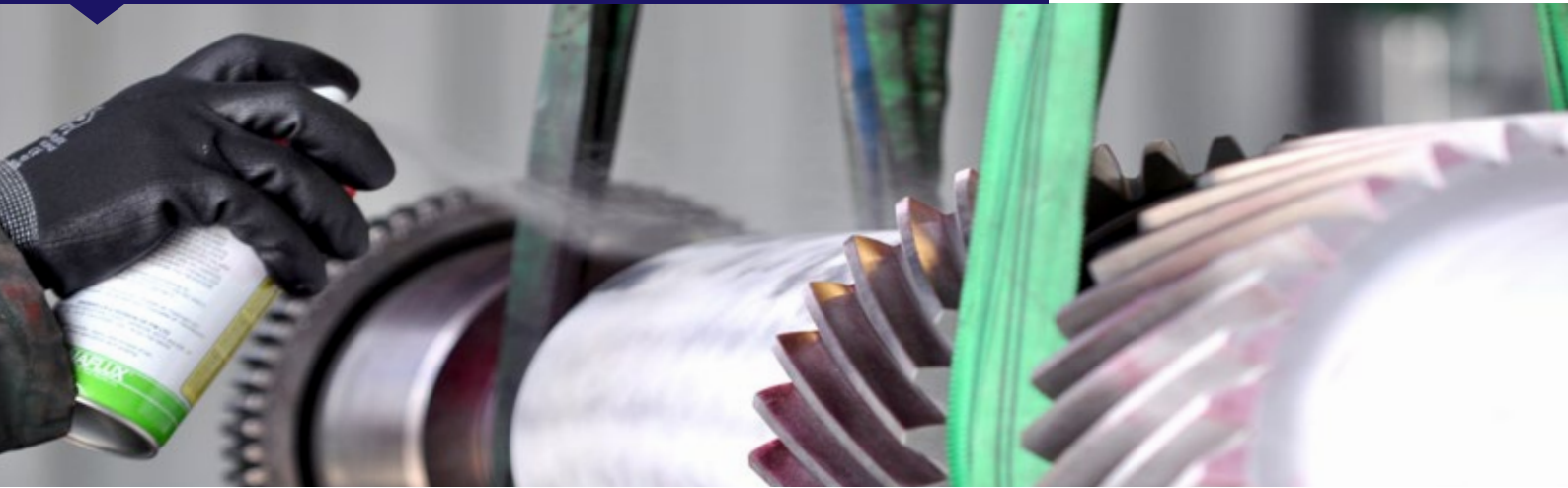


# DYE PENETRANT TESTING (PT)



FOR ALL YOUR INSPECTION NEEDS



The liquid penetrant examination method is an effective means for detecting discontinuities which are open to the surface of nonporous metals and other materials such as metals, plastics, glass, and ceramics e.g. typical discontinuities detectable by this method are cracks, seams, laps, cold shuts, laminations, and porosity.

The liquid penetrant contains either a colored dye easily seen in white light, or a fluorescent dye visible under black (ultraviolet) light. The penetrant is applied by dipping, spraying, brushing, or flowing. After penetrant application, a sufficient time (dwell time) is provided to permit the penetrant to permeate the flaw.

Prior to each liquid penetrant examination, the surface to be examined and all adjacent areas within at least 1 in. (25 mm) shall be dry and free of all dirt, grease, lint, scale, welding flux, weld spatter, paint, oil, and other extraneous matter that could obscure surface openings or otherwise interfere with the examination.

The liquid penetrant can be examined by PT or FPT method, for the highest sensitivity a fluorescent Penetrant in combination with a black light is available. PT can only find surface breaking defects, needs a very thorough surface preparation and has a high sensitivity.

