



# AMENDMENT -- NOTIFICATION

AA 085 01 31 REV,02

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## AA 085 01 31: PROCEDURE FOR LIQUID PENETRANT EXAMINATION

Cl.1.3: This clause should be modified as below:

"This standard confirms substantially with ASTM E165 and ASME code Section V, Article 6."

REF:	AMD. NO.	APPROVED	ISSUED	DATE	CUM. SR. NO.
Cl.8.12 of MOM OF WG(NDT)	01	WG(NDT)	Corp.R&D	June '93	A 1279



PROCEDURE FOR LIQUID PENETRANT EXAMINATION

1.0 SCOPE:

1.1 This standard details the procedure for liquid penetrant examination of non-porous ferrous and non-ferrous and non-metallic materials such as ceramics, plastics, glass, etc.

1.2 Typical surface discontinuities detectable by this method are cracks, seams, laps, cold shuts, porosity, laminations, etc.

1.3 This standard conforms substantially with ASTM E 165 - 1980 (Reapproved 1983) and ASME code section V, Article 6.

2.0 PERSONNEL REQUIREMENT:

Personnel performing non-destructive examination and evaluation shall be qualified to the recommended practice SNT-TC-1A or any other recognised practice.

3.0 DESCRIPTION:

In principle a liquid penetrant is applied to the surface to be examined and allowed to enter discontinuities, excess penetrant removed, the part dried and a developer applied. The developer functions both as a blotter to absorb penetrant that has been trapped in discontinuities and as a contrasting back ground to enhance the visibility of penetrant indications.

4.0 APPROVED METHODS & MATERIALS:

4.1 Either a colour contrast or fluorescent penetrant method may be used. Any one of the following penetrants shall be used:

- (a) Solvent Removable
- (b) Post Emulsifying
- (c) Water Washable

4.2 For nickel base alloys and/or for stainless steel materials used in nuclear components the penetrant materials, cleaner, penetrant developer, etc., used shall not contain sulphur or halogen above 1% by weight.

4.3 Selection of liquid penetrant material shall be from the same family (brand). Inter-mixing of family of liquid penetrant materials is not allowed.

5.0 PROCEDURE:

5.1 Surface Preparation:

Revisions:

Cl.7.10 of MOM of WG(NDT)

INTERPLANT  
STANDARDIZATION COMMITTEE - WG  
(NDT)

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- 5.1.1 Surface preparation by grinding or machining or other method may be employed where surface irregularities may mask indications of unacceptable discontinuities.
- 5.1.2 The surface to be examined and all adjacent areas within at least 25 mm shall be dry and free from any dirt, lint, scale, rust, welding flux, weld spatter, grease, oil or other extraneous matter that could obscure surface openings or otherwise interfere with examination.
- 5.1.3 The surface to be examined shall be cleaned with detergents, organic solvents, descaling solutions or paint removers. Degreasing and ultrasonic cleaning may be employed to increase cleaning efficiency. Cleaning method employed is an important part of the examination procedure. Cleaning solvents shall meet the requirements of Cl.4.2

**Caution:** Blasting with shot or dull sand, rotofinishing, buffing, wire brushing the soft material or machining with dull tools shall not be used as they may peen the discontinuities at the surface.

#### 5.2 Drying:

Drying, after cleaning the surface to be examined, shall be accomplished by normal evaporation or with forced hot air, as appropriate. A minimum period of time shall be established to ensure that the cleaning solution has evaporated prior to application of the penetrant.

#### 5.3 Application Of Penetrants:

- 5.3.1 The penetrant shall be applied by dipping, brushing or spraying. If the penetrant is applied by spraying using compressed air type apparatus, filters shall be placed at the air inlet to preclude contamination of penetrant by oil, water or dirt sediment that may have collected in the lines. Spraying should only be performed in a booth equipped with exhaust system.
- 5.3.2 The length of penetration time is critical and depends upon the material being inspected, the process through which it has passed and the type of discontinuities expected. The recommended penetration time is given in Table 1.
- 5.3.3 The temperature of the penetrant and the surface of the part to be examined shall not be below 10°C(50°F) nor above 50°C(125°F) throughout the examination period. Local heating or cooling is permitted provided the temperatures remain in the range of 10 to 50°C during the examination. Where it is not practical to comply with these temperature limitations, other temperatures and times shall be used provided the procedures are qualified as described in Annexure-I.

#### 5.4 Removal Of Excess Penetrant:

After the penetration time specified in the procedure has elapsed, any penetrant remaining on the surface shall be removed, taking care to minimise removal of penetrant from discontinuities.



## 5.4.1 Postemulsifying Penetrants:

The emulsifier shall be applied by spraying or dipping. The emulsifying time shall not exceed 5 minutes. After emulsification, the mixture shall be removed by water spray.

## 5.4.2 Solvent Removable Penetrants:

Excess penetrant shall be removed by wiping with a cloth or absorbent paper repeating the operation until most traces of penetrants have been removed. The remaining traces shall be removed by wiping the surface lightly with cloth or absorbent paper moistened with solvent.

**Caution:** Care shall be taken to avoid excess solvent as this may remove penetrants from discontinuities. Flushing the surface with solvent following the application of the penetrant and prior to developing is prohibited.

## 5.4.3 Water Washable Penetrants:

Excess water washable penetrant shall be removed with a water spray. The water pressure shall not exceed 0.35 N/mm<sup>2</sup> (50 Psi) and the water temperature shall not exceed 43.3°C (110°F).

## 5.5 Drying:

Surface shall be dried before the application of developer.

5.5.1 a) If postemulsifying or water washable method is used, the surface shall be dried by blotting with clean materials or by using circulating warm air, provided the temperature of the surface is not raised above 50°C (125°F).

b) For solvent removable method, the surface may be dried by normal evaporation, blotting, wiping or forced air.

## 5.6 Application Of Developer:

The developer shall be applied as soon as possible after the removal of the excess penetrant. Two types of developer, dry or wet, shall be used with fluorescent penetrant. With colour contrast penetrants, only wet developer shall be used.

### 5.6.1 Application Of Dry Developer:

Dry developer shall be applied by a soft brush, a hand operated powder bulb or a powder gun or other means provided the powder is dusted evenly over the entire surface being examined.

### 5.6.2 Application Of Wet Developer

Prior to applying suspension type wet developer to the surface, the developer must be thoroughly agitated to ensure adequate dispersion of suspended particles.

(a) Aqueous Developer Application:

Aqueous developer may be applied to either a wet or dry surface. It shall be applied by dipping, spraying or other means provided a thin coating is obtained over the entire surface being examined. Drying time may be decreased by using warm air, provided the surface temperature of the part is not raised above 50°C.

(b) Non-aqueous Developer Application:

Non-aqueous developer shall be applied only on a dry surface. It shall be applied by spraying, except where safety or restricted access preclude it. Under such conditions developer may be applied by brushing. Drying shall be by normal evaporation.

6.0 EXAMINATION:

Observe the surface during the application of the developer to detect nature of any indications which tend to bleed out profusely. Final examination shall be done between 7 minutes at the earliest and 30 minutes at the latest after application of the developer. The nature of discontinuities corresponding to the indications shall be defined depending upon the method of setting, appearance, direction, shape and dimensions of the same. If the bleed out does not alter the examination results, longer periods are permitted. If the surface to be examined is large enough to preclude complete examination within the prescribed time the surface shall be examined in increments.

6.1 Colour Contrast Penetrants (Visible Dye Penetrants):

6.1.1 With colour contrast penetrants the developer forms a reasonably uniform coating. Surface discontinuities are indicated by bleeding out of the penetrant which is normally of a deep red colour. Indication with a light pink colour may indicate excessive cleaning. Inadequate cleaning may leave an excessive background making interpretation difficult.

6.1.2 Adequate illumination is required to ensure no loss of the sensitivity in the examination. Examination shall be done under natural or suitable light (illumination level shall be in the order of 500 LUX).

6.2 Fluorescent Penetrants:

Examination of the surface shall be carried out with a high intensity black light in a darkened area or booth. Black light shall have a wave length of 3650 Å. The bulbs shall be allowed to warm up for not less than 5 minutes prior to use in the examination. The black light intensity shall be at least of 800 uW/cm<sup>2</sup> on the surface of the part being examined and the light source being kept at a distance of at least 375 mm from the surface being examined. The operator should allow his eyes to become accustomed to the darkness of the inspection booth for at least 5 minutes before inspecting the parts. He should avoid looking directly into the black light and also avoid going from the darkness to



the light and back again without allowing sufficient time for his eyes to adjust to the darkness. The intensity shall be measured at least once every 8 hours and whenever the work station is changed.

### 7.0 EVALUATION OF INDICATIONS & INTERPRETATION:

- 7.1 As the developer dries to a smooth, even white coating, indications will appear at the locations of discontinuities. Depth of surface discontinuities may be correlated with the richness of colour and speed of bleeding out. However, localised surface imperfections such as may occur from machining marks or surface conditions may produce similar indications which are non-relevant.
- 7.2 Usually, a crack or similar opening will show a line and light cracks or partially welded lap will show a broken line. Gross porosity may produce large indications covering an entire area. Very fine porosity is indicated by random dots.
- 7.3 Any non-relevant indication shall be regarded as a defect until the indication is either eliminated by surface conditioning or it is Proved non-relevant by other NDT methods.
- 7.4 Linear indications are those indications in which the length is more than three times the width. Rounded indications are indications which are circular or elliptical with the length less than three times the width.
- 7.5 All indications shall be evaluated in terms of the acceptance standards of the referencing documents.

### 8.0 ACCEPTANCE STANDARDS:

- 8.1 For castings - Refer Corporate Standard AA 085 01 32 .
- 8.2 For Austenitic Forgings - Refer Corporate Standard AA 085 01 30.
- 8.3 For Welds - Refer Corporate Standard AA 085 01 29.

### 9.0 POST EXAMINATION CLEANING:

Surfaces examined shall be cleaned after evaluation of the test with dry cotton rag with or without water rinse.

TABLE - 1 (Clause 5.3.2)

Suggested Penetration Time For Post-emulsified And Solvent Removable Penetrants

Material	Form	Type of discontinuity	*Penetration time (min.)
Aluminium	Castings	Porosity	5
		Cold shut	5
	Extrusions & Forgings	Laps	10
		Lack of fusion	5
		Porosity	5
All forms	Cracks	10	

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TABLE - 1 (Clause 5.3.2) Contd.

Material	Form	Type of discontinuity	*Penetration time (min.)
Magnesium	Castings	Porosity	5
		Cold shut	5
	Extrusions & Forgings	Laps	10
		Lack of fusion	10
		Welds	10
All forms	Cracks	10	
Steel	Castings	Porosity	10
		Cold shut	10
	Extrusions & Forgings	Laps	10
		Lack of fusion	20
		Welds	20
All forms	Cracks	20	
Brass & Bronze	Castings	Porosity	5
		Cold shut	5
	Extrusions & Forgings	Laps	10
		Lack of fusion	10
		Brazed parts	10
All forms	Cracks	10	
Plastics	All forms	Cracks	5
Glass	All forms	Cracks	5
Carbide tipped tools	All forms	Lack of fusion	5
		Porosity	5
		Crack	20
Titanium & high temperature alloys	All forms		20 to 30
Ceramic	All forms	Cracks	5
		Porosity	5

\* For lower temperatures, penetration time should be increased.

#### ANNEXURE - 1 (Clause 5.3.3)

#### PROCEDURE FOR NON-STANDARD TEMPERATURES

##### A.1 General:

When it is not practical to conduct a liquid penetrant examination within the temperature range of 15.6 to 51.6°C (60 to 125°F), the examination procedure at the proposed lower or higher temperature range requires qualification. This shall require the use of a quenched aluminium block, which is designated as 'Liquid Penetrant Comparator Block'.

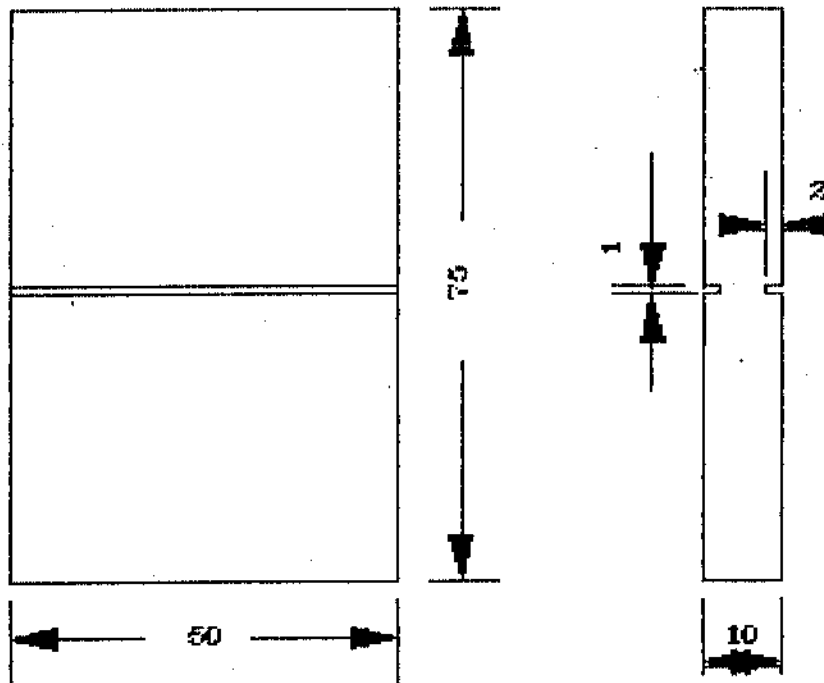
**A.2 Liquid Penetrant Comparator Block:**

The liquid penetrant comparator block shall be made of aluminum, ASTM B209, Type 2024 or SB-211. Type 2024, 10 mm (3/8 in.) thick, and shall have approximate face dimensions of 50 mm x 75 mm (2 in. x 3 in.). At the centre of each face, an area approximately 25 mm in diameter shall be marked with a 510°C (950°F) temperature indicating crayon or paint. The marked area shall be heated with a blow torch, a Bunsen burner or similar device to a temperature between 510°C (950°F) and 524°C (975°F). The specimen shall then be immediately quenched in cold water which produces a network of the fine cracks on each face. The block shall then be dried by heating to approximately 149°C (300°F). After cooling, the block shall be cut into two halves. One half of the specimen shall be designated block 'A' and the other block 'B' for identification in subsequent processing. Figure 1 illustrates the comparator blocks "A" and "B". As an alternate to cutting the block in half to make blocks "A" and "B", separate blocks 50 mm x 75 mm (2 in. x 3 in.) can be made using the heating and quenching technique as described above. Two comparator blocks with closely matched crack patterns may be used. The blocks shall be marked "A" and "B".

**A.3 Comparator Application:**

- (a) If it is desired to qualify a liquid penetrant examination procedure at a temperature of less than 15.6°C (60°F) the proposed procedure shall be applied to block "B" after the block and all materials have been cooled and held at the proposed examination temperature until the comparison is completed. A standard procedure which has previously been demonstrated as suitable for use shall be applied to block "A" in the 15.6 to 51.6°C (60 to 125°F) temperature range. The indications of cracks shall be compared between blocks "A" and "B". If the indications obtained under the proposed condition on block "B" are essentially the same as obtained on block "A" during examination at 15.6 to 51.6°C (60 to 125°F), the proposed procedure shall be considered qualified for use.
- (b) If the proposed temperature for the examination is above 51.6°C (125°F), block "B" shall be held at this temperature throughout the examination. The indication of cracks shall be compared as described in T-647.3(a) while block "B" is at the proposed temperature and block "A" is at the 15.6 to 51.6°C (60 to 125°F) temperature range.
- (c) A procedure qualified at a temperature lower than 15.6°C (60°F) shall be qualified from that temperature to 15.6°C (60°F).
- (d) To qualify a Procedure for temperatures above 51.6°C (125°F), the upper and lower temperature limits shall be established and the procedure qualified at these temperatures.
- (e) As an alternate to the requirements of (a) and (b) when using color contrast penetrants, it is permissible to use a single comparator block for the standard and non-standard temperatures and to make the comparison by photography.

- (f) When the single comparator block and photographic technique is used, the processing details (as applicable) described in (a) and (b) above shall apply. The block shall be thoroughly cleaned between the two processing steps. Photographs shall be taken after processing at the nonstandard temperature and then after processing at the standard temperature. The indication of cracks shall be compared between the two photographs. The same criteria for qualification as (a) above shall apply.
- (g) Identical photographic techniques shall be used to make the comparison photographs.



**FIGURE: 1-LIQUID PENETRANT COMPARATOR BLOCK**



# AMENDMENT - NOTIFICATION

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AA 085 01 32: EVALUATION AND ACCEPTANCE STANDARD FOR LIQUID  
PENETRANT EXAMINATION OF CASTINGS

PAGE 2 OF 2: Cl 4.0 ACCEPTANCE STANDARDS:

In the table, title of the column 3 (Unacceptable defects) is  
modified as "Linear defects"

Please see instructions on the reverse

Ref:	Amd.No.	Approved	Issued	Date:	Cur.Sr.No.
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EVALUATION AND ACCEPTANCE STANDARD FOR LIQUID PENETRANT EXAMINATION OF CASTINGS

**1.0 SCOPE:**

**1.1** This standard is applicable for Liquid Penetrant examination of castings.

**1.2** The procedure adopted for this examination is as per Corporate Standard AA 085 01 31

**2.0 DEFINITION OF INDICATIONS:**

**2.1** Circular indications are those, more or less elliptical with major axis not more than three times the minor axis.

**2.2** Linear indications are those, having length in excess of three times the average width.

**2.3** In-line indications are those, in group of three or more indications aligned side by side in line with intervening gaps of less than 2mm measured edge to edge.

**3.0 EVALUATION OF INDICATIONS:**

**3.1** Defects which occur as mechanical discontinuities at the surface will be indicated by the bleeding out of the penetrant, however, localised surface imperfections such as may occur from machining marks or surface conditions may produce similar indications which are not relevant to the detection of defects.

**3.2** Any indication which is suspected to be non-relevant is to be considered relevant till it is proved otherwise.

**3.3** Relevant indications are those which result from mechanical discontinuities. Linear indications are those indications in which the length is more than three times the width. Rounded indications are those indications which are circular or elliptical with the length less than three times the width.

**3.4** Indications measuring less than 1.5mm across shall not be taken into consideration unless they are clustered in group of more than 4 Nos. with intervening gap of less than the largest dimensions of adjacent flaws. Such clusters shall be evaluated as single defect.

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Revised

Date

Approved:

**INTERPLANT NON-DESTRUCTIVE TESTING COMMITTEE**

Prepared

Issued

Date

Corp. R&D

COMP : R & D

10 SEP 1982

**4.0 ACCEPTANCE STANDARDS:**

Castings are classified into four levels, as details below, according to the size and number of flaws permissible.

<b>Level</b>	<b>No. of acceptable indications per 100 sq. cm. surface area of length not exceeding 25cm.</b>	<b>Unacceptable defects.</b>
<b>I</b>	2 Nos. of 3mm circular indication.	Crack and hot tears.
<b>II</b>	3 Nos. of 3mm circular indication. One 5mm circular or linear indication.	-do-
<b>III</b>	3 Nos. of 3mm circular indication. 2 Nos. of 4mm circular indication. One 6mm circular or linear indication. One in-line indication of 10mm maximum length.	-do-
<b>IV</b>	4 Nos. of 3mm circular indication. 3 Nos. of 4mm circular indication. 2 Nos. of 8mm circular or linear indication.  One in-line indication of 15mm maximum length.	-do-

**Note:** The minimum permissible distance between any two or more acceptable individual flaws shall not be less than the major dimension of the larger flaw.

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