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Designation: E 165 - 02

Standard Test Method for Liquid Penetrant Examination¹

This standard is issued under the fixed designation E 165; the number immediately following the designation indicates the year of original approval or the year of revision, or the year of approval, if the standard was previously published under a different designation. A superscript epsilon (ε) indicates an editorial change since the original approval.

1. Scope
1.1 This test method² governs procedures for penetrant examination of materials. This is a nondestructive testing method for detecting discontinuities that are open to the surface such as cracks, seams, holes, cold chate, inclusions, foreign matter, or lack of fusion and are applicable to pre-process, final, and maintenance examination. This can be effectively used in the examination of nonporous, metallic materials, both ferrous and nonferrous, and of nonmetallic materials such as glass or fully densified ceramics, certain thermoplastic plastics, and glass.
1.2 This test method also provides a reference:
1.2.1 To which a liquid penetrant examination process recommended or required by individual organizations can be referred to determine its applicability and consistency.
1.2.2 For use in the preparation of process specifications dealing with the liquid penetrant examination of material and parts. Agreement by the user and the supplier 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 criteria for evaluation of the indications observed. It should be pointed out, however, that after indications have been produced, they must be interpreted and classified as defects. For this purpose they must be a separate code or specification or a specific agreement as to the type, size, location, and direction of indications considered acceptable, and these considered unacceptable.
1.4 The values stated in inch-pound units are to be regarded as the standard. SI units are provided 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 appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.
2. Referenced Documents
2.1 ASTM Standards:
D 155 Test Method for Sulfate in Petroleum Products (Gravimetric Bomb Method)³
D 895 Test Method for Sulfate Ion in Water⁴
D 895 Test Method for Chloride in New and Used Petroleum Products (Block Method)⁵
D 1195 Specification for Reagent Water⁶
D 1532 Test Method for Sulfate in Petroleum Products (High Temperature Method)⁷
D 4327 Test Method for Arsenic in Water by Chemically Separated Barium Chromate⁸
E 433 Reference Photographs for Liquid Penetrant Inspection⁹
E 543 Practice for Evaluating Agencies that Perform Non-Destructive Testing¹⁰
E 1208 Test Method for Fluorescence Liquid Penetrant Examination Using the Lipophilic Post-Emulsification Process¹¹
E 1209 Test Method for Fluorescence Liquid Penetrant Examination Using the Water-Washable Process¹²
E 1210 Test Method for Fluorescence Liquid Penetrant Examination Using the Hydrophilic Post-Emulsification Process¹³
E 1211 Test Method for Fluorescence Liquid Penetrant Examination Using the Solvent-Removable Process¹⁴
E 1164 Terminology for Nondestructive Examinations¹⁵
E 1164 Test Method for Visible Penetrant Examination Using the Water-Washable Process¹⁶
2.2 ANSI Document:
Recommended Practice SNT-TC-1A for Nondestructive Testing Personnel Qualification and Certification¹⁷
ANSI/ASNT CP 189 Standard for Qualification and Certification of Nondestructive Testing Personnel¹⁸

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