

IRISH STANDARD

I.S. EN 1371-2:1998

ICS 77.140.80 77.150.99

National Standards Authority of Ireland Glasnevin, Dublin 9 Ireland

Tel: +353 1 807 3800 Fax: +353 1 807 3838 http://www.nsai.ie

FOUNDING - LIQUID PENETRANT INSPECTION

Sales

http://www.standards.ie

- PART 2: INVESTMENT CASTINGS

This Irish Standard was published under the authority of the National Standards Authority of Ireland and comes into effect on:

13 November 1998

NO COPYING WITHOUT NSAI PERMISSION EXCEPT AS PERMITTED BY COPYRIGHT LAW

© NSAI 1998

Price Code G

Údarás um Chaighdeáin Náisiúnta na hÉireann

This is a free page sample. Access the full version online.

DECLARATION

OF

SPECIFICATION

ENTITLED

FOUNDING - LIQUID PENETRANT INSPECTION - PART 2: INVESTMENT CASTINGS

AS

THE IRISH STANDARD SPECIFICATION FOR

FOUNDING - LIQUID PENETRANT INSPECTION - PART 2: INVESTMENT CASTINGS

NSAI in exercise of the power conferred by section 16 (3) of the National Standards Authority of Ireland Act, 1966 (No. 28 of 1996) and with the consent of the Minister for Enterprise, Trade and Employment, hereby declares as follows:

- 1. This instrument may be cited as the Standard Specification (Founding Liquid penetrant inspection Part 2: Investment castings) Declaration, 1998.
- 2. (1) The Specification set forth in the schedule to this declaration is hereby declared to be the standard specification for Founding Liquid penetrant inspection Part 2: Investment castings. The Schedule comprises the text of EN 1371-2:1998.
- (2) The said standard specification may be cited as Irish Standard EN 1371-2:1998 or as I.S. EN 1371-2:1998.

This is a free page sample. Access the full version online.

EUROPEAN STANDARD This is a free page sample. Access the full passion and the full passion are full passion as full passion are full passion and the full passion are full passion are full passion and the full passion are full passion and the full passion are full passio

NORME EUROPÉENNE

EUROPÄISCHE NORM

May 1998

ICS 77.140.80; 77.150.99

Descriptors: foundry engineering, castings, precision equipment, inspection, non destructive tests, liquid penetrant tests, surface properties, defects tolerances, acceptability

English version

Founding - Liquid penetrant inspection - Part 2: Investment castings

Fonderie - Contrôle par ressuage - Partie 2: Pièces en moulage de précision (cire perdue)

Gießereiwesen - Eindringprüfung - Teil 2: Feingußstücke

This European Standard was approved by CEN on 9 April 1998.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION COMITÉ EUROPÉEN DE NORMALISATION EUROPÄISCHES KOMITEE FÜR NORMUNG

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

Contents

| | P | age 'age | | P | age |
|---------------------------------|--|------------------|-------|--|-----|
| Forew | vord | 3 | 7 | Interpretation of results | 7 |
| Introd | luction | 4 | 8 | Ordering | 8 |
| 1 | Scope | 4 | 9 | Retesting | 8 |
| 2 | Normative references | 4 | 10 | Post-examination cleaning procedures | 8 |
| 3 | Definitions | 4 | 11 | Test report | 8 |
| 3.1 3.2 | investment casting reference area | 4 5 | Table | 1: Nature of discontinuities and types of corresponding liquid penetrant | |
| 4 | Conditions for liquid penetrant inspection | 5 | | indications | |
| 5 | Method of inspection | 5 | Table | 2: Severity levels – Non-linear indications isolated (SP) and clustered (CP) | 9 |
| 5.1 5.2 5.3 5.4 5.5 | Operating mode | 5 5 5 6 | Table | 3: Severity levels – Linear (LP) and aligned (AP) indications, isolated and cumulative indications | 10 |
| 5.6 | Viewing conditions | 6 | Table | 4: Recommended surface roughness for liquid penetrant inspection | 10 |
| 6 6.1 | Acceptance criteria | 6 6 | Anne | A (informative) Bibliography | 11 |
| 6.2 | indication | 7 7 | Anne | B (informative) Type test report and test report | 12 |



| | This is a free preview. | Purchase the e | entire publication | at the link below: |
|--|-------------------------|----------------|--------------------|--------------------|
|--|-------------------------|----------------|--------------------|--------------------|

Product Page

- Dooking for additional Standards? Visit Intertek Inform Infostore
- Dearn about LexConnect, All Jurisdictions, Standards referenced in Australian legislation