

**641—45.3(136C) Radiation safety requirements for use of sealed sources of radiation in industrial radiography.**

**45.3(1) Limits on external radiation levels from storage containers and source changers.** The maximum exposure rate limits for storage containers and source changers are 200 millirem (2 millisieverts) per hour at any exterior surface, and 10 millirem (0.1 millisievert) per hour at 1 meter from any exterior surface with the sealed source in the shielded position.

**45.3(2) Locking of sources of radiation.**

*a.* Each source of radiation shall be provided with a lock or lockable outer container designed to prevent unauthorized or accidental removal of the sealed source. Either the exposure device or its container must be kept locked and, if applicable, the key removed, at all times when not under the direct surveillance of a radiographer or a radiographer's assistant except at permanent radiographic installations as stated in 45.1(14). Each sealed source storage container and source changer must have a lock or outer locked container designed to prevent unauthorized or accidental removal of the sealed source from its shielded position. Storage containers and source changers must be kept locked (and if the lock is a keyed lock, with the key removed at all times) when containing sealed sources except when the container is under the direct surveillance of a radiographer or radiographer's assistant.

*b.* Radiographic exposure devices, source changers, and storage containers, prior to being moved from one location to another and also prior to being secured at a given location, shall be locked and surveyed to ensure that the sealed source is in the shielded position.

*c.* The sealed source shall be secured in its shielded position by locking the exposure device or securing the remote control each time the sealed source is returned to its shielded position. Then a survey shall be performed to determine that the sealed source is in the shielded position pursuant to 45.3(7) "b."

**45.3(3) Storage precautions.**

*a.* Labeling, storage, and transportation.

(1) The licensee may not use a source changer or a container to store licensed material unless the source changer or the storage container has securely attached to it a durable, legible, and clearly visible label bearing the standard trefoil radiation caution symbol in conventional colors, i.e., magenta, purple or black on a yellow background, having a minimum diameter of 25 mm, and the wording: "CAUTION RADIOACTIVE MATERIAL, NOTIFY CIVIL AUTHORITIES (or name of company)" or "DANGER RADIOACTIVE MATERIAL, NOTIFY CIVIL AUTHORITIES (or name of company)."

(2) The licensee may not transport licensed material unless the material is packaged, and the package is labeled, marked, and accompanied with appropriate shipping papers in accordance with 641—39.5(136C).

(3) Locked radiographic exposure devices and storage containers must be physically secured to prevent tampering or removal by unauthorized personnel. The licensee shall store licensed material in a manner which will minimize danger from explosion or fire.

(4) The licensee shall lock and physically secure the transport package containing licensed material in the transporting vehicle to prevent accidental loss, tampering, or unauthorized removal of the licensed material from the vehicle.

*b.* Radiographic exposure devices, source changers, or storage containers that contain radioactive material shall not be stored in residential locations. This requirement does not apply to storage of radioactive material in a vehicle in transit for use at temporary job sites, if the licensee complies with 45.3(3) "c," and if the vehicle does not constitute a permanent storage location as described in 45.1(9).

*c.* If a vehicle is to be used for storage of radioactive material, a vehicle survey shall be performed after securing radioactive material in the vehicle and before transport to ensure that radiation levels do not exceed the limits specified in 641—subrule 40.26(1) at the exterior surface of the vehicle.

*d.* A storage or use location is permanent if radioactive material is stored at the location for more than 90 days and any one or more of the following applies to the location:

- (1) Telephone service is established by the licensee;
- (2) Industrial radiographic services are advertised for or from the location;

(3) Industrial radiographic operations are conducted at other sites due to arrangements made from the location.

**45.3(4) Performance requirements for radiography equipment.** Equipment used in industrial radiographic operations must meet the following minimum criteria:

*a.* Each radiographic exposure device, source assembly or sealed source, and all associated equipment must meet the requirements specified in American National Standard N432-1980, “Radiological Safety for the Design and Construction of Apparatus for Gamma Radiography” (published as NBS Handbook 136, issued January 1981). This publication has been approved for incorporation by reference by the Director of the Federal Register in accordance with 5 U.S.C. 552(a) and 1 CFR Part 51. This publication may be purchased from the American National Standards Institute, Inc., 25 West 43rd Street, New York, New York 10036, telephone (212)642-4900.

*b.* In addition to the requirements specified in paragraph “*a*” of this subrule, the following requirements apply to radiographic exposure devices, source changers, source assemblies, sealed sources, and associated equipment.

(1) Each radiographic exposure device must have attached to it by the user a durable, legible, clearly visible label bearing the:

1. Chemical symbol and mass number of the radionuclide in the device;
2. Activity and the date on which this activity was last measured;
3. Model number (or product code) and serial number of the sealed source;
4. Manufacturer’s identity of the sealed source; and
5. Licensee’s name, address, and telephone number.

(2) Radiographic exposure devices intended for use as Type B transport containers must meet the applicable requirements of 641—39.5(136C).

(3) Modification of any radiographic exposure devices, source changers, and source assemblies and associated equipment is prohibited, unless the design of any replacement component, including source holder, source assembly, controls or guide tubes would not compromise the design safety features of the system.

*c.* In addition to the requirements specified in paragraphs “*a*” and “*b*” of this subrule, the following requirements apply to radiographic exposure devices, source assemblies, and associated equipment that allow the source to be moved out of the device for radiographic operation or source changing:

(1) The coupling between the source assembly and the control cable must be designed in such a manner that the source assembly will not become disconnected if cranked outside the guide tube. The coupling must be such that it cannot be unintentionally disconnected under normal and reasonably foreseeable abnormal conditions;

(2) The device must automatically secure the source assembly when it is cranked back into the fully shielded position within the device. This securing system may only be released by means of a deliberate operation on the exposure device;

(3) The outlet fittings, lock box, and drive cable fittings on each radiographic exposure device must be equipped with safety plugs or covers which must be installed during storage and transportation to protect the source assembly from water, mud, sand, or other foreign matter;

(4) Each sealed source or source assembly must have attached to it or engraved in it, a durable, legible, visible label with the words: “DANGER—RADIOACTIVE.” The label must not interfere with safe operation of the exposure device or associated equipment;

(5) The guide tube must be able to withstand a crushing test that closely approximates the crushing forces that are likely to be encountered during use, and be able to withstand a kinking resistance test that closely approximates the kinking forces that are likely to be encountered during use;

(6) Guide tubes must be used when moving the source out of the device;

(7) An exposure head or similar device designed to prevent the source assembly from passing out of the end of the guide tube must be attached to the outermost end of the guide tube during radiographic operations;

(8) The guide tube exposure head connection must be able to withstand the tensile test for control units specified in ANSI N432-1980;

(9) Source changers must provide a system for ensuring that the source will not be accidentally withdrawn from the changer when connecting or disconnecting the drive cable to or from a source assembly.

*d.* All newly manufactured radiographic exposure devices and associated equipment acquired by licensees after January 10, 1992, must comply with the requirements of this subrule.

*e.* All radiographic exposure devices and associated equipment in use after January 10, 1996, must comply with the requirements of this subrule.

*f.* Notwithstanding the requirements of 45.3(4) "a," equipment used in industrial radiographic operations need not comply with § 8.9.2(c) of the Endurance Test in American National Standards Institute N432-1980, if the prototype equipment has been tested using a torque value representative of the torque that an individual using the radiography equipment can realistically exert on the lever or crankshaft of the drive mechanism.

*g.* Engineering analysis may be submitted by an applicant or licensee to demonstrate the applicability of previously performed testing on similar individual radiography equipment components. Upon review, the agency may find this an acceptable alternative to actual testing of the component pursuant to the above-referenced standard.

**45.3(5) *Leak testing, repair, tagging, opening, modification, and replacement of sealed sources.***

*a.* The replacement of any sealed source fastened to or contained in a radiographic exposure device and leak testing, repair, tagging, opening, or any other modification of any sealed source shall be performed only by persons specifically authorized to do so by the agency, the U.S. Nuclear Regulatory Commission, or an agreement state.

*b.* Leak testing requirements.

(1) Each licensee that uses a sealed source shall have the source tested for leakage at intervals not to exceed 6 months. The leak testing of the source must be performed using a method approved by this agency. The wipe sample should be taken from the nearest accessible point to the sealed source where contamination might accumulate. The wipe sample must be analyzed for radioactive contamination. The analysis must be capable of detecting the presence of 0.005 microcuries (185 Bq) of radioactive material on the test sample and must be performed by a person specifically authorized by this agency to perform the analysis.

(2) The licensee shall maintain records of the leak tests results for sealed sources and devices containing depleted uranium (DU). The results must be stated in units of microcuries (becquerels). The licensee shall retain each record for three years after it is made or until the source in storage is removed.

(3) Unless a sealed source is accompanied by a certificate from the transferor that shows that it has been leak tested within 6 months before the transfer, it may not be used by the licensee until tested for leakage. Sealed sources that are in storage and not in use do not require leak testing, but must be tested before use or transfer to another person if the interval of storage exceeds 6 months.

*c.* Any test conducted under this subrule which reveals the presence of 0.005 microcuries (185 Bq) or more of removable radioactive material must be considered evidence that the sealed source is leaking. The licensee shall immediately withdraw from use the equipment involved and shall have it decontaminated and repaired or disposed of in accordance with agency rules. Within five days after obtaining the results of the test, the licensee shall file a report with the agency describing the equipment involved, the test results, and the corrective action taken.

*d.* Each exposure device using DU shielding and an "S" tube configuration must be tested for DU contamination at intervals not to exceed 12 months. The analysis must be capable of detecting the presence of 0.005 microcuries (185 Bq) of radioactive material on the test sample and must be performed by a person specifically authorized by the agency to perform the analysis. Should such testing reveal the presence of 0.005 microcuries (185 Bq) or more of removable DU contamination, the exposure device must be removed from use until an evaluation of the wear on the S-tube has been made. Should the evaluation reveal that the S-tube is worn through, the device may not be used again. DU-shielded devices do not have to be tested for DU contamination while in storage and not in use. Before using or

transferring such a device, however, the device must be tested for DU contamination if the interval of storage exceeds 12 months.

*e.* Each radiographic exposure device shall have permanently attached to it a durable label which has, as a minimum, the instruction: “Danger—Radioactive Material—Do Not Handle—Notify Civil Authorities if Found.”

**45.3(6) *Operating and emergency procedures.***

*a.* The licensee’s operating and emergency procedures shall include instructions in at least the following:

- (1) Handling and use of sources of radiation to be employed such that no individual is likely to be exposed to radiation doses in excess of the limits established in 641—Chapter 40;
- (2) Methods and occasions for conducting radiation surveys;
- (3) Methods for controlling access to radiographic areas;
- (4) Methods and occasions for locking and securing sources of radiation;
- (5) Personnel monitoring and the use of personnel monitoring equipment, including steps that must be taken immediately by radiography personnel in the event a pocket dosimeter is found to be off-scale;
- (6) Transportation to field locations, including packing of sources of radiation in the vehicles, posting of vehicles, and control of sources of radiation during transportation;
- (7) Minimizing exposure of individuals in the event of an accident;
- (8) The procedure for notifying proper personnel in the event of an accident;
- (9) Maintenance of records;
- (10) The inspection, maintenance, and operability checks of radiographic exposure devices, survey instruments, source changers, storage containers, and radiation machines;
- (11) The procedure(s) for identifying and reporting defects and noncompliance in 10 CFR Part 21; and

(12) Source recovery procedure if the licensee will perform source recovery.

*b.* Rescinded IAB 4/8/98, effective 7/1/98.

*c.* Whenever radiography is performed at a location other than a permanent radiographic installation, the radiographer must be accompanied by at least one other qualified radiographer or a radiographer’s assistant. If one of the personnel is a radiographer’s assistant, the other shall be a radiographer trainer authorized by the license. The additional qualified individual shall observe the operations and be capable of providing immediate assistance to prevent unauthorized entry. Radiography shall not be performed if only one qualified individual is present.

*d.* Collimators shall be used in industrial radiographic operations which use crank-out devices except when physically impossible.

*e.* All radiographic operations conducted at locations of use authorized on the license must be conducted in a permanent radiographic installation, unless specifically authorized by the agency.

**45.3(7) *Radiation surveys and survey records.***

*a.* No radiographic operation shall be conducted unless calibrated and operable radiation survey instrumentation, as described in 45.1(5), is available and for each exposure device used at each site where radiographic exposures are made.

*b.* A survey with a calibrated and operable radiation survey instrument shall be made after each radiographic exposure to determine that the sealed source has been returned to its shielded position. The entire circumference of the radiographic exposure device shall be surveyed. If the radiographic exposure device has a source guide tube, the survey shall also include the entire length of the guide tube and collimator. The survey required by this subrule must be done before exchanging films, repositioning the exposure head or dismantling the equipment.

*c.* (1) All potential radiation areas where industrial radiographic operations are to be performed shall be posted in accordance with 641—40.61(136C), based on calculated dose rates, before industrial radiographic operations begin. An area survey shall be performed during the first radiographic exposure (i.e., with the sealed source in the exposed position) to confirm that 641—40.61(136C) requirements have been met and that unrestricted areas do not have radiation levels in excess of the limits specified in 641—subrule 40.26(1).

(2) Each time the exposure device is relocated or the exposed position of the sealed source is changed, the requirements of 45.3(7)“c”(1) shall be met.

*d.* A lock-out survey, in which all accessible surfaces of the radiographic exposure device or source changer are surveyed, shall be made to determine that each sealed source is in its shielded position before securing the radiographic exposure device or source changer.

*e.* The sealed source shall be secured in its shielded position by locking the radiographic exposure device or source changer each time the sealed source is returned to its shielded position.

*f.* Each radiographic exposure device and source changer shall be locked and the key removed from any keyed lock prior to being moved or transported from one location to another and also prior to being stored at a given location.

*g.* If a vehicle is to be used for storage of radioactive material, a vehicle survey shall be performed after securing radioactive material in the vehicle and before transport to ensure that radiation levels do not exceed the limits specified in 641—subrule 40.26(1) at the exterior surface of the vehicle.

*h.* Surveys shall be performed on storage containers to ensure that radiation levels do not exceed the limits specified in 641—40.15(136C). These surveys shall be performed initially with the maximum amount of radioactive material present in the storage location and thereafter at the time of the quarterly inventory and whenever storage conditions change.

*i.* A survey meeting the requirements of 45.3(7)“b” shall be performed on the radiographic exposure device and the source changer after every sealed source exchange. A survey shall be made of the storage area as defined in 641—45.2(136C) whenever a radiographic exposure device is being placed in storage.

*j.* Records shall be kept of the surveys required by 45.3(7)“c,” “d,” “g,” “h,” and “i.” Such records shall be maintained for inspection by the agency for two years after completion of the survey. If the survey was used to determine an individual’s exposure, however, the records of the survey shall be maintained until the agency authorizes their disposition.

**45.3(8) Requirements for enclosed radiography.**

*a.* Systems for enclosed radiography, including shielded-room radiography designed to allow admittance of individuals shall comply with all applicable requirements of this chapter.

*b.* Procedures shall be evaluated at intervals not to exceed one year to ensure compliance with the applicable requirements as specified in 641—subrule 40.26(1). Records of these evaluations shall be maintained for inspection by the agency for a period of two years after the evaluation.

*c.* Tests for proper operation of high radiation area control devices or alarm systems, where applicable, shall be conducted, recorded, and maintained in accordance with 45.1(9)“b.”

**45.3(9) Underwater, offshore platform, and lay-barge radiography.**

*a.* Underwater, offshore platform, or lay-barge radiography shall not be performed unless specifically authorized in a license issued by the agency in accordance with 641—paragraph 39.4(27)“e.”

*b.* In addition to the other rules of this chapter, the following rules apply to the performance of lay-barge or offshore platform radiography:

(1) Cobalt-60 sources with activities in excess of 20 curies (nominal) and iridium-192 sources with activities in excess of 100 curies (nominal) shall not be used in the performance of lay-barge or offshore platform industrial radiography.

(2) Collimators shall be used for all industrial radiographic operations performed on lay-barge or offshore platforms.

**45.3(10) Prohibitions.** Industrial radiography performed with a sealed source which is not fastened to or contained in a radiographic exposure device (fishpole technique) is prohibited unless specifically authorized in a license issued by the agency.

**45.3(11) Licensing for industrial radiographic operations.** Rescinded IAB 4/5/00, effective 5/10/00. [ARC 1639C, IAB 10/1/14, effective 11/5/14; ARC 3746C, IAB 4/11/18, effective 5/16/18]