



Nondestructive testing

Magnetic particle testing acc. to DIN EN ISO 9934-1 / Fluorescent testing



Process description

1. Step:

Precleaning with MR[®] Remover

The workpieces resp. the areas of the workpieces which are to be examined must be cleaned thoroughly: rust, scales and other contaminations must be removed with suitable tools, other contaminants (oils, greases, etc.) must be removed from the surface with MR[®] Remover. Before taking the next step please make sure that the surface is completely dry.

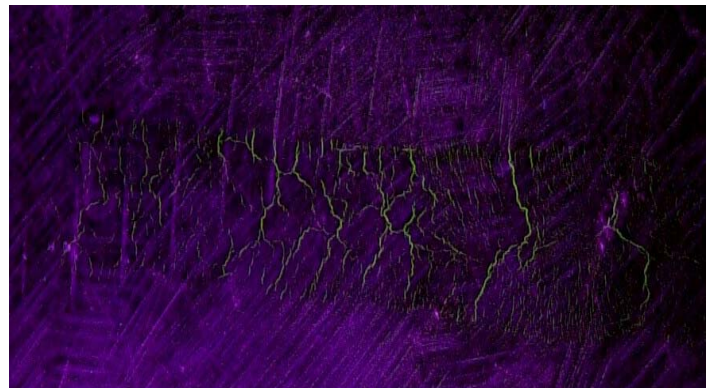
2. Step:

Application MR[®] Magnetic powder fluid spray or suspension, fluorescent

Apply the detection media MR[®] Magnetic powder fluid spray or suspension fluorescent immediately prior to and during magnetization on the workpiece. The application shall cease before magnetization is terminated. Allow sufficient time for indications to develop before moving the workpiece. Under UV-light (e.g. MR[®] UV-Hand lamp), discontinuities will appear as yellow-green fluorescent magnetic particle indications on the surface (observe viewing conditions according to the standard!).

Magnetization may be achieved by an MR[®] Hand yoke. Please ask for our equipment list!

Indications on a load hook and a welding seam,
tested according to DIN EN ISO 9934-1



3. Step:

Cleaning the workpiece after testing

After testing and acceptance, if required, remove detecting media from the surface. For MR[®] detection media you can use e.g. MR[®] 71 Remover.

MR[®] 76 F und MR 158 meet the requirements of DIN EN ISO 9934-2 and ASME Codes, Section V, Article 6, T-641. Batch certificates will be provided upon request.

