

3 PACK FLAW & CRACK DETECTION SYSTEM

HOW TO USE THE THREE-PACK SYSTEM:

To clean the surface, spray on safety cleaner (pack 1) and wipe thoroughly with a lint free cloth or tissue to remove all surface contamination. Then apply penetrant. Parts must be at ambient temperature (between 5°C and 35°C) before penetrant is applied. Spray the area under examination liberally with the penetrant (pack 2) and allow at least ten

minutes contact time. If very fine defects are to be located extend contact time to twenty minutes.

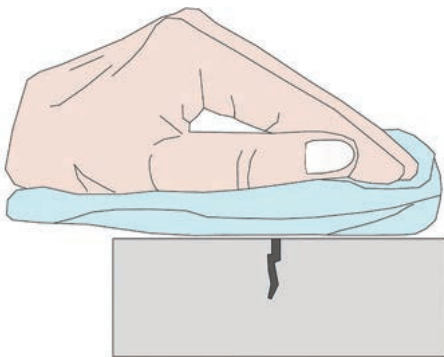
CLEAN OFF THE PENETRANT

Remove most of the penetrant by wiping with a lint free absorbent cloth, to complete removal use a lint free cloth soaked in safety cleaner (pack 1) and dry thoroughly.

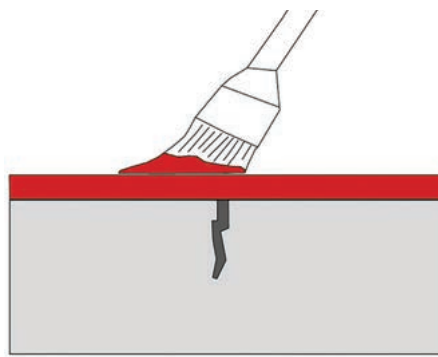
APPLY DEVELOPER

Apply developer by spraying on a thin even film at least 10 minutes before inspecting for fine defects. Inspect in daylight, good artificial illumination or under ultra violet light as appropriate so the system will show continuous lines or pin points where there are cracks or porosity. (See diagrams below for added information)

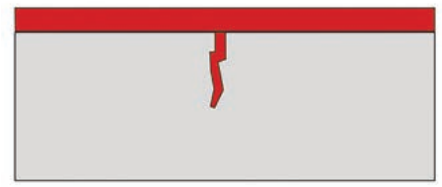
1 Clean with cloth dampened with solvent



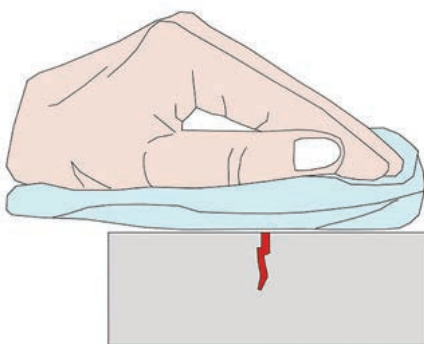
2 Apply penetrant to surface by spraying or brushing



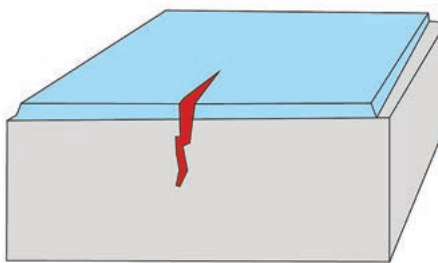
3 Allow proper dwell time of 10 minutes or in the case of fine defects, 20 minutes.



4 Remove excess penetrant from surface with a cloth



5 Apply developer and allow a dwell time of 10 minutes then inspect for flaws



sif tips



Technical advice in the original SifTips style was started in 1932. 'Sifbronzing' is an almost universally recognised way of describing the low temperature bronze welding of sheet steel, cast iron and other metals. This explains why Sifbronze, the company which first developed and promoted the technique, is generally considered to be a supplier of high quality welding rods, wires, fluxes and equipment.

'Will the Welder' was a SifTips magazine that was produced in the early 1930s. The aim was to provide users with ideas and tips on how to get the most out of their welding equipment.

Sif is renowned for its UK manufacturing heritage as well as its complete range of quality welding consumables used globally for almost a century.

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