

MIL-STD-775(SHIPS)

15 November 1962

MILITARY STANDARD

**X-RAY STANDARDS FOR WELDING
ELECTRODE QUALIFICATION TEST WELDS**



FSC MISC

GENERAL FINE COPY
DO NOT REMOVE

MIL-STD-775(SHIPS)
15 November 1962

DEPARTMENT OF THE NAVY

BUREAU OF SHIPS

WASHINGTON 25, D.C.

X-Ray Standards for Welding
Electrode Qualification Test Welds

MIL-STD-775(SHIPS)

1. This standard has been approved by the Bureau of Ships, and is mandatory for use by activities under the cognizance of the Bureau of Ships effective 15 November 1962.

2. Recommended corrections, additions, or deletions should be addressed to the Chief, Bureau of Ships Department of the Navy, Washington 25, D. C.

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Copies of this standard for Military use may be obtained as indicated in the foreword to, or the general provisions of, the Index of Military Specifications and Standards.

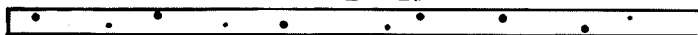
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Navy - Ships
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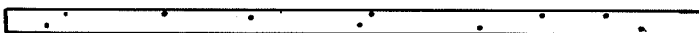
T=1/8" TO AND INCLUDING 1/4" THICK

ASSORTED-RANDOMLY DISPERSED

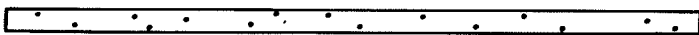


ALL SIZES TO 1/32" IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6" = 10

MEDIUM-RANDOMLY DISPERSED



1/64" TO 1/32" MAX IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6" = 10
FINE-RANDOMLY DISPERSED



UP TO 1/64" IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6" = 15

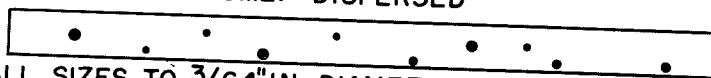
SH7272

Figure 1

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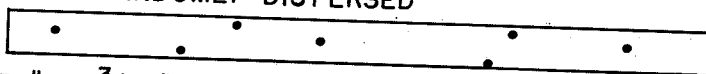
T=OVER 1/4" TO AND INCLUDING 1/2" THICK

ASSORTED-RANDOMLY DISPERSED



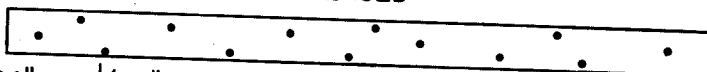
ALL SIZES TO 3/64" IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6"=10, 3 LARGE,
3 MED, AND 4 FINE

LARGE-RANDOMLY DISPERSED



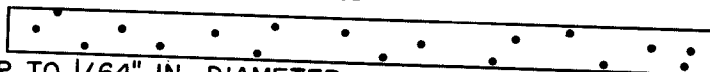
1/32" TO 3/64" MAX IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6"=7

MEDIUM-RANDOMLY DISPERSED



1/64" TO 1/32" IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6"=13

FINE-RANDOMLY DISPERSED



UP TO 1/64" IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6"=18

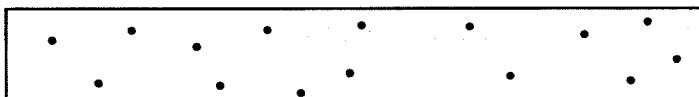
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Figure 2

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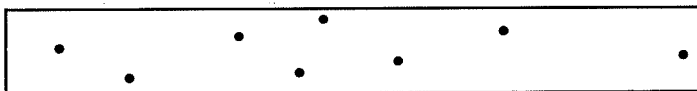
T=OVER 1/2" TO AND INCLUDING 1" THICK

ASSORTED-RANDOMLY DISPERSED

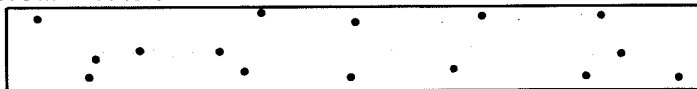


ALL SIZES TO 1/16" IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6"= 15

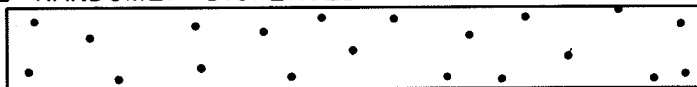
LARGE-RANDOMLY DISPERSED



3/64" TO 1/16" MAXIMUM IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6"= 8
MEDIUM-RANDOMLY DISPERSED



1/32" TO 3/64" IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6"= 15
FINE-RANDOMLY DISPERSED



UP TO 1/32" IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6"= 20

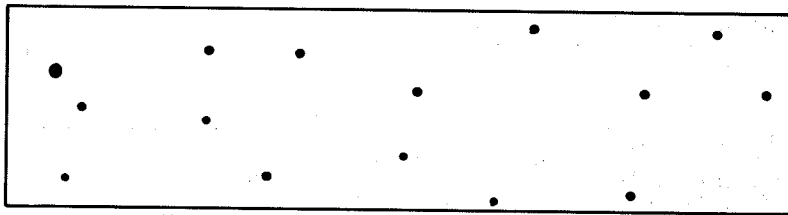
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Figure 3

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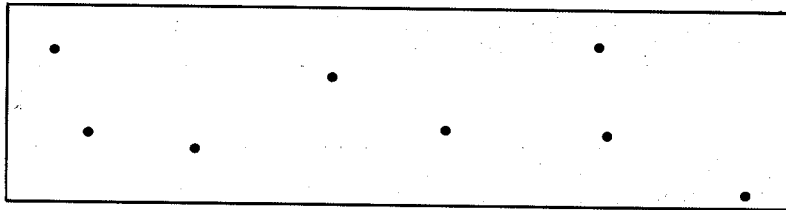
T=OVER 1" TO AND INCLUDING 2" THICK

ASSORTED - RANDOMLY DISPERSED



ALL SIZES TO $3/32$ " IN DIAMETER
MAXIMUM NUMBER OF TOTAL INDICATIONS IN 6"=15

LARGE - RANDOMLY SPACED



$1/16$ " TO $3/32$ " MAXIMUM IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6"= 8

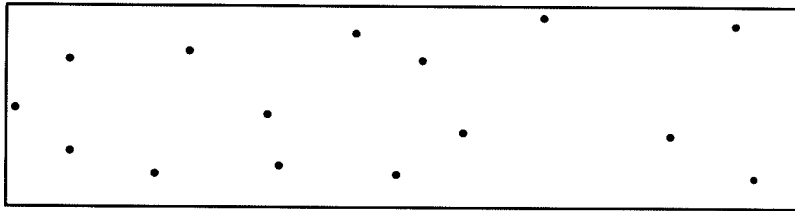
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Figure 4

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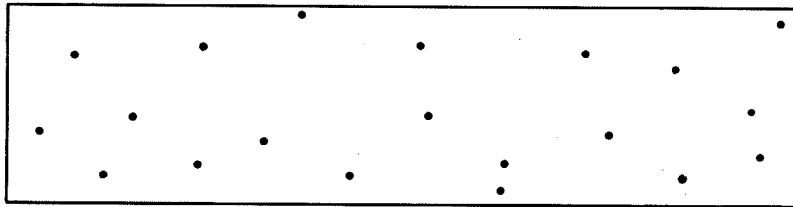
T=OVER 1" TO AND INCLUDING 2" THICK

MEDIUM-RANDOMLY DISPERSED



$\frac{3}{64}$ " TO $\frac{1}{16}$ " IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6"= 15

FINE-RANDOMLY DISPERSED



UP TO $\frac{3}{64}$ " IN DIAMETER
MAXIMUM NUMBER OF INDICATIONS IN 6"= 20

SH7276

Figure 5