



Designation: E 1210 – 99

Standard Test Method for Fluorescent Liquid Penetrant Examination Using the Hydrophilic Post-Emulsification Process¹

This standard is issued under the fixed designation E 1210; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope

1.1 This test method 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 test method 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 test method 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 *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 and health practices and determine the applicability of regulatory limitations prior to use.* For specific hazard statements, see Note 11 and Note 16.

¹ This test method is under the jurisdiction of ASTM Committee E-7 on Nondestructive Testing and is the direct responsibility of Subcommittee E07.03 on Liquid Penetrant and Magnetic Particle Methods.

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1.5 All areas of this test method 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:

D 129 Test Method for Sulfur in Petroleum Products (General Bomb Method)²

D 516 Test Method for Sulfate Ion in Water³

D 808 Test Method for Chlorine in New and Used Petroleum Products (Bomb Method)²

D 1552 Test Method for Sulfur in Petroleum Products (High-Temperature Method)²

E 165 Test Method for Liquid Penetrant Examination⁴

E 433 Reference Photographs for Liquid Penetrant Inspection⁴

E 543 Practice for Agencies Performing Nondestructive Testing⁴

E 1316 Terminology for Nondestructive Examinations⁴

2.2 ASNT Documents:

SNT-TC-1A Recommended Practice for Personnel Qualification and Certification in Nondestructive Testing⁵

ANSI/ASNT-CP-189 Standard for Qualification and Certification of Nondestructive Testing Personnel⁵

2.3 Military Standard:

MIL-STD-410 Nondestructive Testing Personnel Qualification and Certification⁶

2.4 AIA Standard:

NAS 410 Certification and Qualification of Nondestructive Testing Personnel⁷

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

² Annual Book of ASTM Standards, Vol 05.01.

³ Annual Book of ASTM Standards, Vol 11.01.

⁴ Annual Book of ASTM Standards, Vol 03.03.

⁵ Available from the American Society for Nondestructive Testing, 1711 Arlington Plaza, Columbus, OH 43228-0518.

⁶ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

⁷ Available from the Aerospace Industries Association of America, Inc., 1250 Eye St., N.W., Washington, DC 20005.

Specifications and Standards) cited in the solicitation.

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

3. Terminology

3.1 *Definitions*—definitions relating to liquid penetrant examination, which appear in Terminology E 1316, shall apply to the terms used in this test method.

4. Summary of Test Method

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.

NOTE 1—Caution: 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 test method 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 Examination Materials*, for use in the hydrophilic post-emulsification process, (see Note 2) 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 2—Refer to 8.1 for special requirements for sulfur, halogen, and alkali metal content.

NOTE 3—Caution: 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 (maximum 33 %) or spray (maximum 5 %). 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)).

NOTE 4—Caution: 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)).

NOTE 5—Caution: 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)).

