



Standard Practice for Fluorescent Liquid Penetrant Testing Using the Hydrophilic Post-Emulsification Process¹

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1. Scope

1.1 This practice covers procedures for fluorescent penetrant examination utilizing the hydrophilic post-emulsification process. It is a nondestructive testing method for detecting discontinuities that are open to the surface such as cracks, seams, laps, cold shuts, laminations, isolated porosity, through leaks, or lack of fusion and is applicable to in-process, final, and maintenance examination. It can be effectively used in the examination of nonporous, metallic materials, both ferrous and nonferrous, and of nonmetallic materials such as glazed or fully densified ceramics and certain nonporous plastics and glass.

1.2 This practice also provides a reference:

1.2.1 By which a fluorescent penetrant examination hydrophilic post-emulsification process recommended or required by individual organizations can be reviewed to ascertain their applicability and completeness.

1.2.2 For use in the preparation of process specifications dealing with the fluorescent penetrant examination of materials and parts using the hydrophilic post-emulsification process. Agreement by the purchaser and the manufacturer regarding specific techniques is strongly recommended.

1.2.3 For use in the organization of the facilities and personnel concerned with the liquid penetrant examination.

1.3 This practice does not indicate or suggest standards for evaluation of the indications obtained. It should be pointed out, however, that indications must be interpreted or classified and then evaluated. For this purpose there must be a separate code or specification or a specific agreement to define the type, size, location, and direction of indications considered acceptable, and those considered unacceptable.

1.4 The values stated in inch-pound units are regarded as standard. SI units given in parentheses are for information only.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appro-*

priate safety and health practices and determine the applicability of regulatory limitations prior to use.

1.6 All areas of this practice may be open to agreement between the cognizant engineering organization and the supplier, or specific direction from the cognizant engineering organization.

2. Referenced Documents

2.1 ASTM Standards:²

D129 Test Method for Sulfur in Petroleum Products (General Bomb Method)

D516 Test Method for Sulfate Ion in Water

D808 Test Method for Chlorine in New and Used Petroleum Products (Bomb Method)

D1552 Test Method for Sulfur in Petroleum Products (High-Temperature Method)

E165 Practice for Liquid Penetrant Examination for General Industry

E433 Reference Photographs for Liquid Penetrant Inspection

E543 Specification for Agencies Performing Nondestructive Testing

E1316 Terminology for Nondestructive Examinations

2.2 ASNT Documents:

Recommended Practice SNT-TC-1A Personnel Qualification and Certification in Nondestructive Testing³

ANSI/ASNT-CP-189 Standard for Qualification and Certification of Nondestructive Testing Personnel³

2.3 Military Standard:

MIL-STD-410 Nondestructive Testing Personnel Qualification and Certification⁴

2.4 AIA Standard:

NAS 410 Certification and Qualification of Nondestructive Testing Personnel⁵

¹ This practice is under the jurisdiction of ASTM Committee E07 on Nondestructive Testing and is the direct responsibility of Subcommittee E07.03 on Liquid Penetrant and Magnetic Particle Methods.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from The American Society for Nondestructive Testing (ASNT), P.O. Box 28518, 1711 Arlington Lane, Columbus, OH 43228-0518.

⁴ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

⁵ Available from the Aerospace Industries Association of America, Inc., 1250 Eye St., N.W., Washington, DC 20005.

2.5 *DoD Contracts*—Unless otherwise specified, the issue of the documents that are DoD adopted are those listed in the issue of the DoDISS (Department of Defense Index of Specifications and Standards) cited in the solicitation.

2.6 *Order of Precedence*—In the event of conflict between this practice and the references cited herein, this practice takes precedence.

3. Terminology

3.1 *Definitions*—definitions relating to liquid penetrant examination, which appear in Terminology E1316, shall apply to the terms used in this practice.

4. Summary of Practice

4.1 A post-emulsifiable, liquid, fluorescent penetrant is applied evenly over the surface being tested and allowed to enter open discontinuities. After a suitable dwell time and prerinse, the excess surface penetrant is removed by applying a hydrophilic emulsifier and the surface is rinsed and dried. A developer is then applied drawing the entrapped penetrant out of the discontinuity and staining the developer. If an aqueous developer is to be employed, the developer is applied prior to the drying step. The test surface is then examined visually under black light in a darkened area to determine the presence or absence of indications. (**Warning**—Fluorescent penetrant examination shall not follow a visible penetrant examination unless the procedure has been qualified in accordance with 9.2, because visible dyes may cause deterioration or quenching of fluorescent dyes.)

4.2 Processing parameters such as precleaning, penetration time, prerinse, hydrophilic emulsifier concentration, etc., are determined by the specific materials used, the nature of the part under examination (that is, size, shape, surface condition, alloy), type of discontinuities expected, etc.

5. Significance and Use

5.1 Liquid penetrant examination methods indicate the presence, location, and, to a limited extent, the nature and magnitude of the detected discontinuities. This practice is normally used for production examination of critical components, where reproducibility is essential. More procedural controls and processing steps are required than with other processes.

6. Reagents and Materials

6.1 *Liquid Fluorescent Penetrant Testing Materials*, for use in the hydrophilic post-emulsification process, (see Note 1) consist of a family of post-emulsifiable fluorescent penetrant, hydrophilic remover, and appropriate developer and are classified as Type I Fluorescent, Method D—Post-Emulsifiable, Hydrophilic. Intermixing of materials from various manufacturers is not recommended.

NOTE 1—Refer to 8.1 for special requirements for sulfur, halogen, and alkali metal content. (**Warning**—While approved penetrant materials will not adversely affect common metallic materials, some plastics or rubbers may be swollen or stained by certain penetrants.)

6.2 *Post-Emulsifiable Penetrants* are designed to be insoluble in water and cannot be removed with water rinsing alone. They are designed to be selectively removed from the

surface by the use of a separate hydrophilic emulsifier. The hydrophilic emulsifier, at the proper concentration, properly applied, and given a proper emulsification time, combines with the excess surface penetrant to form a water-washable mixture, which can then be rinsed from the surface leaving the surface free of fluorescent background. Proper concentration and hydrophilic emulsification time must be experimentally established and maintained to assure that over-emulsification does not occur, resulting in loss of indications.

6.3 *Hydrophilic Emulsifiers* are liquids used to emulsify the excess oily fluorescent penetrant on the surface of the part, rendering it water-washable (see 7.1.6). They are water-base emulsifiers (detergent-type removers) that are supplied as concentrates to be diluted with water and used as a dip or spray. The concentration, use, and maintenance shall be in accordance with manufacturer's recommendations.

6.3.1 Hydrophilic emulsifiers function by displacing the excess penetrant film from the surface of the part through detergent action. The force of the water spray or air/mechanical agitation in an open dip tank provides the scrubbing action while the detergent displaces the film of penetrant from the part surface. The emulsification time will vary, depending on its concentration. Its concentration can be monitored by the use of a suitable refractometer.

6.4 *Developers*—Development of penetrant indications is the process of bringing the penetrant out of discontinuities through blotting action of the applied developer, thus increasing the visibility of the penetrant indications. Several types of developers are suitable for use with the hydrophilic penetrant process.

6.4.1 *Dry Powder Developers* are used as supplied (that is, free-flowing, noncaking powder) in accordance with 7.1.9.1(a). Care should be taken not to contaminate the developer with fluorescent penetrant, as the penetrant specks can appear as indications.

6.4.2 *Aqueous Developers* are normally supplied as dry powder particles to be either suspended or dissolved (soluble) in water. The concentration, use, and maintenance shall be in accordance with manufacturer's recommendations (see 7.1.9.1(b)). (**Warning**—Aqueous developers may cause stripping of indications if not properly applied and controlled. The procedure should be qualified in accordance with 9.2.)

6.4.3 *Nonaqueous, Wet Developers* are supplied as suspensions of developer particles in a nonaqueous, solvent carrier ready for use as supplied. Nonaqueous, wet developers form a coating on the surface of the part when dried, which serves as the developing medium for fluorescent penetrants (see 7.1.9.1(c)). (**Warning**—This type of developer is intended for application by spray only.)

6.4.4 *Liquid Film Developers* are solutions or colloidal suspensions of resins/polymer in a suitable carrier. These developers will form a transparent or translucent coating on the surface of the part. Certain types of film developer may be stripped from the part and retained for record purposes (see 7.1.9.1(d)).

7. Procedure

7.1 The following general procedure applies to the fluorescent penetrant examination hydrophilic post-emulsification method (see Fig. 1).

7.1.1 *Temperature Limits*—The temperature of the penetrant materials and the surface of the part to be processed should be between 40 and 125°F (4 and 52°C). Where it is not practical

to comply with these temperature limitations, qualify the procedure at the temperature of intended use as described in 9.2.

7.1.2 *Surface Conditioning Prior to Penetrant Inspection*—Satisfactory results may be obtained on surfaces in the as-welded, as-rolled, as-cast, or as-forged conditions or for ceramics in the densified condition. These sensitive penetrants

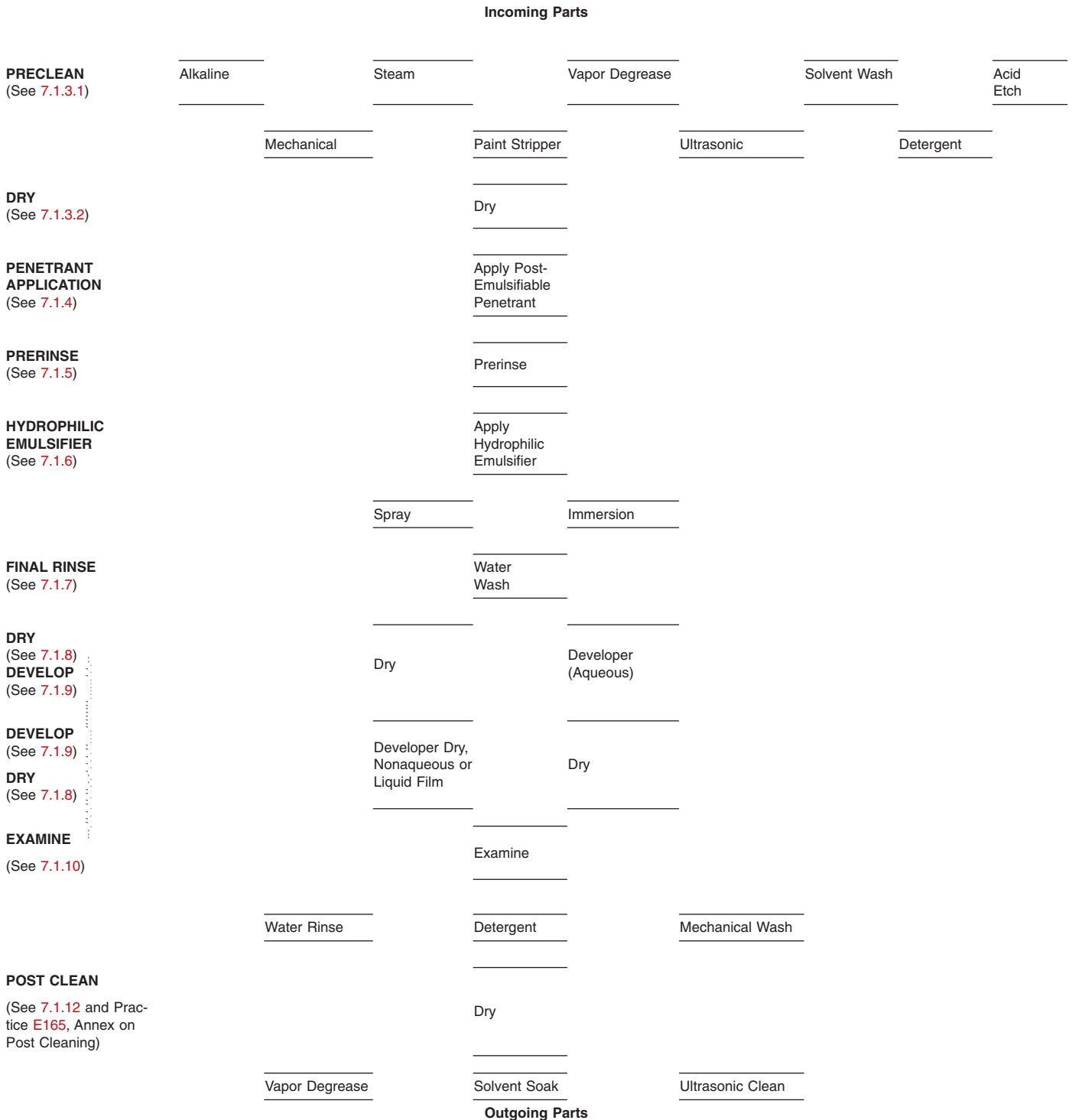


FIG. 1 General Procedure Flowsheet for Fluorescent Penetrant Examination Using the Water-Washable Process

are generally less easily rinsed away and are therefore less suitable for rougher surfaces. When only loose surface residuals are present, these may be removed by wiping the surface with clean lint-free cloths. However, precleaning of metals to remove processing residuals such as oil, graphite, scale, insulating materials, coatings, and so forth, should be done using cleaning solvents, vapor degreasing or chemical removing processes. Surface conditioning by grinding, machining, polishing or etching shall follow shot, sand, grit and vapor blasting to remove the peened skin and when penetrant entrapment in surface irregularities might mask the indications of unacceptable discontinuities or otherwise interfere with the effectiveness of the examination. For metals, unless otherwise specified, etching shall be performed when evidence exists that previous cleaning, surface treatments or service usage have produced a surface condition that degrades the effectiveness of the examination. (See Annex on Mechanical Cleaning and Surface Conditioning and Annex on Acid Etching in Test Method E165 for general precautions relative to surface preparation.)

NOTE 2—When agreed between purchaser and supplier, grit blasting without subsequent etching may be an acceptable cleaning method. (**Warning**—Sand or shot blasting may possibly close indications and extreme care should be used with grinding and machining operations.)

NOTE 3—For structural or electronic ceramics, surface preparation by grinding, sand blasting and etching for penetrant examination is not recommended because of the potential for damage.

7.1.3 Removal of Surface Contaminants:

7.1.3.1 *Precleaning*—The success of any penetrant examination procedure is greatly dependent upon the surface and discontinuity being free of any contaminant (solid or liquid) that might interfere with the penetrant process. All parts or areas of parts to be inspected must be clean and dry before the penetrant is applied. If only a section of a part, such as a weld, including the heat-affected zone is to be examined, all contaminants shall be removed from the area being examined as defined by the contracting parties. “Clean” is intended to mean that the surface must be free of any rust, scale, welding flux, spatter, grease, paint, oily films, dirt, etc., that might interfere with penetration. All of these contaminants can prevent the penetrant from entering discontinuities. (See Annex on Cleaning of Parts and Materials in Test Method E165 for more detailed cleaning methods.) (**Warning**—Residues from cleaning processes, such as strong alkalis, pickling solutions and chromates in particular, may adversely react with the penetrant and reduce its sensitivity and performance.)

7.1.3.2 *Drying After Cleaning*—It is essential that the surface be thoroughly dry after cleaning, since any liquid residue will hinder the entrance of the penetrant. Drying may be accomplished by warming the parts in drying ovens, with infrared lamps, forced hot or cold air, or exposure to ambient temperature.

7.1.4 *Penetrant Application*—After the part has been cleaned, dried, and is within the specified temperature range, apply the penetrant to the surface to be inspected so that the entire part or area under examination is completely covered with penetrant.

7.1.4.1 *Modes of Application*—There are various modes of effective application of penetrant such as dipping, brushing,

flooding, or spraying. Small parts are quite often placed in suitable baskets and dipped into a tank of penetrant. On larger parts, and those with complex geometries, penetrant can be applied effectively by brushing or spraying. Both conventional and electrostatic spray guns are effective means of applying liquid penetrants to the part surfaces. Electrostatic spray application can eliminate excess liquid buildup of penetrant on the part, minimize overspray, and minimize the amount of penetrant entering hollow-cored passages which might serve as penetrant reservoirs, causing severe bleedout problems during examination. Aerosol sprays are conveniently portable and suitable for local application. (**Warning**—Not all penetrant materials are suitable for electrostatic spray applications.) (**Warning**—With spray applications, it is important that there be proper ventilation. This is generally accomplished through the use of a properly designed spray booth and exhaust system.)

7.1.4.2 *Penetrant Dwell Time*—After application, allow excess penetrant to drain from the part (care should be taken to prevent pools of penetrant on the part), while allowing for proper penetrant dwell time (see Table 1). The length of time the penetrant must remain on the part to allow proper penetration should be as recommended by the penetrant manufacturer. Table 1, however, provides a guide for selection of penetrant dwell times for a variety of materials, forms, and types of discontinuity. Unless otherwise specified the dwell time shall not exceed the maximum recommended by the manufacturer.

NOTE 4—For some specific applications in structural ceramics (for example, detecting parting lines in slip-cast material), the required penetrant dwell time should be determined experimentally and may be longer than that shown in Table 1 and its notes.

7.1.5 *Prerinsing*—Directly after the required penetration time, it is recommended that the parts be prerinsed (7.1.5.1) prior to emulsification (7.1.6). This step allows for the removal of excess surface penetrant from the parts prior to emulsification so as to minimize the degree of penetrant contamination in the hydrophilic emulsifier bath, thereby extending its life. In

TABLE 1 Recommended Minimum Dwell Times

Material	Form	Type of Discontinuity	Dwell Times ^A (minutes)	
			Pene- trant ^B	Devel- oper ^C
Aluminum, magnesium, steel, brass and bronze, titanium and high-temperature alloys	castings and welds	cold shuts, porosity, lack of fusion, cracks (all forms)	5	10
	wrought materials— extrusions, forgings, plate	laps, cracks (all forms)	10	10
Carbide-tipped tools		lack of fusion, porosity, cracks	5	10
Plastic	all forms	cracks	5	10
Glass	all forms	cracks	5	10
Ceramic	all forms	cracks, porosity	5	10

^A For temperature range from 40 to 120°F (4 to 49°C).

^B Maximum penetrant dwell time 60 min in accordance with 7.1.4.2.

^C Development time begins as soon as wet developer coating has dried on surface of parts (recommended minimum). Maximum development time in accordance with 7.1.9.2.

addition, prerinsing of penetrated parts allows for the minimization of possible oily penetrant pollution in the final rinse step of this process. This is accomplished by collecting the prerinsings in a hold tank, separating the penetrant from water.

7.1.5.1 Prerinsing Controls—Effective prerinsing is accomplished by either manual or automatic water spray rinsing of the parts as follows:

(a) Control water temperature within the range of 50 to 100°F (10 to 38°C).

(b) Spray rinse at water pressure of 25 to 40 psi (175 to 275 kPa).

(c) Prerinse time should be maintained at the least possible time to provide a consistent residue of penetrant on parts, nominally 60 s maximum wash time to be as specified by the part or material specification.

(d) Remove water trapped in cavities using filtered shop air at a nominal pressure of 25 psi (175 kPa) or a suction device to remove water from pooled areas.

(e) Water should be free of contaminants that could clog spray nozzles or leave a residue on parts.

7.1.6 Application of Emulsifier—After the required penetration time and following the prerinse, the residual surface penetrant on parts is emulsified by immersing the parts in a hydrophilic emulsifier bath (7.1.6.1) or by spraying the parts with the emulsifier (7.1.6.2) thereby rendering the remaining residual surface penetrant water-washable in the final rinse station (7.1.7).

7.1.6.1 Immersion—For immersion application of hydrophilic emulsifier, parts are completely immersed in the emulsifier bath. The hydrophilic emulsifier is gently air agitated throughout the contact cycle.

(a) The concentration, percent volume, shall be no higher than specified by the penetrant system supplier, and shall not exceed that for which the system was qualified.

(b) Immersion contact time should be kept to the minimum time consistent with an acceptable background and should not exceed 120 s or the maximum time stipulated by the part or material specification.

(c) Emulsifier drain time begins immediately after parts have been withdrawn from the emulsifier tank and continues until the parts are washed in the final rinse station (7.1.7).

7.1.6.2 Spray Application—All part surfaces should be evenly and uniformly sprayed to effectively emulsify the residual penetrant on part surfaces to render it water-washable.

NOTE 5—Prerinse is not necessary for a spray application of hydrophilic emulsifier.

(a) The concentration of the emulsifier for spray application should be in accordance with the manufacturer's recommendations, but should not exceed 5 %.

(b) The spray pressure should not exceed 40 psi (275 kPa).

(c) Temperature to be maintained at 50 to 100°F (10 to 38°C).

(d) Contact time should be kept to the least possible time consistent with an acceptable background and should not exceed 120 s or the maximum time specified by the part or material specification.

(e) If over-removal is suspected, dry (see 7.1.8) and reclean the part and reapply the penetrant for the prescribed dwell time.

7.1.7 Post-Rinsing of Hydrophilic Emulsified Parts—

Effective post-rinsing of emulsified penetrant from the surface can be accomplished using either manual, semiautomatic, or automatic water spray or immersion equipment or combinations thereof.

7.1.7.1 Immersion Post-Rinsing—Parts are to be completely immersed in the water bath with air or mechanical agitation.

(a) The maximum immersion time should not exceed 120 s unless otherwise specified by part or material specification.

(b) The temperature of the water should be relatively constant and should be maintained within the range of 50 to 100°F (10 to 38°C).

7.1.7.2 Spray Post-Rinsing—Following emulsification parts can be post-rinsed by either manual or automatic water spray rinsing as follows:

(a) Spray rinse water pressure shall not exceed 40 psi (275 kPa) when manual, automated, or hydro-air spray guns are used. When hydro-air pressure spray guns are used, the air pressure shall not exceed 25 psi (172 kPa).

(b) The maximum spray rinse time should not exceed 120 s unless otherwise specified by part or materials specification.

(c) Control rinse water temperature within the range of 50 to 100°F (10 to 38°C).

7.1.8 Drying—During the preparation of parts for examination, drying is necessary either following the application of the aqueous, wet developer or prior to applying dry or nonaqueous developers. Drying time will vary with the size, nature, and number of parts under examination.

7.1.8.1 Drying Modes—Parts can be dried by using a hot-air recirculating oven, a hot- or cold-air blast, or by exposure to ambient temperature. Drying is best done in a thermostatically controlled recirculating hot-air dryer. (**Warning**—Drying oven temperature should not exceed 160°F (71°C).)

7.1.8.2 Drying Time Limits—Do not allow parts to remain in the drying oven any longer than is necessary to dry the part. Excessive time in the dryer may impair the sensitivity of the examination.

7.1.9 Developer Application:

7.1.9.1 Modes of Application—There are various modes of effective application of the various types of developers such as dusting, immersing, flooding, or spraying. The size, configuration, surface condition, number of parts to be processed, etc., will influence the choice of developer application.

(a) **Dry Powder Developers**—Apply immediately after drying in such a manner as to assure complete coverage. Parts can be immersed into a container of dry developer or dipped into a fluid bed of dry developer; they can also be dusted with the powder developer through a hand powder bulb or a powder gun. It is quite common and most effective to apply dry powder in an enclosed dust chamber, which creates an effective and controlled dust cloud. Other means suited to the size and geometry of the specimen may be used provided the powder is dusted evenly over the entire surface being examined. Excess powder may be removed by shaking or tapping the part gently,

or by blowing with low-pressure, (5 to 10 psi (34 to 70 kPa)), dry, clean, compressed air.

(b) *Aqueous Developers*—Apply to the surface immediately after the excess penetrant has been removed from the part and prior to drying. The dried developer coating appears as a translucent or white coating on the part. Prepare and maintain aqueous developers in accordance with the manufacturer's instructions and apply them in such a manner as to assure complete, even coverage. Aqueous developers may be applied by spraying, flowing, or immersing the part. It is most common to immerse the parts in the prepared developer bath. Immerse parts only long enough to coat all of the part surfaces with the developer. Then remove parts from the developer bath and allow to drain. Drain all excess developer from recesses and trapped sections to eliminate pooling of developer, which can obscure discontinuities. Dry the parts in accordance with 7.1.8. (**Warning**—Atomized spraying is not recommended since a spotty film may result.) (**Warning**—If the parts are left in the bath too long, indications may leach out.)

(c) *Nonaqueous, Wet Developers*—After the excess penetrant has been removed and the surface has been dried, apply developer by spraying in such a manner as to assure complete coverage with a thin, even film of developer. These types of developer carrier evaporate very rapidly at normal room temperature and do not, therefore, require the use of a dryer. Dipping or flooding parts with nonaqueous developers is prohibited, since it will flush (dissolve) the penetrant from within the discontinuities because of the solvent action of the types of developers.

NOTE 6—**Warning:** The vapors from the evaporating, volatile solvent developer carrier may be hazardous. Proper ventilation should be provided in all cases, but especially when the surface to be examined is inside a closed volume, such as a process drum or a small storage tank.

(d) *Liquid Film Developers*—Apply by spraying as recommended by the manufacturer. Spray parts in such a manner as to insure complete coverage of the area being examined with a thin, even film of developer.

7.1.9.2 *Developer Time*—The minimum and maximum bleedout time with no developer shall be 10 min and 2 h, respectively. Developing time for dry developer begins immediately after application of the dry developer and begins when the developer coating has dried for wet developers (aqueous and nonaqueous). The minimum developer dwell time shall be 10 min for all types of developer. The maximum developer dwell time shall be 1 h for nonaqueous developer, 2 h for aqueous developer, and 4 h for dry developers.

7.1.10 *Examination*—Perform examination of parts after the applicable development time as specified in 7.1.9.2 to allow for bleedout of penetrant from discontinuities onto the developer coating. It is good practice to observe the surface while applying the developer as an aid in evaluating indications.

7.1.10.1 *Visible Ambient Light Level*—Examine fluorescent penetrant indications under black light in a darkened area. Visible ambient light should not exceed 2 fc (20 lux).

7.1.10.2 *Black Light Level*—Black light intensity, (recommended minimum of 1000 $\mu\text{W}/\text{cm}^2$) should be measured on the surface being examined with a suitable black light meter. The black light shall have a wavelength in the range from 320 to

380 nm. The intensity should be checked daily to assure the required output. Since drop in line voltage can cause decreased black light output with consequent inconsistent performance, a constant voltage transformer should be used when there is evidence of voltage fluctuation. (**Warning**—Certain high-intensity black lights may emit unacceptable amounts of visible light, which will cause fluorescent indications to disappear. Care should be taken to use only bulbs certified by the supplier to be suitable for such examination purposes.)

7.1.10.3 *Black Light Warm-Up*—Allow the black light to warm up for a minimum of 10 min prior to its use or measurement of the intensity of the ultraviolet light emitted.

7.1.10.4 *Visual Adaption*—The examiner should be in the darkened area for at least 1 min before examining parts. Longer times may be necessary for more complete adaptation under some circumstances. (**Warning**—Photochromic or darkened lenses shall not be worn during examination.)

7.1.10.5 *Housekeeping*—Keep the examination area free of interfering debris or fluorescent objects. Practice good housekeeping at all times.

7.1.11 *Evaluation*—Unless otherwise agreed upon, it is normal practice to interpret and evaluate the discontinuity indication based on the size of the penetrant indication created by the developer's absorption of the penetrant (see Reference Photographs E433).

7.1.12 *Post Cleaning*—Post cleaning is necessary in those cases where residual penetrant or developer could interfere with subsequent processing or with service requirements. It is particularly important where residual penetrant examination materials might combine with other factors in service to produce corrosion. A suitable technique, such as a simple water rinse, water spray, machine wash, vapor degreasing, solvent soak, or ultrasonic cleaning may be employed (see Test Method E165, Annex on Post Cleaning). It is recommended that if developer removal is necessary, it shall be carried out as promptly as possible after examination so that it does not fix on the part. Water spray rinsing is generally adequate. (**Warning**—Developers should be removed prior to vapor degreasing. Vapor degreasing can bake developer on parts.)

8. Special Requirements

8.1 Impurities:

8.1.1 When using penetrant materials on austenitic stainless steels, titanium, nickel-base or other high-temperature alloys, the need to restrict impurities such as sulfur, halogens, and alkali metals must be considered. These impurities may cause embrittlement or corrosion, particularly at elevated temperatures. Any such evaluation should also include consideration of the form in which the impurities are present. Some penetrant materials contain significant amounts of these impurities in the form of volatile organic solvents. These normally evaporate quickly and usually do not cause problems. Other materials may contain impurities which are not volatile and may react with the part, particularly in the presence of moisture or elevated temperatures.

8.1.2 Because volatile solvents leave the tested surface quickly without reaction under normal inspection procedures, penetrant materials are normally subjected to an evaporation procedure to remove the solvents before the materials are

analyzed for impurities. The residue from this procedure is then analyzed in accordance with Test Method **D129**, Test Method **D1552**, or Test Method **D129** decomposition followed by Test Methods **D516**, Method B (Turbidimetric Method) for sulfur. The residue may also be analyzed in accordance with Test Methods **D808** or **E165**, Annex on Methods for Measuring Total Chlorine Content in Combustible Liquid Penetrant Materials (for halogens other than fluorine) and Test Method **E165**, Annex on Method for Measuring Total Fluorine Content in Combustible Liquid Penetrant (for fluorine). The Annex on Determination of Anions and Cations by Ion Chromatography in Test Method **E165** can be used as an alternate procedure. Alkali metals in the residue are determined by flame photometry or atomic absorption spectrophotometry.

NOTE 7—Some current standards indicate that impurity levels of sulfur and halogens exceeding 1 % of any one suspect element may be considered excessive. However, this high a level may be unacceptable in some cases, so the actual maximum acceptable impurity level must be decided between supplier and user on a case by case basis.

8.2 Elevated Temperature Examination—Where penetrant examination is performed on parts that must be maintained at elevated temperature during examination, special materials and processing techniques may be required. Such examination requires qualification in accordance with **9.2**. Manufacturer's recommendations should be observed.

9. Qualification and Requalification

9.1 Personnel Qualification—Unless otherwise specified by client/supplier agreement, all examination personnel shall be

qualified/certified in accordance with a written procedure conforming to the applicable edition of Recommended Practice SNT-TC-1A, ANSI/ASNT-CP-189, NAS-410, or MIL-STD-410.

9.2 Procedure Qualification—Qualification of procedure using conditions or times differing from those specified or for new materials may be performed by any of several methods and should be agreed upon by the contracting parties. A test piece containing one or more discontinuities of the smallest relevant size is used. The test piece may contain real or simulated discontinuities, providing it displays the characteristics of the discontinuities encountered in production examinations.

9.3 Nondestructive Testing Agency Qualification—If a non-destructive testing agency as described in Practice **E543** is used to perform the examination, the agency shall meet the requirements of Practice **E543**.

9.4 Requalification may be required when a change or substitution is made in the type of penetrant materials or in the procedure (see **9.2**).

10. Keywords

10.1 fluorescent liquid penetrant testing; hydrophilic post-emulsification method; nondestructive testing

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