level 3

Level 4

Level 5

Gas porosity

Sand and
slag inclusions

Linear shrinkage
Ca

Feathery shrinkage
Cb

Sponge shrinkage
Cc

Combinations
of linear Cd

Crack + Hot tear
D+E

Insert + Mottling
F+G

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