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### MANDATORY APPENDIX B METHODS FOR LIQUID PENETRANT EXAMINATION (PT)

**B.1 SCOPE**  
This Appendix describes methods which should be used to detect and identify surface-breaking defects in ferrous and nonferrous metal components.

**B.2 GENERAL**  
This Appendix describes methods which should be used to detect and identify surface-breaking defects in ferrous and nonferrous metal components. The methods in this Appendix shall be applied to all welds, including those which are not welded, unless specified otherwise. The methods in this Appendix shall be applied to all welds, including those which are not welded, unless specified otherwise.

**B.3 MATERIALS**  
This Appendix describes methods which should be used to detect and identify surface-breaking defects in ferrous and nonferrous metal components.

**B.4 SURFACE PREPARATION**  
An initial test of an inspection shall be made to determine the surface condition. The test shall be made in the form of a roughness profile. The test shall be made with a roughness profile (RPM) of 100 or less.

(1) The surface shall be prepared by one of the following methods:  
(a) Mechanical cleaning  
(b) Chemical cleaning  
(c) Solvent cleaning

**B.5 APPLICATION OF PENETRANT**  
The penetrant shall be applied to the surface of the component to be inspected.

The penetrant shall be applied to the surface of the component to be inspected. The penetrant shall be applied to the surface of the component to be inspected. The penetrant shall be applied to the surface of the component to be inspected.

**B.6 REMOVAL OF EXCESS PENETRANT**  
The excess penetrant shall be removed from the surface of the component to be inspected.

The excess penetrant shall be removed from the surface of the component to be inspected. The excess penetrant shall be removed from the surface of the component to be inspected. The excess penetrant shall be removed from the surface of the component to be inspected.

**B.7 DEVELOPMENT**  
The penetrant shall be applied to the surface of the component to be inspected.

### NONMANDATORY APPENDIX H GUIDANCE TO ACCOMMODATE LOADINGS PRODUCED BY DEFLAGRATION

**H.1 SCOPE**  
When an internal rupture or duct air deflagration is likely to occur in a vessel or its associated piping, the design shall be such that the vessel or piping will be able to withstand the forces produced by such conditions.

**H.2 GENERAL**  
Deflagration is the propagation of a combustion zone at a velocity that is less than the speed of sound in the unburned medium. When deflagration is the propagation of a combustion zone at a velocity that is greater than the speed of sound in the unburned medium, it is called a supersonic combustion event. This Appendix describes methods for the design of vessels and piping to accommodate the forces produced by such conditions.

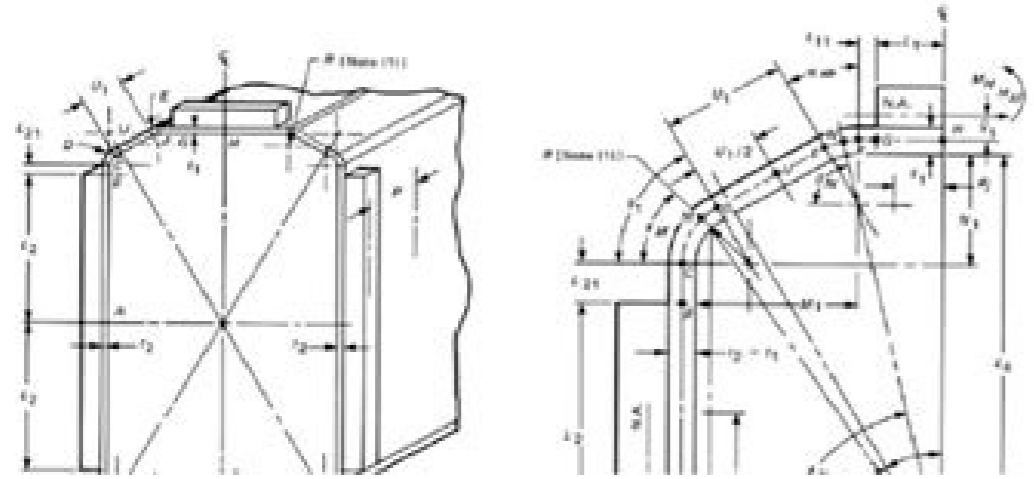
**H.3 DESIGN LIMITATIONS**  
The limits of validity for deflagration pressure calculations are described in References (1) and (2).

**H.4 DESIGN CRITERIA**  
**H.4.1 Safety Margin**  
As described in NFA-01 (see Reference (1)), a vessel may be designed to withstand the loads produced by a deflagration.



**Appendix 13 - Vessels of Noncircular Cross Section (Type 13-2(a)(6))**

|                                      |          |                             |
|--------------------------------------|----------|-----------------------------|
| Shell Material                       |          | = ASME SA516 Grade 65       |
| Material Width Coefficient           | $\Delta$ | = 498                       |
| Max Allowable Working Pressure       | $P$      | = 0.200 N/mm <sup>2</sup>   |
| Design Temperature                   | $T$      | = 50.000 °C                 |
| Material Yield Stress                | $S_y$    | = 262.000 N/mm <sup>2</sup> |
| ASME II Design Stress                | $f$      | = 120.658 N/mm <sup>2</sup> |
| PVHO-1 Design Stress                 | $S = f$  | = 120.658 N/mm <sup>2</sup> |
| Circumferential Joint Efficiency     | $E_1$    | = 1.000                     |
| Longitudinal Joint Efficiency        | $E_2$    | = 1.000                     |
| Corrosion Allowance                  | $C$      | = 0.000 mm                  |
| Actual Short Length Shell Thickness  | $t_1$    | = 10.000 mm                 |
| Actual Long Length Shell Thickness   | $t_2$    | = 10.000 mm                 |
| Inside Radius of Bends               | $R$      | = 50.000 mm                 |
| Pitch Spacing of Reinforcing         | $p$      | = 1.000 mm                  |
| Half Length of Reinforced Short Side | $L_1$    | = 250.000 mm                |
| Half Length of Remaining Short Side  | $L_{11}$ | = 0.000 mm                  |
| Half Length of Reinforced Long Side  | $L_2$    | = 250.000 mm                |
| Half Length of Remaining Long Side   | $L_{21}$ | = 0.000 mm                  |
| Half Length of Short Side            | $L_3$    | = 426.7766 mm               |
| Half Length of Long Side             | $L_4$    | = 426.7766 mm               |
| Thickness of Reinforcing Bar         | $b_1$    | = 0.000 mm                  |
| Height of Reinforcing Bar            | $y_1$    | = 0.000 mm                  |
| Thickness of Reinforcing Bar         | $b_2$    | = 0.000 mm                  |
| Height of Reinforcing Bar            | $y_2$    | = 0.000 mm                  |
| Staying Parameter                    | $C$      | = 2.1                       |



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The rounded indication can be considered rejected if the size is greater than 3/16 inch or 5 mm. The linear indication depends on the thickness if the thickness is less than 0.75 inch then any linear indication greater than 1/4 inch will be considered unacceptable. For instance, if you are performing a liquid penetrant testing on pipe weld to pump casing and you find an indication, then you need to refer to appendix 8 of the code mentioned above for evaluation since the API 610 does not directly address the acceptance criteria issue. For example, if a pressure vessel such as a reactor, heat exchanger, drum, process tower subjected to the test, then acceptance criteria can be found in the ASME Code Section VIII Div. An indication is elongated or linear when its length is three times of its wide. APPENDIX 8 METHODS FOR LIQUID PENETRANT EXAMINATION (PT) NOTE: Satisfactory application of this method of examination requires special skills in the techniques involved and in interpreting the results. 1. Mandatory Appendix 8 covers the acceptance criteria for Penetrant testing on the weld. Where welding is required after repair of an imperfection, the area shall be cleaned and welding performed in accordance with a qualified welding procedure. (a) Treatment of Indications Believed Nonrelevant. Any indication which is believed to be nonrelevant shall be regarded as an imperfection unless it is shown by reexamination by the same method or by the use of other nondestructive methods and/or by surface conditioning that no unacceptable imperfection is present. (b) Examination of Areas From Which Defects Have Been Removed. Click on below Like and G+1 buttons! Loading Preview Sorry, preview is currently unavailable. (1.6 mm) or less (edge toe) (d) an indication of an imperfection may be larger than the imperfection that causes it; however, the size of the indication is the basis for acceptance evaluation. 8-5 REPAIR REQUIREMENTS Unacceptable imperfections shall be repaired and reexamination made to assure removal or reduction to an acceptable size. Liquid penetrant testing acceptance criteria depend on the construction code. Only indications with major dimensions greater than 116 in. However, if several rounded indications existed in line and separated by a short distance, might be considered rejected indications. If you are doing a penetrant test on steel structure, then you should look for acceptance criteria in the AWS D1.1 Liquid Penetrant Testing Acceptance Criteria Based on ASME VIII Div 1 Appendix 8 The ASME Code Section VIII Div. If the thickness of the test object is between 0.75 and 2.25 inch, then max allowed linear indication is the 1/3 of the thickness. The test evaluation and interpretation shall be done by qualified ASNT Level II or Level III liquid penetrant test technicians. Return to Inspection 4 Industry Home Did you find this article useful? After a defect is thought to have been removed and prior to making weld repairs, the area shall be examined by suitable methods to ensure it has been removed or reduced to an acceptably sized imperfection. (c) Reexamination of Repair Areas. (305 mm), and is capable of distinguishing and differentiating contrast between colors used. You may ignore any indication that might be less than this value. An indication might be rejected based on one code or standard and might be acceptable based another code and standard. The requirements specified herein presume application by suitably experienced personnel. 8-1 SCOPE (a) This Appendix describes methods which shall be employed whenever liquid penetrant examination is specified in this Division. (b) Article 6 of Section V shall be applied for detail requirements in methods, procedures and qualifications, unless specified within this Appendix. (c) Liquid penetrant examination shall be performed in accordance with a written procedure, certified by the Manufacturer to be in accordance with the requirements of T-150 of Section V. 8-2 CERTIFICATION OF COMPETENCY OF NONDESTRUCTIVE EXAMINATION PERSONNEL. The manufacturer shall certify that each liquid penetrant examiner meets the following requirements. (a) He has vision, with correction if necessary, to enable him to read a Jaeger Type No. 2 Standard Chart at a distance of not less than 12 in. Whenever an imperfection is repaired by chipping or grinding and subsequent repair by welding is not required, the excavated area shall be blended into the surrounding surface so as to avoid. COPYRIGHT American Society of Mechanical Engineers Licensed by Information Handling Services COPYRIGHT American Society of Mechanical Engineers Licensed by Information Handling Services 8-5 1998 SECTION VIII DIVISION 1 8-5 sharp notches, crevices, or corners. shall be considered relevant. (a) A linear indication is one having a length greater than three times the width. (b) A rounded indication is one of circular or elliptical shape with the length equal to or less than three times the width. (c) Any questionable or doubtful indications shall be reexamined to determine whether or not they are relevant. 8-4 ACCEPTANCE STANDARDS These acceptance standards shall apply unless otherwise restrictive standards are specified for specific materials or applications within this Division. All surfaces to be examined shall be free of: (a) relevant linear indications; (b) relevant rounded indications greater than 316 in. (4.8 mm); (c) four or more relevant rounded indications in a line separated by 116 in. You can download the paper by clicking the button above. Please note API codes for rotating equipment also refer to this code. 1 Appendix 8. As you see, there is more leeway for rounded indication. It divides the indication into two groups as follows: Rounded indications: any relevant indication (it means if its major dimension is greater than 1/16 (1.5 mm) ) shall be considered rejected if it is greater than 3/16 in (5 mm). Linear or elongated indication: all elongated indication are rejected regardless of the size. 1 Appendix 7 addresses this issue. As per appendix 8, any indication greater than 1/16 in (1.5 mm) shall be considered a relevant indication. The code requires all cracks and hot tears to be rejected regardless of the size. After repairs have been made, the repaired area shall be blended into the surrounding surface so as to avoid sharp notches, crevices, or corners and reexamined by the liquid penetrant method and by all other methods of examination that were originally required for the affected area, except that, when the depth of repair is less than the radiographic sensitivity required, reradiography may be omitted. COPYRIGHT American Society of Mechanical Engineers Licensed by Information Handling Services COPYRIGHT American Society of Mechanical Engineers Licensed by Information Handling Services APPENDIX 8 METHODS FOR LIQUID PENETRANT EXAMINATION (PT) 8-1 SCOPE 8-2 CERTIFICATION OF COMPETENCY OF NONDESTRUCTIVE EXAMINATION PERSONNEL 8-3 EVALUATION OF INDICATIONS 8-4 ACCEPTANCE STANDARDS 8-5 REPAIR REQUIREMENTS test: P1: Official Release: test: P2: Official Release: test: You're Reading a Free Preview Page 2 is not shown in this preview. Liquid Penetrant Testing Acceptance Criteria for Process Piping - ASME B31.3 The acceptance criteria exactly is as the same of ASME Section VIII Div. The criteria addressed in clause number 344.4.2 - Acceptance Criteria Liquid Penetrant Testing Acceptance Criteria for Casting Used for Pressure Vessels and Rotating Equipment The ASME Code Section VIII Div. These requirements shall be checked annually. (b) He is competent in the techniques of the liquid penetrant examination method for which he is certified, including making the examination and interpreting and evaluating the results, except that, where the examination method consists of more than one operation, he may be certified as being qualified only for one or more of these operations. 3698-3 EVALUATION OF INDICATIONS An indication is the evidence of a mechanical imperfection.

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