



10675-2—
2025

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(ISO 10675-2:2021, IDT)

1 322 « », -

« - « » (« « ») -

4 , 4 -

2 322 « » -

3 29 2025 . 1844- -

4 10675—2:2021 « -

2. » (ISO 10675-2:2021 «Non-destructive testing of welds — Acceptance levels for radiographic testing — Part 2: Aluminum and its alloys», IDT). -

5 -

29 2015 . 162- « 26 », -

) — « (1 », -

() « », -

». , « -

— (www.rst.gov.ru)

1 1
2 1
3 2
4 2
5 2
6 3
7 3
()6
() (%) 7
() 9
() 11
..... 12

2

Non-destructive testing of welds. Acceptance levels for radiographic testing.
Part 2. Aluminum and its alloys

— 2026—04—01

1

(S =) RT-D (D =)¹⁾.

17636-1	RT-F (F =)	17636-2	RT-S
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2

ISO 6520-1, Welding and allied processes — Classification of geometric imperfections in metallic materials — Part 1: Fusion welding ()¹⁾.

ISO 10042, Welding — Arc-welded joints in aluminium and its alloys — Quality levels for imperfections ()

ISO 17636-1, Non-destructive testing of welds — Radiographic testing — Part 1: X- and gamma-ray techniques with film ()

ISO 17636-2, Non-destructive testing of welds — Radiographic testing — Part 2: X- and gamma-ray techniques with digital detectors ()

¹⁾ (, ,) , -

ISO 17637, Non-destructive testing of welds — Visual testing of fusion-welded joints ()

3

- : <https://www.iso.org/obp>
 - : <http://www.electropedia.org>

4

1— 1.

	$L * w_p$
b	
D	
d	
d_A	
h	
/	.4
L	100 (/ 10042)
s	(. 2553)
t	
w_p	
	L (L)

5

RT-F
 17636-1, 2,
 17636-2 RT-S RT-D,

3.

2— (RT-F)

10042	17636-1 RT-F	
		1
		2
D		3
17636-1.		

3 —

(RT-S)

(RT-D)

10042	17636-2	RT-S	RT-D	
				1
				2
D				3
17636-2.				

6

17637

17635

(. . .), 5:

(. . . 4).

10042

10042.

7

4 5.

10042

6520-1 (. . .).

(. . .)

(. . .).

L.

4 —

	6520-1		2	1
1	(100)			
2	(2011)	$d < 0,4s$, . 6	$d < 0,3s$, . 5	$d < 0,2s$, . 4
2	(2012), 0,5 3	$d < 0,4s$, . 6 < 6 % $L=100$	$d < 0,3s$, . 5 < 2 % $L=100$	$d < 0,2s$, . 4 < 1 % $Z_{-} = 100$
2	(2012), — >3 12	$d < 0,4s$, . 6 < 10 % $L = 100$	$d < 0,3s$, . 5 < 4 % $L=100$	$d < 0,2s$, . 4 < 2 % $L = 100$

	6520-1		2	1	
2d	(2012), — >12 30	-	$d < 0,4s$, .6 < 15% L = 100	$d < 0,3s$, .5 < 6% X = 100	$d < 0,2s$, .4 < 3% L = 100
2	(2012), — >30	-	$d < 0,4s$, .6 < 20% L = 100	$d < 0,3s$, .5 < 8% X = 100	$d < 0,2s$, .4 < 4% L = 100
	(2013)		$d_A < 25$ \wedge . max - Wp < \wedge - 0,4s, .6	$d_A < 20$ \wedge , max - "p \wedge 0,3s, .5	< 15 \wedge . " Wp/2 $d < 0,2s$, .4
	(2014)		$l < 25$, $d < 0,4s$, .6 L = 100		
5 l	(2015) (2016)		$l < 0,4s$, .6	$l < 0,3s$, .4	$l < 0,2s$, .3
6	(303)		$X / < s$, .10	$X / < 0,5s$, .5	$X / < 0,2s$, .3
7	(3041)	-	$l < 0,4s$, .6	$l < 0,3s$, .4	$l < 0,2s$, .3
8	(401)		$l < 0,3s$, .3 , , $l < 25$, L = 100		
9	(402)		$X / < 25$, L = 100	- - $l < 25$, L = 100	
<p>3 2 «X», -</p> <p>25 .</p> <p>.1 .2.</p> <p>. .4.</p> <p>d .5 .6.</p> <p>100 ,</p> <p>25 % .</p>					

	6520-1		2	1
10	(104)		$l < 0,4s$	
11	(5011)		$h < 0,2\wedge$.1	$h < 0,\wedge t$, .0,5 -
11	(5012)		$h < 0,2t$, .1,5 $l < 25$	$h < 0,1t$, .1 - $l < 25$ -
				$h < 0,1f$, .0,5 $l < 25$

5

	6520-1		2	1
12	(504) -	< 5	< 4	/? < 3
13	(515)	l < 25 h < 0,2/, . 1,5	l < 25 h < 0,1/, . 1	l < 25 h < 0,05/, . 0,5
14	(5013)	l < 25 h < 0,2/, . 1,5	l < 25 < 0,1/, . 1	l < 25 h < 0,05/, . 0,5
<p>—</p> <p>3 2 «X», , -</p> <p>25</p> <p>100 ,</p> <p>25 %</p>				

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.1

6520-1.

.2

(2011,2012, 2013, 2014 2017).
(2016 2015).

(303).

(3041).

4 5,

17636-1

RT-F,

2,

17636-2

RT-S

RT-D,

3.

(104).

(100).

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17636-1

17636-2,

.4

(401).

(402).

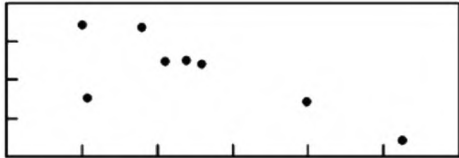
),

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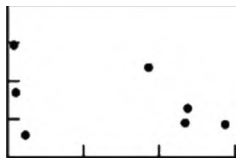
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(%)

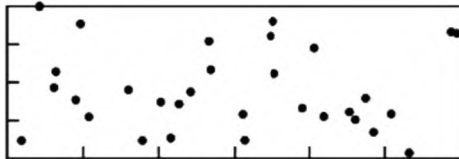
60 20 .1 .10



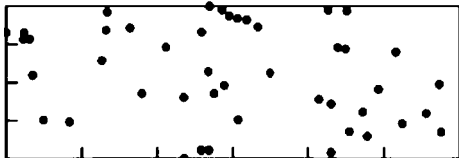
.1 — = 0,5%, d = 1 , 8



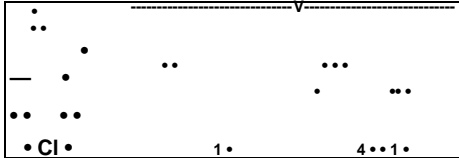
.2 — = 1%, / = 1 , 15



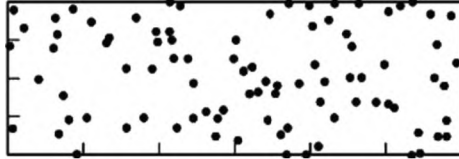
. — = 2%, / = 1 , 31



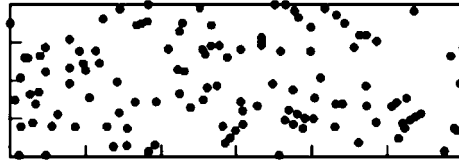
.4 — = 3%, / = 1 , 45



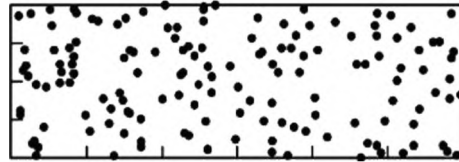
.5 — = 4%, d = 1 , 61



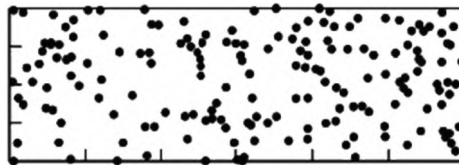
.6 — = 6%, / = 1 , 92



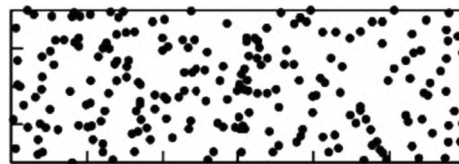
.7 — = 8 %, $d = 1$, 122



.8 — = 10 %, $d = 1$, 153



.9 — = 15 %, $d = 1$, 229



.10 — = 20 %, $d = 1$, 305

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.1— .10

.1— .10

10042:2018.

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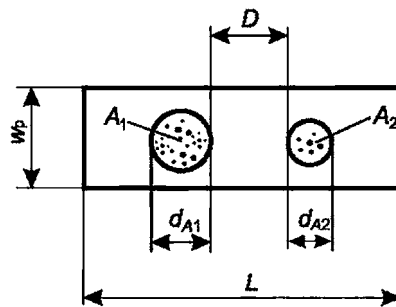
.1

$d_{A'}$

D d_M d_{A2} d_{Ac} $d_{Ac} = d_M + d_{A2} + D.$

d_M , d_{A2} d_{Ac}

d_A



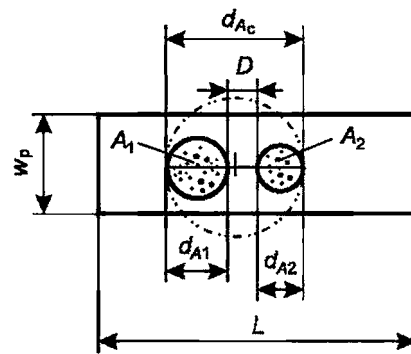
1 — D —

1; 2 — ; L —

2; d_{A1} — ; w_p —

d_{A2} — 2;

.1 — , $D < d_{A2}$



1 — d_{Ac} —

1; 2 — ; D — ; w —

2; d_M —

1; d_{A2} — ; L — 2;

.2 — , $D < d_{A2}$

.2

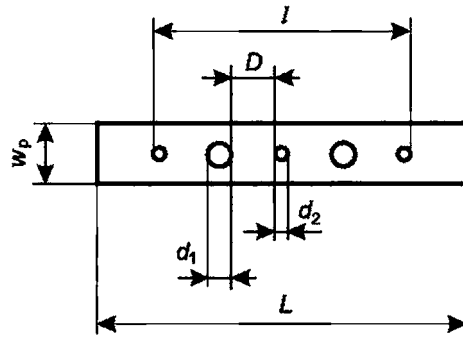
()

, L w_p (

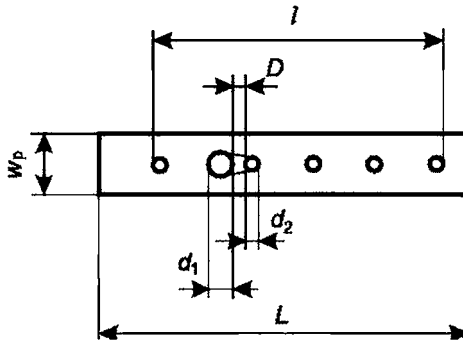
.).

D

(.4).

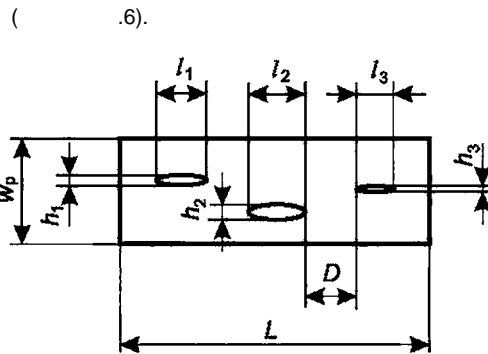


d_1 — / — ; d_2 — ; L — 100 ; w_p — ; $D < d_2$

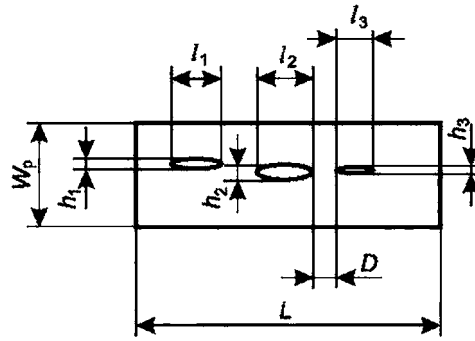


d_1 — / — ; d_2 — ; L — 100 ; w_p — ; $D < d_2$

.5). D L (



l_1 — ; l_2 — ; l_3 — ; L — 100 ; w_p — ; $D > l_3$



l_1 — 1; l_2 — 1; l_3 — 2; h_3 — 2; h_3 — 100; l — 3; D — 3; —
 W_p — ; L — .6 — , $D < l_3$

()

.1

		/
ISO 6520-1	IDT	6520-1—2012 « 1. »
ISO 10042	IDT	10042—2022 « »
ISO 17636-1	IDT	ISO 17636-1—2017 « 1. »
ISO 17636-2	IDT	ISO 17636-2—2017 « 2. »
ISO 17637	IDT	17637—2024 « »
— :		
- IDT -		

[1] ISO 2553 Welding and allied processes. Symbolic representation on drawings. Welded joints () -

[2] ISO 17635 Non-destructive testing of welds. General rules for metallic materials ()

620.179.16:006.354

25.160.40

30.12.2025.

09.02.2026.

60x847s.

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