
**Steels, nickel alloys and cobalt alloys
investment castings — Visual testing
of surface quality**

*Pièces moulées par le procédé dit «à la cire perdue» en acier, alliages
de nickel et alliages de cobalt — Examen visuel de la qualité de surface*



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Published in Switzerland

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Foreword

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This document was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 11, *Steel castings*.

This second edition cancels and replaces the first edition (ISO 19959:2005), which has been technically revised. The main changes compared to the previous edition are as follows:

- “Terms and Definition” renumbered as [Clause 3](#);
- “Ordering Information” renumbered as [Clause 4](#);
- new [Clause 7](#) for “Testing documentation”.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Steels, nickel alloys and cobalt alloys investment castings — Visual testing of surface quality

1 Scope

This document specifies the acceptance criteria for the surface examination of steel, nickel alloy and cobalt alloy investment castings by visual testing.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 9712, *Non-destructive testing — Qualification and certification of NDT personnel*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

3.1

surface pit

depression on the surface of the casting, the length of the depression being less than three times its width

3.2

linear discontinuity

depression on the surface of the casting, the length of the depression being equal to, or greater than, three times its width

3.3

positive metal

protrusion on the surface of the casting

3.4

surface roughness

measure of the surface condition

Note 1 to entry: The surface roughness is normally determined by the use of a visual or tactile comparator.

3.5

parting line

surface condition resulting from joints in the tool or die

Note 1 to entry: Parting lines are not linear discontinuities.

3.6

ejector-pin mark

surface condition caused by pins used to remove the pattern from the die