

Liquid Penetrant Inspection Procedure

1. Perform JSEA with all personnel involved.
2. Perform visual inspection of asset to be inspected.
3. Locate all padeyes, lifting eyes, load bearing areas and other areas of inspection.
4. Clean areas to be inspected using appropriate methods according to CETCO Procedure PT-001. If areas to be inspected are painted, paint must be removed by blasting or any other means that will not mask relevant indications. If areas to be inspected are heavily soiled, oily, or greasy, use an appropriate degreasing agent. If degreasing agent is used, ensure that all areas to be inspected are clean and dry before proceeding.
5. A visual inspection shall be performed again after the item has been properly cleaned. If item is not cleaned to the inspectors satisfaction Step 4 shall be repeated.
6. Apply penetrant to areas of asset to be inspected.
7. Allow 10 minutes dwell time for penetrant.
8. Using a clean, white, lint free rag, remove as much penetrant from the surface of the part as possible.
9. Lightly apply cleaner to a new clean, white, lint free rag. Remove as much of the remaining penetrant from the surface of the part as possible using a new clean, white, lint free rag each time. DO NOT SOAK RAG WITH CLEANER. DO NOT SPRAY CLEANER DIRECTLY ONTO THE PART AS THIS WILL REMOVE PENETRANT FROM RELEVANT INDICATIONS.
10. Allow 5 minutes for part to dry before applying developer.
11. Apply a thin coat of developer to areas to be inspected.
12. Allow 10 minutes for developer to dry and indications to fully form.
13. Evaluate and classify any indications as either relevant or non-relevant. Acceptance criteria shall be in accordance with approved standards.
14. All relevant and non-relevant indications shall be recorded to the CETCO MT/PT Report.
15. Report all findings to QA/QC Department.

Liquid Penetrant Inspection Manual

N Colangelo



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