

AlBeCast [®] 910 X-ray Grade Standards							
Discontinuity Type	Reference Plate Type	Maximum reference radiograph number on applicable plate					
		Grade B		Grade C		Grade D	
		1/4" ⁽¹⁾	3/4" ⁽¹⁾	1/4" ⁽¹⁾	3/4" ⁽¹⁾	1/4" ⁽¹⁾	3/4" ⁽¹⁾
Gas Holes	Al	1	1	2	2	5	5
Gas Porosity (Round)	Al	1	1	3	3	7	7
Gas Porosity (Elongated)	Al	1	2	3	4	5	5
Shrinkage Cavity	Al	1		2		3	
Foreign Material (Less dense)	Al	1	1	2	2	4	4
Foreign Material (More dense)	Al	1	1	2	1	4	3
Cracks	None	None		None		None	
Cold Shuts	None	None		None		None	
Surface Irregularity	None	Not to exceed drawing tolerance					
Core Shift	None	Not to exceed drawing tolerance					
Eutectic Segregation							
(a) Microshrinkage	Mg	4		5		6	
(b) Pipe Shrink	Mg	None		None		1/3 plate size	
(c) Hot Tear	Mg	plate size		plate size		2X plate size	
Eutectic Depletion							
Flow Line	Mg	plate size		2X plate size		Any length	
Internal Shrinkage							
Shrinkage	Steel	2		4		7	

(1) Use 1/4" radiographs for all thickness up to 1/2" inclusive. Use 3/4" radiograph for casting thickness greater than 1/2" and less than or equal to 2". When only one thickness is indicated, use the 1/4" radiograph for all thicknesses.

MAC-010