



PENETRANT PROFESSOR APPROVED

PRODUCT DATA SHEET

MPI-1400B



Met-L-Chek manufactures a complete line of Nondestructive Testing materials and supplies fluorescent and visible dye penetrants, wet and dry magnetic particles and a variety of specialty testing materials. All Met-L-Chek products are designed to yield maximum value through quality, cost, and usability. Met-L-Chek products are sold under the Met-L-Chek® and Pen-Chek trademarks.

MPI-1400B is a premixed, ready-to-use, fluorescent magnetic particle bath designed for high sensitivity fluorescent wet method inspection. It is a mixture of **MPI-FLUID C2** and **MPI-1400** fluorescent particles. It meets the requirements of **AMS-3045** and **ASTM E-1444** for fluorescent wet method magnetic particle inspection. Aerosols are pressurized with nonflammable, environmentally friendly CO₂.

General Magnetic Particle Inspection

Magnetic particle inspection is used to locate discontinuities on or near the surface of ferromagnetic materials. A magnetic field is induced in the part to be examined. Discontinuities at or near the surface will cause the magnetic field to concentrate at any discontinuity. Fine magnetic particles are attracted to the magnetic field leakage over the discontinuities forming indications or mapping the discontinuities. Considerable theory, technical training, specialized equipment and trial and error is involved for effective magnetic particle inspection.

Particles

There are two types of materials generally used for magnetic particle inspection, wet method and dry method. Dry method materials are primarily used in weld inspection. Production and overhaul situations require high sensitivity, broad area detection capability best achieved with the wet method. Wet method particles are generally smaller than dry method particles and are more easily attracted to weaker leakage fields. The particles are suspended in a liquid carrier fluid which facilitates the mobility of the particles on the part surface. The particles may be visibly colored relying on contrast with the base material or contrast coating for detectability or they may be fluorescent and produce brilliant indications under UV-A illumination. Fluorescent inspection requires the inspection area be darkened to ensure detection of the fluorescent indications.

Magnetic Particle Bath

Special petroleum-based carrier fluids or water, which has been treated with conditioning agents, may be used as the wet method particle bath media. The bath must be continuously agitated during use as the dense particles will settle out of solution upon standing. Materials intended for water bath use should not be placed in equipment that has been used for oil bath applications until the tank and all plumbing have been thoroughly cleaned. Similarly, water or wet parts should not be introduced to baths with oil carriers as this will cause the particles to cling to the tank and agglomerate. The particle concentration must be maintained for maximum performance. The settling volume per ASTM E-1444 should be between 0.1 and 0.4 ml/100 ml. for fluorescent particles after 60 minutes in oil and 30 minutes in water and between 1.2 and 2.4 ml/100 ml for visible particles.



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Rev. 1/19

MPI-1400B

Typical Physical Properties

Form: dark green brown liquid when particles are suspended
Density: 832 g/L
Flash Point: > 93.3°C (> 200°F)
Viscosity: 2.4 mm²/s
Particle size: 1-12µ
Fluorescence: yellow green
SAE Relative Sensitivity: 7-8
Corrosion of steel: none
Chloride content: < 1000 ppm (< 0.1%)
Fluoride content: < 1000 ppm (< 0.1%)
Sulfur content: < 1000 ppm (< 0.1%)
Mercury: none
VOC's: 0 g/L
Ozone layer depleting substances: none
PCB's: none

Product Availability

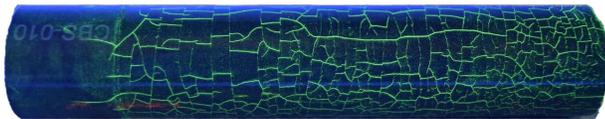
12 x 16oz (400ml) vol. aerosol(net wt 241g or 8.5oz)
5 gallon (18.9L) metal pail

NSN #

5 gallon (18.9L) 6850-01-196-5472

Specifications

- AMS-2641
AMS-3045 (bulk)
AMS-3046 (aerosol)
ASTM E-709
ASTM E-1444
API RP 5A5
ASME SE-709, B&PV code, section V, art. 7&25.



MPI-1400B Indications



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Contact Us

United States
McGean
Phone: +1-216-441-4900
Fax: +1-216-441-1377

United Kingdom
McGean UK
Phone: +44-1902-456563
Fax: +44-1902-457443

Singapore
McGean Singapore
Phone: +65-6863-2296
Fax: +65-6863-2297