



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 adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last approval. A superscript symbol (n) indicates an editorial change since the last revision or approval.

1. Scope

1.1 This test method² covers procedures for penetrant examination of materials. They are nondestructive testing methods for detecting discontinuities that are open to the surface such as cracks, seams, laps, cold shuts, laminations, through leaks, or lack of fusion and are applicable to in-process, final, and maintenance examination. They can be effectively used in the examination of nonporous, metallic materials, both ferrous and nonferrous, and of nonmetallic materials such as glazed or fully densified ceramics, certain nonporous plastics, and glass.

1.2 This test method 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 dealing with the liquid penetrant examination of materials 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 obtained. 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 must be a separate code or specification or a specific agreement to define the type, size, location, and direction of indications considered acceptable, and those 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.*

¹ This test method is under the jurisdiction of ASTM Committee E07 on Nondestructive Testing and is the direct responsibility of Subcommittee E07.02 on Liquid Penetration and Magnetic Particle Methods.

Current edition approved February 10, 2002. Published April 2002. Originally published as E 165 – 90 E. Last previous edition E 165 – 95.

² For SI/USC, Boiler and Pressure Vessel Code applications see related Recommended Test Method E84-E85 in the Code.

2. Referenced Documents

2.1 ASTM Standards:

D 129 Test Method for Sulfur in Petroleum Products (General Bomb Method)³

D 516 Test Method for Sulfate Ion in Water⁴

D 808 Test Method for Chlorine in New and Used Petroleum Products (Bomb Method)⁵

D 1193 Specification for Reagent Water⁴

D 1552 Test Method for Sulfur in Petroleum Products (High-Temperature Method)⁵

D 4327 Test Method for Anions in Water by Chemically Suppressed Ion Chromatography⁴

E 423 Reference Photographs for Liquid Penetrant Inspection⁶

E 543 Practice for Evaluating Agencies that Perform Nondestructive Testing⁷

E 1208 Test Method for Fluorescent Liquid Penetrant Examination Using the Lipophilic Post-Emulsification Process⁸

E 1209 Test Method for Fluorescent Liquid Penetrant Examination Using the Water-Washable Process⁸

E 1210 Test Method for Fluorescent Liquid Penetrant Examination Using the Hydrophilic Post-Emulsification Process⁸

E 1219 Test Method for Fluorescent Liquid Penetrant Examination Using the Solvent-Removable Process⁸

E 1220 Test Method for Visible Penetrant Examination Using the Solvent-Removable Process⁸

E 1316 Terminology for Nondestructive Examinations⁹

E 1418 Test Method for Visible Penetrant Examination Using the Water-Washable Process⁸

2.2 ASNT Document:¹⁰

Recommended Practice SNT-TC-1A for Nondestructive Testing Personnel Qualification and Certification
ANSI/ASNT CP-189 Standard for Qualification and Certification of Nondestructive Testing Personnel

³ Annual Book of ASTM Standards, Vol. 05.01.

⁴ Annual Book of ASTM Standards, Vol. 11.01.

⁵ Annual Book of ASTM Standards, Vol. 05.03.

⁶ Available from the American Society for Nondestructive Testing, 4711 Arden Lane, Columbus, OH 43228-0518.

Astm E165

Ram Babu Sao



Astm E165:

Handbook of Engineering Practice of Materials and Corrosion Jung-Chul (Thomas) Eun, 2020-09-04 This handbook is an in depth guide to the practical aspects of materials and corrosion engineering in the energy and chemical industries The book covers materials corrosion welding heat treatment coating test and inspection and mechanical design and integrity A central focus is placed on industrial requirements including codes standards regulations and specifications that practicing material and corrosion engineers and technicians face in all roles and in all areas of responsibility The comprehensive resource provides expert guidance on general corrosion mechanisms and recommends materials for the control and prevention of corrosion damage and offers readers industry tested best practices rationales and case studies **ASME**

Section IX Simplified: Fundamentals, Variables, Welder Qualification, Compliance and Audits Sumitra Kumari, Master the complexities of ASME Section IX with this comprehensive easy to understand guide designed for welding inspectors engineers and quality control professionals ASME Section IX Simplified breaks down the fundamentals of welding procedure and performance qualification making it accessible for both beginners and experienced professionals Whether you re preparing for welder qualification ensuring compliance or navigating audits this asme section ix welder qualification book provides clear explanations real world applications and expert insights to help you succeed What You ll Learn Fundamentals of ASME Section IX Key concepts explained in simple language Welding Variables Essential non essential and supplementary variables demystified Welder Qualification Step by step guides for GMAW GTAW SMAW FCAW and SAW in all positions Compliance Audits How to avoid common failures and maintain certification Material Filler Metal Selection Understanding P Numbers F Numbers and A Numbers This welder qualification book is an essential resource for anyone working with welding qualification and compliance under ASME Section IX Whether you re a welding inspector engineer or quality control professional this guide will boost your expertise and confidence in handling welder and procedure qualification with ease

Department Of Defense Index of Specifications and Standards Numerical Canceled Listing (APPENDIX) Part IV November 2005 , **Introduction to Piping Quality Control** Ram Babu Sao, 2025-03-23 The terms Quality Control and Quality Assurance are often used interchangeably but they are not synonymous Quality Assurance is a program executed by company management Quality Control is a task that takes place on the production floor Two aspects are quality control QC and quality assurance QA Understanding these programs and their roles is critical in making sure the respective engineer to carry out their duties effectively There are three most important criteria for evaluating the Quality Control of work such as Cost Time of delivery and Quality Quality is most important factor out of the three Quality isn t simply a cost It is a powerful tool that contributes to the economic success of the work Therefore there is need to control all three but quality is the most significant Many manufacturers recognize that quality leads to a higher customer retention rate and helps to build competitive boundaries However the term quality by itself isn t sufficient ISO 9000 definitions the QC is the operational

techniques and activities that are utilized to fulfil requirements for quality and QA is all those planned and systematic activities implemented to provide adequate confidence that the entity will fulfil requirements for quality QC is a production line function The aim of QC is to offer the highest reasonable quality of product or service to the client thereby meeting or even exceeding the client's requirements The QA manager is interested in investigating technologies and processes that prevent defects QA is a staff function The aim of QA is to apply a planned and systematic production process establishing confidence that the process generates suitable products QC method is intended to provide regular product inspection thereby guaranteeing the output's correctness completeness and integrity It finds and addresses mistakes They file and record all the QC procedures The product or service needs to be suitable and fit for the intended purpose The methods and processes should decrease errors and shortcomings the first time through the manufacturing process QC is product oriented it focuses on tests and inspections carried out at various production line checkpoints QA is process oriented its concerns are process definitions proper selection of tools proper use of testing methods and operator training QC works at locating defects QA works at preventing them QC emphasizes testing of products to discover defects and reporting the results to management QA attempts to improve and stabilize production to minimize or prevent the conditions that trigger defects Typically quality control involves problem identification problem analysis problem correction and feedback Quality assurance involves data collection problem trend analysis process identification process analysis and process improvement

The Best Knowledge of Piping Engineering II, 2025-11-15 It gives me great pleasure and sense of deep satisfaction to publish this book of The Best Knowledge of Piping Engineering II You can learn how to design material selection and testing fabrication erection construction inspections and quality control of pipe along with weld joints detail joint preparation pipe cutting joints fit up welding of pipe pipe supports and steel structural platforms fabrication and installation etc and teach yourself to be a master of the process piping construction with the step by step instructions and quality control It provides all the information about tools and equipments being used in the piping construction work An engineer is the tradesperson who is busy in fabrication installation assembly testing maintenance and repair of process piping systems Fresh Piping engineer usually begins as apprentices and deals with industrial commercial marine piping and process piping systems Typical industrial process pipe works under high pressure and temperature and requires metals such as carbon steel stainless steel alloy steel cupronical and many different alloying metals fused together through precise cutting threading grooving bending and welding Piping engineer plan and test piping and tubing layouts cut bend or fabricated pipe or tubing segments and joints of those segments by threading welding brazing cementing or soldering them together They check the installation of manual pneumatic hydraulic and electric operated valves on pipes to control the flow through the pipes or tubes They do testing and inspection of the piping system Piping engineers are often exposed to hazardous or dangerous materials such as asbestos lead ammonia steam flammable gases various resins and solvents including benzene and various refrigerants Much

progress was made in the 20th century toward eliminating or reducing hazardous materials exposures. Many aspects of hazardous materials are now regulated by law in most countries including asbestos usage and removal and refrigerant selection and handling. Other occupational hazards include exposure to the weather, heavy lifting, crushing hazards, lacerations, and other risks normal to the construction industry. This book has proved to be a friend and guide to many Piping engineer Contractors and Technicians working with any Construction or Consultants Companies who are responsible for Laying out, assembling or installation of piping systems, pipe supports, applying their knowledge of construction experience, following blueprints, and select the type and size of pipe related materials and equipment such as supports, hangers, and hydraulic cylinders according to piping drawings and specifications.

Introduction to Engine Valvetrains Yushu Wang, 2006-10-27. Many books have been written about the design, construction, and maintenance of valvetrains, but until now, information has been scattered and difficult to find. This comprehensive book will serve as your single resource, providing a systematic introduction to valvetrain systems and components. Focusing on the fundamental concepts, this book enables you to appreciate design and material considerations while, at the same time, understanding the difficulties in designing valvetrains to satisfy functional requirements and manufacturing challenges.

Welding, Design, Procedures and Inspection, 1985 Handbook of Bolts and Bolted Joints John Bickford, 1998-04-28. Presenting time-tested standards as well as reliable, emerging knowledge on threaded fasteners and joints, this book covers how to select parts and materials, predict behavior, control assembly processes, and solve on-the-job problems. It examines key issues affecting bolting in the automotive, pressure vessel, petrochemical, aerospace, and structural.

Introduction to Piping Engineering RAM BABU SAO, 2025-03-23. It gives me great pleasure and sense of deep satisfaction to publish this book of Introduction to Piping Engineering. You can learn how to design, material selection, and testing, fabrication, erection, construction, inspections, and quality control of pipe, along with weld joints, detail joint preparation, pipe cutting, joints, fit-up, welding of pipe, pipe supports, and steel structural platforms, fabrication, and installation, etc., and teach yourself to be a master of the process piping construction with the step-by-step instructions and quality control. It provides all the information about tools and equipments being used in the piping construction work. An engineer is the tradesperson who is busy in fabrication, installation, assembly, testing, maintenance, and repair of process piping systems. Fresh Piping engineer usually begins as an apprentice and deals with industrial, commercial, marine piping, and process piping systems. Typical industrial process pipe works under high pressure and temperature and requires metals such as carbon steel, stainless steel, alloy steel, cupronical, and many different alloying metals fused together through precise cutting, threading, grooving, bending, and welding. Piping engineer plan and test piping and tubing layouts, cut, bend, or fabricate pipe or tubing segments and joints of those segments by threading, welding, brazing, cementing, or soldering them together. They check the installation of manual, pneumatic, hydraulic, and electric operated valves on pipes to control the flow through the pipes or tubes. They carry out testing and inspection of the piping system.

Piping engineers are often exposed to hazardous or dangerous materials such as asbestos lead ammonia steam flammable gases various resins and solvents including benzene and various refrigerants Much progress was made in the 20th century toward eliminating or reducing hazardous materials exposures Many aspects of hazardous materials are now regulated by law in most countries including asbestos usage and removal and refrigerant selection and handling Other occupational hazards include exposure to the weather heavy lifting crushing hazards lacerations and other risks normal to the construction industry This book has proved to be a friend and guide to many Piping engineer Contractors and Technicians working with any Construction or Consultants Companies who are responsible for Laying out assembling or installation of piping systems pipe supports applying their knowledge of construction experience following blueprints and select the type and size of pipe related materials and equipment such as supports hangers and hydraulic cylinders according to piping drawings and specifications Piping engineers are the main technical professionals who are responsible to deliver the quality job of piping work and they should have sufficient knowledge of Piping Engineering subject This will result in improving the general quality levels of a Piping engineer in this direction leading to a greater satisfaction in work This book is taking a lead in upgrading the awareness knowledge of various matters related with piping work benefiting Piping engineers working in the field of piping work The total practical approach of this book explodes the statistical data on mathematics physics chemistry and engineering that even the piping engineering subject is tough and difficult to understand a general reader or beginners willing to know about the subject will find the content very easy and simple to follow I hope that the excellence of this book will be appreciated by the readers from all parts of India and abroad

Standard Handbook of Petroleum & Natural Gas Engineering William C. Lyons, 1996 Volume 1 presents the mathematics and general engineering and science of petroleum engineering It also examines the auxiliary equipment and provides coverage of all aspects of drilling and well completion

Steel Shipbuilding Kai Turing, AI, 2025-02-19 Steel shipbuilding a complex feat of engineering relies on advanced principles modern welding techniques and stringent design standards This book Steel Shipbuilding explores how these elements ensure the structural integrity and longevity of vessels navigating demanding maritime environments From the evolution of steel alloys to the intricacies of welding the book reveals the science behind constructing massive steel ships capable of withstanding immense ocean pressures Discover how material advancements like the shift from iron to high strength alloys have revolutionized shipbuilding impacting operational safety and efficiency The book methodically progresses first introducing the properties of steel alloys then detailing welding processes such as submerged arc welding laser welding and friction stir welding The final section delves into design specifications mandated by classification societies Case studies throughout illustrate real world applications of the principles discussed Emphasizing the integration of material science welding methodologies and design standards this book provides a balanced approach valuable to engineers and policymakers alike offering a comprehensive reference for professionals in naval architecture marine engineering and related

fields *An Introduction to Specifications for Structural Welding for Professional Engineers* J. Paul Guyer, P.E., R.A., 2024-08-09 Introductory technical guidance for Professional Engineers and construction managers interested in welding of structural steel *CWI Part A Exam* Mike L Turner, 2024-09-24 Are you ready to elevate your career in welding and become a Certified Welding Inspector CWI In the demanding world of welding the CWI certification not only enhances your professional credentials but also ensures you possess the expertise needed to uphold industry standards This comprehensive guide to the CWI Part A exam is your essential resource for mastering the knowledge required to succeed Designed for both aspiring and seasoned welding professionals this book delves into every crucial aspect of the CWI Part A exam It begins with an in depth overview of welding safety and health emphasizing the importance of personal protective equipment and hazard identification You ll discover a detailed examination of various welding processes including Shielded Metal Arc Welding SMAW and Gas Metal Arc Welding GMAW complete with their advantages limitations and applications As you navigate through the chapters you will encounter essential topics such as welding symbols and drawings weld joint design and the critical role of metallurgy in welding Each section is crafted to provide you with clear explanations and practical insights ensuring you not only understand the material but can also apply it in real world situations With a focus on inspection techniques the guide covers both non destructive and destructive testing methods equipping you with the knowledge to evaluate weld quality effectively It also explores the various codes standards and specifications that govern welding practices underscoring the importance of adherence to these guidelines in maintaining industry integrity What truly sets this book apart are the extensive practice questions and full length mock exams designed to simulate the actual CWI Part A exam experience With detailed answers and explanations provided you ll be able to assess your understanding and refine your knowledge in preparation for exam day This guide is the ultimate companion on your journey to becoming a Certified Welding Inspector Empower yourself with the confidence and expertise to excel in your field ensuring your place at the forefront of the welding industry Prepare to embark on a transformative experience that will not only help you pass the exam but also position you as a leader in welding quality assurance **Wastewater Treatment Plants** Salah Souabi, Abdelkader Anouzla, Shalini Yadav, Vijay P. Singh, Ram Narayan Yadava, 2025-07-20 The book provides technical information on the operation of wastewater treatment plants and strategies to be adopted for the design of plants assessment processes and technologies for wastewater treatment and reuse for irrigation and industry including protecting the environment It discusses the crucial parts that science technology and innovation play in formulating implementing and administering wastewater treatment policy It highlights the challenges that must be overcome to successfully adopt the wastewater treatment infrastructure regulations and provides some answers It investigates how the operation of wastewater treatment plant technology can be used in a wide variety of fields apart from other on the shelf publications on the market It also delves into the core concepts of the operation of wastewater treatment plants It explores how these concepts can be modified to fit a

variety of contexts and uses Applications such as managing facilities dealing with pandemics urban wastewater treatment and reuse farming and other applications are included in this book Consequently this book s content is engaging and it will pique the interest of a diverse audience of readers who come from a wide variety of professional backgrounds This book will be helpful to industrialists researchers entrepreneurs professionals planners policymakers environmental engineers and others interested in the operation of wastewater treatment system management strategies through the application of breakthroughs in the operation of wastewater treatment plants The book constitutes a database that can help companies guide the choice of a treatment technique considering operating and investment costs Similarly the book presents several solutions to problems encountered during the operation of treatment plants particularly the challenges encountered at the biological and physicochemical treatment levels The book also illustrates some design and sizing methods and methods for good practice to organize the extension of a treatment plant if necessary properly The book also deals with options for resource recovery and wastewater governance thus establishing a clear link between the performance of a treatment plant and obtaining treated water that could be used for irrigation which is often the missing link in current debates on the issue of making wastewater an asset The chapters present experiences from developed and developing countries including case studies on design eco efficiency and the circular economy applied to wastewater The book presents advanced methods for evaluating advanced solutions with low investment and operating costs In addition the authors and co authors are key international experts in the field of wastewater treatment

Handbook of Bolts and Bolted Joints Sayed A. Nassar, John H. Bickford, 2025-03-20 Presenting time tested standards as well as validated emerging knowledge on threaded fasteners and bolted joints this updated edition covers how to design select parts and materials control assembly processes predict behavior and solve on the job problems This handbook examines key issues affecting bolting in the automotive pressure vessel petrochemical aerospace energy and structural steel industries The editors have successfully created a useful rather than scholarly handbook with chapters written in a straightforward how to manner Theory is discussed only when necessary and the handbook s logical organization and thorough index enhance its usefulness **Handbook of Bolts and Bolted Joints** Second Edition includes updated chapters solved numerical examples and case studies This new edition is an essential handbook for professionals researchers and students in all fields in which threaded joints are used including automotive aerospace structural chemical and naval and ocean engineering as well as agricultural equipment wind turbines and medical devices

Advanced Characterization and Testing of Textiles Patricia I. Dolez, Olivier Vermeersch, Valério Izquierdo, 2017-09-19 Advanced Characterization and Testing of Textiles explores developments in physical and chemical testing and specific high performance tests relating to textiles The book introduces the principles of advanced characterization and testing including the importance of performance based specifications in the textiles industry Chapters are organized by textile properties providing in depth coverage of each characteristic Tests for specific applications are

addressed with the main focus on high performance and technical textiles Focuses on advanced testing methods for technical and high performance textiles covering state of the art technology in its field Details specific textile properties and associated testing for each characteristic **National Voluntary Laboratory Accreditation Program** Paul R. Martin,1994

Introduction to Knowledge of Piping Engineering Ram Babu Sao, It gives me great pleasure and a sense of deep satisfaction to publish this book *Introduction to Knowledge of Piping Engineering* You can learn how to design material selection and test fabrication erect construct inspections and quality control pipe along with weld joints detail joint preparation pipe cutting joints fit up welding of pipe pipe supports and steel structural platforms fabrication and installation etc and teach yourself to be a master of the process piping construction with the step by step instructions and quality control It provides all the information about tools and types of equipment being used in the piping construction work An engineer is a tradesperson who is busy in the fabrication installation assembly testing maintenance and repair of process piping systems Fresh Piping engineer usually begins as apprentices and deal with industrial commercial marine piping and process piping systems Typical industrial process pipe works under high pressure and temperature and requires metals such as carbon steel stainless steel alloy steel cupronickel and many different alloying metals fused through precise cutting threading grooving bending and welding Piping engineers plan and test piping and tubing layouts cut bend or fabricate pipe or tubing segments and joints of those segments by threading welding brazing cementing or soldering them together They check the installation of manual pneumatic hydraulic and electric operated valves on pipes to control the flow through the pipes or tubes They do testing and inspection of the piping system Piping engineers are often exposed to hazardous materials such as asbestos lead ammonia steam flammable gases various resins and solvents including benzene and various refrigerants Much progress was made in the 20th century toward eliminating or reducing hazardous materials exposures Many aspects of hazardous materials are now regulated by law in most countries including asbestos usage and removal and refrigerant selection and handling Welding Code - Steel , Quality Assurance: Guide to Specifying NDT in Materiel Life Cycle Applications United States. Army Materiel Command,1970

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