



CERTIFICATION SCHEME FOR PERSONNEL

**Document No. CSWIP-ISO-NDT-11/93-R  
Requirements for the Certification of Personnel Engaged in Non-Destructive Testing in accordance with the requirements of EN 473 and ISO 9712**

**APPENDIX 1**

**Examination Format and Syllabus for the Certification of Personnel engaged in Non-Destructive Testing of Welded Joints and General Engineering Components**

**PART 5: Radiographic Inspector Levels 1, 2 and 3**

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These syllabi are applicable to candidates seeking certification in accordance with Document CSWIP-ISO-NDT-11/93- Requirements for the Certification of Personnel engaged in Non-Destructive Testing.

## **RADIOGRAPHIC INSPECTOR EXAMINATION FORMAT**

### **1 Level 1**

#### **1.1 General theory examination**

- 40 multiple choice questions on general theory
- 20 multiple choice questions on basic radiation safety
- Time allowed 90 minutes
- Pass mark 70%

#### **1.2 Specific theory examination**

- 20 multiple choice questions
- Time allowed 30 minutes
- Pass mark 70%

#### **1.3 General practical examination**

The candidate is required to conduct a test selected by the examiner from:

Check film for fog level  
Check fix for clearing  
Check safelight.

- Time allowed 30 minutes
- Pass mark 70%

#### **1.4 Specific practical examination**

##### **1.4.1 Welds**

In the practical part of the specific examination, the candidate is required to test a plate butt weld and a pipe butt weld in materials selected by the examiner and to evaluate the quality of the radiographs produced.

- Time allowed 4 hours.
- Pass mark 70%

##### **1.4.2 Castings**

In the practical part of the specific examination, the candidate is required to test a minimum of two castings of simple form in materials selected by the examiner and to evaluate the quality of the radiographs produced.

- Time allowed 4 hours.
- Pass mark 70%

**Note:** Both written examinations and practical tests will be selected according to the category of certification being sought with particular reference to the material group(s) and type of radiation.

## **2 Level 2**

### **2.1 General theory examination**

- 40 multiple choice questions on general theory
- 20 multiple choice questions on basic radiation safety
- Time allowed 90 minutes
- Pass mark 70%

### **2.2 Specific theory examination**

- 20 multiple choice questions
- Time allowed 30 minutes
- Pass mark 70%

### **2.3 General practical examination**

The candidate is required to conduct a test selected by the examiner from:

Film fog level  
Fixer for clearing  
Safe light.

- Time allowed 30 minutes
- Pass mark 70%

### **2.4 Specific practical examination**

#### **2.4.1 Welds**

In the practical part of the specific examination, the candidate is required to prepare detailed reports for testing four samples and to evaluate the radiographs produced for areas requiring further investigation.

Candidates are in addition required to produce a detailed NDT instruction, suitable for a Level 1 to follow, for one of the samples selected by the examiner.

The samples will be selected randomly by the Examiner/Invigilator from the following categories:

Plate butt welds (3.1)  
Pipe butt welds (3.2)  
Variable configuration joints (3.7)

- Time allowed 8 hours
- Pass mark 70%

### **2.5 Specific practical - castings**

In the practical part of the specific examination, the candidate is required to prepare detailed reports for testing two samples and to evaluate the radiographs produced for areas requiring further investigation.

Candidates are in addition required to produce a detailed NDT instruction, suitable for a Level 1 to follow, for one of the samples selected by the examiner.

- Time allowed 4 hours
- Pass mark 70%

**Note:** Both written examinations and practical tests will be selected according to the sector and category of certification being sought with particular reference to the material group(s) and type of radiation.

### **3 Level 3**

#### **3.1 Basic examination (exempt if already holding Level 3)**

##### **Section A1 – Material Science and Process Technology**

- 30 multiple choice questions
- Time allowed 45 minutes.
- Pass mark 70%

##### **Section A2 – Knowledge of the Certification Scheme**

- 10 multiple choice questions
  - Time allowed 15 minutes.
  - Pass mark 70%
- This section of the examination is open book.

##### **Section B – Level 2 Knowledge of other NDT Methods**

- 60 multiple choice questions
- Time allowed 90 minutes
- Pass mark 70%

Exemptions may be available for holders of Level 2 certification in the main NDT methods

#### **3.2 Main method examination**

##### **Section C1 – Level 3 General Theory**

- 30 multiple choice questions
- Time allowed 45 minutes
- Pass mark 70%

##### **Section C2 – Application of the NDT Method**

- 20 multiple choice questions
- Time allowed 30 minutes
- Pass mark 70%

##### **Section C3 – Procedure Writing**

The candidate is required to draft an NDT procedure for a component selected by the examiner.

- Time allowed 4 hours
- Pass mark 70%

### **4 Ten Year Examination**

Level 1 and Level 2 candidates whose certificates expire at the end of the maximum ten year period of validity will be required to undertake a renewal examination comprising practical tests only as detailed below.

Level 3 candidates should refer to CSWIP-ISO-NDT-11/93-R, Section 7.5.3.

#### **4.1 Level 1 Radiographic Inspector**

##### **4.1.1 Welds**

The candidate is required to test a plate butt weld and a pipe butt weld in materials selected by the examiner and to evaluate the quality of the radiographs produced.

- Time allowed 4 hours
- Pass mark 70%.

##### **4.1.2 Castings**

The candidate is required to test a minimum of two castings of simple form in materials selected by the examiner and to evaluate the quality of the radiographs produced.

- Time allowed 4 hours
- Pass mark 70%.

**Note:** Tests will be selected according to the category of certification being renewed with particular reference to the material group(s) and type of radiation.

#### **4.2 Level 2 Radiographic Inspector**

##### **4.2.1 Welds**

The candidate is required to prepare detailed reports for testing four samples and to evaluate the radiographs produced for areas requiring further investigation.

Candidates are in addition required to produce a detailed NDT instruction, suitable for a Level 1 to follow, for one of the samples selected by the examiner.

The samples will be selected randomly by the Examiner/Invigilator from the following categories:

Platt butt welds (3.1)  
Pipe butt welds (3.2)  
Variable configuration joints (3.7)

- Time allowed 8 hours
- Pass mark 70%.

##### **4.2.2 Castings**

The candidate is required to prepare detailed reports for testing two samples and to evaluate the radiographic produced for areas requiring further investigation.

Candidates are in addition required to produce a detailed NDT instruction, suitable a Level 1 to follow, for one of the samples selected by the examiner.

- Time allowed 4 hours
- Pass mark 70%.

**Note:** Tests will be selected according to the category of certification being renewed with particular reference to the material group(s) and type of radiation.

## **5 Level 1 Radiographic Inspector (Welds) Syllabus**

### **5.1 General theory**

#### **a. Nature and properties of X and/or Gamma Radiation**

Penetration, absorption, scatter, diffraction, transmission. Rectilinear propagation. Photographic, fluorescent and ionising effects. Physiological properties.

#### **b. Photographic aspects**

Dark room procedures: layout, light traps and entrance, wet and dry benches, film-pass hatches, processing units, safe-lights and ancillary equipment. Handling and processing of films, temperature control.

Sensitometry: types of film and paper used in industrial radiography.

The use of screens

#### **c. Fundamental aspects of radiographic quality**

Quality of radiation. Optimum working densities. Radiographic contrast. Objective and subjective contrast. Methods of controlling radiographic contrast. Effects of scattered radiation. Use of filters, screens, masking and blocking media. Brief reference to grids. Influence of processing conditions and viewing conditions on contrast.

Radiographic definition: objective and subjective, unsharpness, geometric unsharpness, inter-relationship of dimensions of focal spot or source, focus (source) – object and focus (source) – film distances. Inherent unsharpness. Movement. Film screen contact. The summation of factors controlling definition. Control of radiographic sensitivity and its assessment by the use of image quality indicators.

#### **d. X-ray equipment**

Generation of X-rays, their characteristics and selection. Handling equipment

#### **e. Geometry of image formation**

Control of focus (source) – object distance, object – film distance, focus (source) – film distance. Selection of beam angle.

#### **f. Safety**

An understanding of working practices including safety precautions (see recommended reading).

### **5.2 Specific Theory**

#### **a. Exposure calculations**

Effect of distance on exposure. Use of exposure charts and calculators for X and gamma radiography.

#### **b. Geometric considerations of radiography for welds and castings**

Flaw depth determination in a specimen by the tube or source shift method.

Geometric unsharpness and its control

### **c. Viewing of radiographs**

Spurious indications: light (and safe-light) fogging, chemical fog, strains, air bubbles, reticulation, pressure marks, static marks, drying marks, finger marks, defective screens, incomplete fixing, film manufacturing faults.

Optimum viewing conditions. Checking for acceptable density, contrast and freedom from spurious indications.

### **d. Standards and Specifications**

The standards and specifications to be used will be relevant to the region in which the examination is to be conducted and to the employment of the candidate.

### **e. Welding technology**

Terminology for welds, welded joints, welding procedures. Types of defect in welds and parent metals detectable by radiographic inspection.

### **f. Casting technology**

Types of castings: sand casting, investment castings, pressure die- castings.

Typical defects in cast materials.

## **6 Level 2 Radiographic Inspector (Welds) Syllabus**

### **6.1 General theory**

As for Level 1 but the examination questions will be more complex.

### **6.2 Specific theory**

As for level 1 but in addition:

#### **a. Welding technology**

Influence on techniques of geometry, size, surface condition, parent metal composition, weld metal structure. Influence of surface cladding, heat treatments and weld repairs.

Basic principles of fusion welding processes.

Types of defect associated with particular parent metal/welding process combinations. Defect parameters which influence detectability.

## **7 Level 2 Radiographic Inspector (Castings) Syllabus**

### **7.1 General Theory**

As for Level 1 but the examination questions will be more complex.

### **7.2 Specific Theory**

As for level 1 but in addition:

#### **a. Casting technology**

Influence on techniques of geometry, size, surface condition, parent metal composition, feeding and cooling effects on defect formation. Influence of heat treatments and weld repairs.

Basic principles of casting processes.

Types of defect associated with particular materials and casting process combinations. Defect parameters and their influence on detection.

## **8 Level 3 Radiographic Inspection Syllabus**

### **8.1 General Theory**

#### **8.1.1 Section A**

##### **1. Materials, Processes and Product Technology**

###### **Material Technology**

Properties of materials, origin of discontinuities and failure modes, statistical process control and probability of detection.

###### **Basic Production – Crude and Finished Products**

Ingot types narrow end up and wide end up, concast methods (continuous casting process). Definition used in the production of ingots and casting.

Difference between ingot and concast production processes.

Ingot casting further hot working, rolling, forging and extrusion.

###### **Basic Casting Production Methods – Finished Products**

Methods of casting: sand casting, die casting, investment casting

Basic defects associated with cast products, their appearance and how they are formed: shrinkage, inks, cold shuts, porosity, laps, hot tears, cracks.

###### **Wrought Production Processes**

Rolling process: primary rolling – blooms and slabs, secondary rolling, billets, sections and plates, cold rolling, sheets and strips, basic rolling defects, appearance and how they are formed

Forging: open die forging and press forging, closed die forging

Basic forging defects, their appearance and how they are formed: forging bursts, laps, seams, cracks

Extrusion: definition of and how it works, why extrusion is used instead of rolling or forging

###### **Heat Treatment Processes**

Annealing. How annealing is carried out and the results obtained, full anneal and definitions, sub critical anneal and definition

Normalising: how it is carried out and the results obtained.

Stress relieving. Why stress relieving is and why it is carried out.

###### **Machining and Material Removal**

Turning, boring, milling, grinding and electrochemical.

## **Surface Finishing and Corrosion Protection.**

Shot peening, grit blasting, painting, plating, chemical conversion coatings.

## **Non-metals and composite materials processing**

### **Dimensional Metrology**

## **2. Other NDT Methods**

### **Acoustic Emission**

Principles, sources of acoustic emissions, equipment and materials, proper selection of technique

### **Electromagnetic Testing**

Principles, properties of eddy currents, effect of varying frequency, equipment, application and test results interpretation.

### **Thermography**

Principles, temperature measurement, technique selection, equipment, application and test results interpretation.

### **Magnetic Particle Inspection**

Principles, technique selection, equipment, application and test results interpretation.

### **Liquid Penetrant Inspection**

Principles, technique selection, equipment, application and test results interpretation.

### **Radiographic Inspection**

Principles, technique selection, equipment, application and test results interpretation.

### **Ultrasonic Inspection**

Principles, technique selection, equipment, application and test results interpretation.

### **Visual and Optical Inspection**

Principles, technique selection, equipment, application and test results interpretation.

## **3. Standards and Documentation Relating to the Certification of NDT Operators**

ISO 9712, EN 473, SNT-TC-1A

### **8.1.2 Section B**

Candidates for Level 3 examinations will be questioned on the contents of the syllabus for Levels 1 and 2, the questions will however be of a more complex nature.

### **8.2 Specific Theory**

Candidates for Level 3 examinations will be questioned on the contents of the syllabus for Levels 1 and 2, the questions will however be of a more complex nature. Candidates will in addition require a knowledge of the following:

### **Alternative forms of imaging**

Fluoroscopy, Real time radiography, digital imaging

### **Alternative Equipment**

Micro focus X-ray equipment, linear accelerators, neutron radiography

## **9 Reference Literature**

Product Technology Classroom Training Handbook – The British Institute of Non-Destructive Testing.

An introduction to Industrial Radiology Techniques by R Halmshaw. Wykeham Publications.

Basic Metallurgy for NDT. British Institute of NDT.

Data Sheets for Industrial Radiography. Kodak Limited, London.

Handbook of Radiographic Apparatus and Techniques, a concise guide to the radiography of welds. The Welding Institute.

Industrial Radiography. Agfa-Gevaert Limited. Brentford, Middlesex.

Industrial Radiography. Kodak Limited, London.

Non-Destructive Testing (second edition, 1991) by R Halmshaw. Edward Arnold.

Recent Developments in Non-Destructive Testing. The Welding Institute.

The Physics of Industrial Radiography by R Halmshaw. Heywood.

ASNT Classroom Training Handbook. Originally published by General Dynamics.

ASNT Self Study Handbook. Originally published by General Dynamics.

ASNT Question and Answer Book.

ASNT Level III Study Guide.

ASNT Student Package.

ASNT Instructor Package (overheads for training).