



Standard Practice for Liquid Penetrant Examination 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 testing. 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 inspection 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;

therefore, each system shall be used independently of the other. Combining values from the two systems may result in nonconformance 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 and health practices and determine the applicability of regulatory limitations prior to use.

2. Referenced Documents

2.1 ASTM Standards:³

- D129 Test Method for Sulfur in Petroleum Products (General High Pressure Decomposition Device Method)
- E516 Practice for Testing Thermal Conductivity Detectors Used in Gas Chromatography
- D808 Test Method for Chlorine in New and Used Petroleum Products (High Pressure Decomposition Device Method)
- D1193 Specification for Reagent Water
- D1552 Test Method for Sulfur in Petroleum Products (High-Temperature Method)
- D4327 Test Method for Anions in Water by Suppressed Ion Chromatography
- E433 Reference Photographs for Liquid Penetrant Inspection
- E543 Specification for Agencies Performing Nondestructive Testing
- E1208 Practice for Fluorescent Liquid Penetrant Testing Using the Lipophilic Post-Emulsification Process
- 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
- E1417 Practice for Liquid Penetrant Testing

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 June 15, 2012. Published July 2012. Originally approved in 1960. Last previous edition approved in 2009 as E165 - 09. DOI: 10.1520/E0165-12.

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

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