



Designation: E 709 – 08

Standard Guide for Magnetic Particle Testing¹

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This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This guide² describes techniques for both dry and wet magnetic particle testing, a nondestructive method for detecting cracks and other discontinuities at or near the surface in ferromagnetic materials. Magnetic particle testing may be applied to raw material, semifinished material (billets, blooms, castings, and forgings), finished material and welds, regardless of heat treatment or lack thereof. It is useful for preventive maintenance testing.

1.1.1 This guide is intended as a reference to aid in the preparation of specifications/standards, procedures and techniques.

1.2 This guide is also a reference that may be used as follows:

1.2.1 To establish a means by which magnetic particle testing, procedures recommended or required by individual organizations, can be reviewed to evaluate their applicability and completeness.

1.2.2 To aid in the organization of the facilities and personnel concerned in magnetic particle testing.

1.2.3 To aid in the preparation of procedures dealing with the examination of materials and parts. This guide describes magnetic particle testing techniques that are recommended for a great variety of sizes and shapes of ferromagnetic materials and widely varying examination requirements. Since there are many acceptable differences in both procedure and technique, the explicit requirements should be covered by a written procedure (see Section 21).

1.3 This guide does not indicate, suggest, or specify acceptance standards for parts/pieces examined by these techniques. It should be pointed out, however, that after indications have been produced, they must be interpreted or classified and then evaluated. For this purpose there should be a separate code, specification, or a specific agreement to define the type, size, location, degree of alignment and spacing, area concentration,

and orientation of indications that are unacceptable in a specific part versus those which need not be removed before part acceptance. Conditions where rework or repair is not permitted should be specified.

1.4 This guide describes the use of the following magnetic particle method techniques.

1.4.1 Dry magnetic powder (see 8.4),

1.4.2 Wet magnetic particle (see 8.5),

1.4.3 Magnetic slurry/paint magnetic particle (see 8.5.7), and

1.4.4 Polymer magnetic particle (see 8.5.8).

1.5 *Personnel Qualification*—Personnel performing examinations in accordance with this guide should be qualified and certified in accordance with ASNT Recommended Practice No. **SNT-TC-1A**, ANSI/ASNT Standard **CP-189**, **NAS 410**, or as specified in the contract or purchase order.

1.6 *Nondestructive Testing Agency*—If a nondestructive testing agency as described in Practice **E 543** is used to perform the examination, the nondestructive testing agency should meet the requirements of Practice **E 543**.

1.7 The numerical values shown in inch-pound units are to be regarded as the standard. SI units are provided for information only.

1.8 *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

A 275/A 275M Practice for Magnetic Particle Examination of Steel Forgings

A 456/A 456M Specification for Magnetic Particle Examination of Large Crankshaft Forgings

D 93 Test Methods for Flash Point by Pensky-Martens Closed Cup Tester

D 445 Test Method for Kinematic Viscosity of Transparent

¹ This guide 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.

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² For ASME Boiler and Pressure Vessel Code Applications see related Guide SE-709 in Section II of that 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.