



Designation: E165/E165M – 23

Standard Practice for Liquid Penetrant Testing for General Industry¹

This standard is issued under the fixed designation E165/E165M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This practice² covers procedures for penetrant examination of materials. Penetrant testing is a nondestructive testing method for detecting discontinuities that are open to the surface such as cracks, seams, laps, cold shuts, shrinkage, laminations, through leaks, or lack of fusion and is applicable to in-process, final, and maintenance examinations. It can be effectively used in the examination of nonporous, metallic materials, ferrous and nonferrous metals, and of nonmetallic materials such as nonporous glazed or fully densified ceramics, as well as certain nonporous plastics, and glass.

1.2 This practice also provides a reference:

1.2.1 By which a liquid penetrant examination process recommended or required by individual organizations can be reviewed to ascertain its applicability and completeness.

1.2.2 For use in the preparation of process specifications and procedures dealing with the liquid penetrant testing of parts and materials. Agreement by the customer requesting penetrant testing is strongly recommended. 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.

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

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

1.4 *Units*—The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents;

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.

Current edition approved July 1, 2023. Published August 2023. Originally approved in 1960. Last previous edition approved in 2018 as E165/E165M – 18. DOI: 10.1520/E0165_E0165M-23.

² For ASME Boiler and Pressure Vessel Code applications see related Recommended Test Method SE-165 in the Code.

therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

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 appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.6 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*³

D129 Test Method for Sulfur in Petroleum Products (General High Pressure Decomposition Device Method)

D329 Specification for Acetone

D770 Specification for Isopropyl Alcohol

D1193 Specification for Reagent Water

D1552 Test Method for Sulfur in Petroleum Products by High Temperature Combustion and Infrared (IR) Detection or Thermal Conductivity Detection (TCD)

D4327 Test Method for Anions in Water by Suppressed Ion Chromatography

D6919 Test Method for Determination of Dissolved Alkali and Alkaline Earth Cations and Ammonium in Water and Wastewater by Ion Chromatography

E433 Reference Photographs for Liquid Penetrant Inspection

E516 Practice for Testing Thermal Conductivity Detectors Used in Gas Chromatography

E543 Specification for Agencies Performing Nondestructive Testing

E1208 Practice for Fluorescent Liquid Penetrant Testing Using the Lipophilic Post-Emulsification Process

³ 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.

*A Summary of Changes section appears at the end of this standard

- [E1209 Practice for Fluorescent Liquid Penetrant Testing Using the Water-Washable Process](#)
- [E1210 Practice for Fluorescent Liquid Penetrant Testing Using the Hydrophilic Post-Emulsification Process](#)
- [E1219 Practice for Fluorescent Liquid Penetrant Testing Using the Solvent-Removable Process](#)
- [E1220 Practice for Visible Penetrant Testing Using Solvent-Removable Process](#)
- [E1316 Terminology for Nondestructive Examinations](#)
- [E1418 Practice for Visible Penetrant Testing Using the Water-Washable Process](#)
- [E2297 Guide for Use of UV-A and Visible Light Sources and Meters used in the Liquid Penetrant and Magnetic Particle Methods](#)
- [E3022 Practice for Measurement of Emission Characteristics and Requirements for LED UV-A Lamps Used in Fluorescent Penetrant and Magnetic Particle Testing](#)
- 2.2 *APHA Standard*.⁴
- [429 Method for the Examination of Water and Wastewater](#)
- 2.3 *SAE Standards*.⁵
- [AMS 2644 Inspection Material, Penetrant](#)
- [QPL-AMS-2644 Qualified Products of Inspection Materials, Penetrant](#)

3. Terminology

3.1 The definitions relating to liquid penetrant testing, which appear in Terminology [E1316](#), shall apply to the terms used in this practice.

NOTE 1—Throughout this practice, the term *blacklight* has been changed to *UV-A* to conform with the latest terminology in Terminology [E1316](#). *Blacklight* can mean a broad range of ultraviolet radiation – fluorescent penetrant testing uses only UV-A light.

4. Summary of Practice

4.1 Liquid penetrant may consist of visible or fluorescent material. The liquid penetrant is applied evenly over the surface being examined and allowed to enter open discontinuities. After a suitable dwell time, the excess surface penetrant is removed. A developer is applied to draw the entrapped penetrant out of the discontinuity and stain the developer. The test surface is then examined to determine the presence or absence of indications.

NOTE 2—The developer may be omitted by agreement between the contracting parties.

NOTE 3—Fluorescent penetrant examination shall not follow a visible penetrant examination unless the procedure has been qualified in accordance with [10.2](#), because visible dyes may cause deterioration or quenching of fluorescent dyes.

4.2 Processing parameters, such as surface precleaning, penetrant dwell time, and excess penetrant removal methods, are dependent on the specific materials used, the nature of the part under examination (that is, size, shape, surface condition, alloy), and type of discontinuities expected.

⁴ Available from American Public Health Association, Publication Office, 1015 Fifteenth Street, NW, Washington, DC 20005.

⁵ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.

5. Significance and Use

5.1 Liquid penetrant testing methods indicate the presence, location, and to a limited extent, the nature and magnitude of the detected discontinuities. Each of the various penetrant methods has been designed for specific uses such as critical service items, volume of parts, portability, or localized areas of examination. The method selected will depend accordingly on the design and service requirements of the parts or materials being tested.

6. Classification of Penetrant Materials and Methods

6.1 Liquid penetrant testing methods and materials are classified in accordance with AMS 2644 as listed in [Table 1](#).

6.2 *Fluorescent Penetrant Testing (Type I)*—Fluorescent penetrant testing utilizes penetrants that fluoresce brilliantly when excited by UV-A radiation. The sensitivity of fluorescent penetrants depends on their ability to be retained in the various size discontinuities during processing, and then to bleed out into the developer coating and produce indications that will fluoresce. Fluorescent indications are many times brighter than their surroundings when viewed under appropriate UV-A illumination.

6.3 *Visible Penetrant Testing (Type II)*—Visible penetrant testing uses a penetrant that can be seen in visible light. The penetrant is usually red, so that resultant indications produce a definite contrast with the white background of the developer. Visible penetrant indications must be viewed under adequate visible light.

7. Materials

7.1 *Liquid Penetrant Testing Materials* consist of fluorescent or visible penetrants, emulsifiers (oil-base and water-base), removers (water and solvent), and developers (dry powder, aqueous, and nonaqueous). A family of liquid penetrant testing materials consists of the applicable penetrant and emulsifier, as recommended by the manufacturer. Any liquid penetrant, remover, and developer listed in QPL-AMS-2644 can be used, regardless of the manufacturer. Penetrants and emulsifiers shall be from the same family; use of a penetrant and emulsifier from different manufacturers or family groups is prohibited.

NOTE 4—Refer to [9.1](#) for special requirements for sulfur, halogen, and alkali metal content.

TABLE 1 Classification of Penetrant Testing Types and Methods

Type I—Fluorescent Penetrant Testing	
Method A—Water-washable (see Practice E1209)	
Method A(W)—Water Washable Penetrant (penetrant containing >20 % water) (see Practice E1209)	
Method B—Post-emulsifiable, lipophilic (see Practice E1208)	
Method C—Solvent removable (see Practice E1219)	
Method D—Post-emulsifiable, hydrophilic (see Practice E1210)	
Type II—Visible Penetrant Testing	
Method A—Water-washable (see Practice E1418)	
Method A(W)—Water Washable Penetrant (penetrant containing >20 % water) (see Practice E1418)	
Method C—Solvent removable (see Practice E1220)	

NOTE 5—While approved penetrant materials will not adversely affect common metallic materials, some plastics or rubbers may be swollen or stained by certain penetrants.

7.2 Penetrants:

7.2.1 *Post-Emulsifiable Penetrants* are insoluble in water and cannot be removed with water rinsing alone. They are formulated to be selectively removed from the surface using a separate emulsifier. Properly applied and given a proper emulsification time, the emulsifier combines with the excess surface penetrant to form a water-washable mixture, which can be rinsed from the surface, leaving the surface free of excessive fluorescent background. Proper emulsification time must be experimentally established and maintained to ensure that over-emulsification does not result in loss of indications.

7.2.2 *Water-Washable Penetrants* are formulated to be directly water-washable from the surface of the test part, after a suitable penetrant dwell time. Because the emulsifier is formulated into the penetrant or the penetrant is water-based (penetrant containing >20 % water), water-washable penetrants can be washed out of discontinuities if the rinsing step is too long or too vigorous. It is therefore extremely important to exercise proper control in the removal of excess surface penetrant to ensure against overwashing. Some penetrants are less resistant to overwashing than others, so caution should be exercised.

7.2.3 *Solvent-Removable Penetrants* are formulated so that excess surface penetrant can be removed by wiping until most of the penetrant has been removed. The remaining traces should be removed with the solvent remover (see 8.6.4). To prevent removal of penetrant from discontinuities, care should be taken to avoid the use of excess solvent. Flushing the surface with solvent to remove the excess penetrant is prohibited as the penetrant indications could easily be washed away.

7.3 Emulsifiers:

7.3.1 *Lipophilic Emulsifiers* are oil-miscible liquids used to emulsify the post-emulsified penetrant on the surface of the part, rendering it water-washable. The individual characteristics of the emulsifier and penetrant, and the geometry/surface roughness of the part material contribute to determining the emulsification time.

7.3.2 *Hydrophilic Emulsifiers* are water-miscible liquids used to emulsify the excess post-emulsified penetrant on the surface of the part, rendering it water-washable. These water-base emulsifiers (detergent-type removers) 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.

7.3.2.1 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 individual characteristics of the emulsifier and penetrant, and the geometry and surface roughness of the part material contribute to determining the emulsification time. Emulsification concentration shall be monitored weekly using a suitable refractometer.

7.4 *Solvent Removers*—Solvent removers function by dissolving the penetrant, making it possible to wipe the surface clean and free of excess penetrant.

7.5 *Developers*—Developers form a translucent or white absorptive coating that aids in bringing the penetrant out of surface discontinuities through blotting action, thus increasing the visibility of the indications.

7.5.1 *Dry Powder Developers*—Dry powder developers are used as supplied, that is, free-flowing, non-caking powder (see 8.8.1). Care should be taken not to contaminate the developer with fluorescent penetrant, as the contaminated developer specks can appear as penetrant indications.

7.5.2 *Aqueous Developers*—Aqueous developers are normally supplied as dry powder particles to be either suspended (water suspendable) or dissolved (water soluble) in water. The concentration, use, and maintenance shall be in accordance with manufacturer's recommendations. Water soluble developers shall not be used with Type II penetrants or Type I, Method A or Method A(W) (penetrant containing >20 % water) penetrants.

NOTE 6—Aqueous developers may cause stripping of indications if not properly applied and controlled. The procedure should be qualified in accordance with 10.2.

7.5.3 *Nonaqueous Wet Developers*—Nonaqueous wet developers are supplied as suspensions of developer particles in a nonaqueous solvent carrier ready for use as supplied. Nonaqueous, wet developers are sprayed on to form a thin coating on the surface of the part when dried. This thin coating serves as the developing medium.

NOTE 7—This type of developer is intended for application by spray only.

8. Procedure

8.1 The following processing parameters apply to both fluorescent and visible penetrant testing methods.

8.2 *Temperature Limits*—The temperature of the penetrant materials and the surface of the part to be processed shall be between 40 °F and 125 °F [4 °C and 52 °C] or the procedure must be qualified at the temperature used as described in 10.2.

8.3 *Examination Sequence*—Final penetrant examination shall be performed after the completion of all operations that could cause surface-connected discontinuities or operations that could expose discontinuities not previously open to the surface. Such operations include, but are not limited to, grinding, welding, straightening, machining, and heat treating. Satisfactory examination results can usually be obtained on surfaces in the as-welded, as-rolled, as-cast, as-forged, or ceramics in the densified condition.

8.3.1 *Surface Treatment*—Final penetrant testing may be performed prior to treatments that can smear the surface but not by themselves cause surface discontinuities. Such treatments include, but are not limited to, vapor blasting, deburring, sanding, buffing, sand blasting, or lapping. Performance of final penetrant testing after such surface treatments necessitates that the part(s) be etched to remove smeared metal from the surface prior to testing unless otherwise agreed by the contracting parties. Note that final penetrant testing shall always precede surface peening.

NOTE 8—Sand or shot blasting can close discontinuities, so extreme care should be taken to avoid masking discontinuities. Under certain circumstances, however, grit blasting with certain air pressures, mediums, or both, may be acceptable without subsequent etching when agreed by the contracting parties.

NOTE 9—Surface preparation of structural or electronic ceramics for penetrant testing by grinding, sand blasting, and etching is not recommended because of the potential for damage.

8.4 Precleaning—The success of any penetrant testing procedure is greatly dependent upon the surrounding 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 examined 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 rust, scale, welding flux, weld spatter, grease, paint, oily films, dirt, and so forth, that might interfere with the penetrant process. All of these contaminants can prevent the penetrant from entering discontinuities (see **Annex A1** on Cleaning of Parts and Materials).

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

NOTE 10—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.

8.5 Penetrant Application—After the part has been cleaned, dried, and is within the specified temperature range, the penetrant is applied to the surface to be examined so that the entire part or area under examination is completely covered with penetrant. Application methods include 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. Not all penetrant materials are suitable for electrostatic spray applications, so tests

should be conducted prior to use. Electrostatic spray application can eliminate excess liquid build-up 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.

NOTE 11—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.

8.5.1 Penetrant Dwell Time—After application, allow excess penetrant to drain from the part (care should be taken to prevent pools of penetrant from forming on the part), while allowing for proper penetrant dwell time (see **Table 2**). The length of time the penetrant must remain on the part to allow proper penetration should be as recommended by the penetrant manufacturer. **Table 2**, however, provides a guide for selection of penetrant dwell times for a variety of materials, forms, and types of discontinuities. The maximum dwell time shall not exceed that recommended by the manufacturer; if no maximum is provided, the maximum dwell shall not exceed 2 h unless penetrant is reapplied as required.

8.6 Penetrant Removal

8.6.1 Water Washable (Method A and Method A(W)):

8.6.1.1 Removal of Water Washable Penetrant—After the required penetrant dwell time, the excess penetrant on the surface being examined must be removed with water. It can be removed manually with a coarse spray or wiping the part surface with a dampened rag, automatic or semi-automatic water-spray equipment, or by water immersion. For immersion rinsing, parts are completely immersed in the water bath with air or mechanical agitation.

(a) The temperature of the water shall be maintained within the range of 50 °F to 100 °F [10 °C to 38 °C].

(b) Spray-rinse water pressure shall not exceed 40 psi [275 kPa]. When hydro-air pressure spray guns are used, the air pressure should not exceed 25 psi [172 kPa].

NOTE 12—Overwashing should be avoided. Excessive washing can cause penetrant to be washed out of discontinuities; spray nozzles should be kept a minimum of 12 in. [30 cm] from the surface when no physical limitations exist. With fluorescent penetrant methods perform the manual

TABLE 2 Recommended Minimum Dwell Times

Material	Form	Type of Discontinuity	Dwell Times ^A (minutes)	
			Penetrant ^B	Developer ^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 50 °F to 125 °F [10 °C to 52 °C]. For temperatures between 40 °F and 50 °F [4.4 °C and 10 °C], recommend a minimum dwell time of 20 min.

^B Maximum penetrant dwell time in accordance with **8.5.1**.

^C Development time begins as soon as wet developer coating has dried on surface of parts (recommended minimum). Maximum development time in accordance with **8.8.4**.

rinsing operation under UV-A light so that it can be determined when the surface penetrant has been adequately removed.

8.6.2 *Lipophilic Emulsification (Method B):*

8.6.2.1 *Application of Lipophilic Emulsifier*—After the required penetrant dwell time, the excess penetrant on the part must be emulsified by immersing or flooding the parts with the required emulsifier (the emulsifier combines with the excess surface penetrant and makes the mixture removable by water rinsing). Lipophilic emulsifier shall not be applied by spray or brush and the part or emulsifier shall not be agitated while being immersed. After application of the emulsifier, the parts shall be drained and positioned in a manner that prevents the emulsifier from pooling on the part(s).

8.6.2.2 *Emulsification Time*—The emulsification time begins as soon as the emulsifier is applied. The length of time that the emulsifier is allowed to remain on a part and in contact with the penetrant is dependent on the type of emulsifier employed and the surface roughness. Nominal emulsification time should be as recommended by the manufacturer. The actual emulsification time must be determined experimentally for each specific application. The surface finish (roughness) of the part is a significant factor in the selection of and in the emulsification time of an emulsifier. Contact time shall be kept to the minimum time to obtain an acceptable background and shall not exceed 3 min.

8.6.2.3 *Post Rinsing*—Effective post rinsing of the emulsified penetrant from the surface can be accomplished using either manual, semi-automated, or automated water immersion or spray equipment or combinations thereof.

8.6.2.4 *Immersion*—For immersion post rinsing, parts are completely immersed in the water bath with air or mechanical agitation. The amount of time the part is in the bath should be the minimum required to remove the emulsified penetrant. In addition, the temperature range of the water should be 50 °F to 100 °F [10 °C to 38 °C]. Any necessary touch-up rinse after an immersion rinse shall meet the requirements of 8.6.2.5.

8.6.2.5 *Spray Post Rinsing*—Effective post rinsing following emulsification can also be accomplished by either manual or automatic water spray rinsing. The water temperature shall be between 50 °F and 100 °F [10 °C and 38 °C]. The water spray pressure shall not exceed 40 psi [275 kPa] when manual spray guns are used. When hydro-air pressure spray guns are used, the air pressure should not exceed 25 psi [172 kPa].

8.6.2.6 *Rinse Effectiveness*—If the emulsification and final rinse step is not effective, as evidenced by excessive residual surface penetrant after emulsification and rinsing; thoroughly reclean and completely reprocess the part.

8.6.3 *Hydrophilic Emulsification (Method D):*

8.6.3.1 *Application of Hydrophilic Remover*—Following the required penetrant dwell time, the parts may be prerinsed with water prior to the application of hydrophilic emulsifier. This prerinse allows for the removal of excess surface penetrant from the parts prior to emulsification so as to minimize penetrant contamination in the hydrophilic emulsifier bath, thereby extending its life. It is not necessary to prerinse a part if a spray application of emulsifier is used.

8.6.3.2 *Prerinsing Controls*—Effective prerinsing is accomplished by manual, semi-automated, or automated water spray

rinsing of the part(s). The water spray pressure shall not exceed 40 psi [275 kPa] when manual 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]. Water free of contaminants that could clog spray nozzles or leave a residue on the part(s) is recommended.

8.6.3.3 *Application of Emulsifier*—The residual surface penetrant on part(s) must be emulsified by immersing the part(s) in an agitated hydrophilic emulsifier bath or by spraying the part(s) with water/emulsifier solutions thereby rendering the remaining residual surface penetrant water-washable for the final rinse station. The emulsification time begins as soon as the emulsifier is applied. The length of time that the emulsifier is allowed to remain on a part and in contact with the penetrant is dependent on the type of emulsifier employed and the surface roughness. The emulsification time should be determined experimentally for each specific application. The surface finish (roughness of the part) is a significant factor in determining the emulsification time necessary for an emulsifier. Contact emulsification time should be kept to the least possible time consistent with an acceptable background and shall not exceed 2 min.

(a) *Immersion*—For immersion application, parts shall be completely immersed in the emulsifier bath. The hydrophilic emulsifier concentration shall be as recommended by the manufacturer and the bath or part shall be gently agitated by air or mechanically throughout the cycle. The minimum time to obtain an acceptable background shall be used, but the dwell time shall not be more than 2 min unless approved by the contracting parties.

(b) *Spray Application*—For spray applications, all part surfaces should be evenly and uniformly sprayed with a water/emulsifier solution to effectively emulsify the residual penetrant on part surfaces to render it water-washable. The concentration of the emulsifier for spray application should be in accordance with the manufacturer's recommendations, but it shall not exceed 5 %. The water spray pressure should be less than 40 psi [275 kPa]. The nozzle shall produce a coarse spray pattern similar to that used in rinsing. Contact with the emulsifier shall be kept to the minimum time to obtain an acceptable background and shall not exceed 2 min. The water temperature shall be maintained between 50 °F and 100 °F [10 °C and 38 °C].

8.6.3.4 *Post-Rinsing of Hydrophilic Emulsified Penetrants*—Effective post-rinsing of emulsified penetrant from the surface can be accomplished using either manual or automated water spray, water immersion, or combinations thereof. The total rinse time shall not exceed 2 min regardless of the number of rinse methods used.

(a) *Immersion Post-Rinsing*—If an agitated immersion rinse is used, the amount of time the part(s) is (are) in the bath shall be the minimum required to remove the emulsified penetrant and shall not exceed 2 min. In addition, the temperature range of the water shall be within 50 °F and 100 °F [10 °C and 38 °C]. Be aware that a touch-up rinse may be necessary after immersion rinse, but the total wash time still shall not exceed 2 min.

(b) *Spray Post-Rinsing*—Effective post-rinsing following emulsification can also be accomplished by manual, semi-automatic, or automatic water spray. The water spray pressure shall not exceed 40 psi [275 kPa] when manual 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]. The water temperature shall be between 50 °F and 100 °F [10 °C and 38 °C]. The spray rinse time shall be less than 2 min, unless otherwise specified.

8.6.3.5 *Rinse Effectiveness*—If the emulsification and final rinse steps are not effective, as evidenced by excessive residual surface penetrant after emulsification and rinsing, thoroughly reclean, and completely reprocess the part.

8.6.4 *Removal of Solvent-Removable Penetrant (Method C)*—After the required penetrant dwell time, the excess penetrant is removed by wiping with a dry, clean, lint-free cloth/towel. Then use a clean lint-free cloth/towel lightly moistened with solvent to remove the remaining traces of surface penetrant as determined by examination under UV-A lighting for fluorescent methods and visible light for visible methods. Perform a final wipe using a dry, clean cloth to remove any solvent residues that might remain. Gentle wiping must be used to avoid removing penetrant from any discontinuity. On smooth surfaces, an alternate method of removal can be done by wiping with a clean, dry cloth. Flushing the surface with solvent following the application of the penetrant and prior to developing is prohibited.

8.7 *Drying*—Regardless of the type and method of penetrant used, drying the surface of the part(s) is necessary prior to applying dry or nonaqueous developers or following the application of the aqueous developer. Drying time will vary with the type of drying used and the size, nature, geometry, and number of parts being processed.

8.7.1 *Drying Parameters*—Components shall be air dried at room temperature or in a drying oven. Room temperature drying can be aided by the use of fans. Oven temperatures shall not exceed 160 °F [71 °C]. Drying time shall only be that necessary to adequately dry the part. Components shall be removed from the oven after drying. Components should not be placed in the oven with pooled water or pooled aqueous solutions/suspensions.

8.8 *Developer Application*—There are various modes of effective application of the various types of developers such as dusting, immersing, flooding, or spraying. The developer form, the part size, configuration, and surface roughness will influence the choice of developer application.

8.8.1 *Dry Powder Developer (Form A)*—Dry powder developers shall be applied after the part is dry in such a manner as to ensure complete coverage of the area of interest. Parts can be immersed in a container of dry developer or in a fluid bed of dry developer. They can also be dusted with the powder developer through a hand powder bulb or a conventional or electrostatic powder gun. It is common and 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 applied evenly over the entire surface being examined. Excess developer powder may be removed by shaking or

tapping the part, or by blowing with low-pressure dry, clean, compressed air not exceeding 5 psi [34 kPa]. Dry developers shall not be used with Type II penetrant.

8.8.2 *Aqueous Developers (Forms B and C)*—Water soluble developers (Form B) are prohibited for use with Type II penetrants or Type I, Method A penetrants. Water suspendable developers (Form C) can be used with both Type I and Type II penetrants. Aqueous developers shall be applied to the part immediately after the excess penetrant has been removed and prior to drying. Aqueous developers shall be prepared and maintained in accordance with the manufacturer's instructions and applied in such a manner as to ensure complete, even, part coverage. Aqueous developers may be applied by spraying, flowing, or immersing the part in a prepared developer bath. Immerse the parts only long enough to coat all of the part surfaces with the developer since indications may leach out if the parts are left in the bath too long. After the parts are removed from the developer bath, allow the parts 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 8.7. The dried developer coating appears as a translucent or white coating on the part.

8.8.3 *Nonaqueous Wet Developers (Forms D and E)*—After the excess penetrant has been removed and the surface has been dried, apply nonaqueous wet developer by spraying in such a manner as to ensure complete part coverage with a thin, even film of developer. The developer shall be applied in a manner appropriate to the type of penetrant being used. For visible dye, the developer must be applied thickly enough to provide a contrasting background. For fluorescent dye, the developer must be applied thinly to produce a translucent covering. Dipping or flooding parts with nonaqueous developers is prohibited, because the solvent action of these types of developers can flush or dissolve the penetrant from within the discontinuities.

NOTE 13—The vapors from the volatile solvent carrier in the developer may be hazardous. Proper ventilation should be provided at all times, but especially when the developer is applied inside a closed area.

8.8.4 *Developing Time*—The length of time the developer is to remain on the part prior to examination shall be not less than 10 min. Developing time begins immediately after the application of dry powder developer or as soon as the wet (aqueous or nonaqueous) developer coating is dry (that is, the water or solvent carrier has evaporated to dryness). The maximum permitted developing times shall be 4 h for dry powder developer (Form A), 2 h for aqueous developer (Forms B and C), and 1 h for nonaqueous developer (Forms D and E).

8.9 *Examination*—After the applicable development time, perform examination of the parts under visible light or UV-A radiation as appropriate. It may be helpful to observe the bleed out during the development time as an aid in interpreting indications. LED UV-A sources, with the exception of Bore-scope LED UV-A sources, shall meet the requirements of Practice E3022.

8.9.1 *UV-A Radiance Examination*—Examine parts tested with Type I fluorescent penetrant under UV-A irradiance in a darkened area. Ambient visible light shall not exceed 2 fc

[21.5 lx]. The ambient light measurement shall be made with a suitable visible light sensor at the examination surface, with visible light sources off.

NOTE 14—Because the fluorescent constituents in the penetrant will eventually fade with direct exposure to UV-A sources, direct exposure of the part under test to UV-A radiation should be minimized when not removing excess penetrant or evaluating indications.

8.9.1.1 *UV-A Radiance Level Control*—UV-A sources shall provide a minimum irradiance of 1000 $\mu\text{W}/\text{cm}^2$, at a distance of 15 in. [38.1 cm]. The intensity shall be checked daily to ensure the required output (see Guide E2297 for more information). Reflectors and filters shall also be checked daily for cleanliness and integrity. Cracked or broken ultraviolet filters shall be replaced immediately. LED UV-A sources used to examine parts shall be checked daily (or before use if not used daily) to ensure that all elements are operational. If any diode element is not operational the condition shall be corrected or the unit replaced. The operational check should be performed by placing a white sheet of paper over the lamp and then viewing the transmitted light from each diode. LED UV-A sources are at full intensity at power-on, and the intensity may decrease as the lamp stabilizes.

NOTE 15—Certain high-intensity UV-A sources may emit unacceptable amounts of visible light, which can cause fluorescent indications to disappear. Care should be taken to only use bulbs suitable for fluorescent penetrant examination purposes.

8.9.1.2 *UV-A Source Warm-Up*—Unless otherwise specified by the manufacturer, allow the UV-A source to warm up for a minimum of 10 min prior to use or measurement of its intensity. LED UV-A sources do not require warmup.

8.9.1.3 *Visual Adaptation*—Personnel examining parts after penetrant processing shall be in the darkened area for at least 1 min before examining parts. Longer times may be necessary under some circumstances. Photochromic or tinted lenses shall not be worn during the processing and examination of parts.

8.9.2 *Visible Light Examination*—Examine parts tested with Type II visible penetrant under either natural or artificial visible light. Proper illumination is required to ensure adequate sensitivity of the examination. A minimum light intensity at the examination surface of 100 fc [1076 lx] is required (see Guide E2297 for more information).

8.9.3 *Housekeeping*—Keep the examination area free of interfering debris, including fluorescent residues and objects.

8.9.4 *Indication Verification*—If allowed by the specific procedure, indications may be evaluated by wiping the indication with a solvent-dampened swab, brush, or lint-free cloth allowing the area to dry, and redeveloping the area. Redevelopment time shall be a minimum of 10 min, except nonaqueous redevelopment time should be a minimum of 3 min. If the indication does not reappear, the original indication may be considered false. This procedure may be performed up to two times for any given original indication. Unless prohibited by the Purchaser, Specification D770 isopropyl alcohol and Specification D329 acetone are commonly accepted solvents.

8.9.5 *Evaluation*—All indications found during examination shall be evaluated in accordance with acceptance criteria as specified. Reference Photographs of indications are noted in E433.

8.10 *Post Cleaning*—Post cleaning is necessary when residual penetrant or developer could interfere with subsequent processing or with service requirements. It is particularly important where residual penetrant testing materials might combine with other factors in service to produce corrosion and prior to vapor degreasing or heat treating the part as these processes can bake the developer onto the part. A suitable technique, such as a simple water rinse, water spray, machine wash, solvent soak, or ultrasonic cleaning may be employed (see Annex A1 for further information on post cleaning). It is recommended that if developer removal is necessary, it should be carried out as promptly as possible after examination so that the developer does not adhere to the part.

9. Special Requirements

9.1 Impurities:

9.1.1 When using penetrant materials on austenitic stainless steels, titanium, nickel-base, or other high-temperature alloys, the need to restrict certain 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 shall 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 that 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.

9.1.2 Because volatile solvents leave the surface quickly without reaction under normal examination 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 D1552 or Test Method D129 decomposition followed by Test Method E516, Method B (Turbidimetric Method) for sulfur. The residue may also be analyzed by Annex A2 on Methods for Measuring Total Chlorine Content in Combustible Liquid Penetrant Materials (for halogens other than fluorine) and Annex A3 on Method for Measuring Total Fluorine Content in Combustible Liquid Penetration Materials (for fluorine). An alternative procedure, Annex A4 on Determination of Anions by Ion Chromatography, provides a single instrumental technique for rapid sequential measurement of common anions such as chloride, fluoride, and sulfate (see Test Method D4327). Alkali metals in the residue are determined by flame photometry, atomic absorption spectrophotometry, or ion chromatography (see Test Method D6919).

NOTE 16—Some current standards require impurity levels of sulfur and halogens to not exceed 1 % of any one suspect element. This level, however, may be unacceptable for some applications, so the actual maximum acceptable impurity level must be decided between supplier and user on a case by case basis.

9.2 *Elevated-Temperature or Low-Temperature Examination*—Where penetrant examination is performed on parts that must be maintained at elevated or lowered temperature during testing, special penetrant materials and processing