

MG 410

Wet Method Fluorescent Magnetic Particles



MAGNAGLO® MG 414 is a powder concentrate used to prepare fluorescent inks for high-sensitivity, wet method magnetic particle testing. The inks give clear bright yellow/green indications when viewed in a darkened area under UV(A) of peak wavelength 365 nm.

MG 410 can be suspended in either a petroleum-based vehicle (oil), such as MG-MX Carrier II, or in water. If water is used, you must add a conditioning agent (such as MAGNAFLUX® WA-1) to improve particle suspendibility and mobility, surface wetting and corrosion inhibition.

BENEFITS

Increases indication detection

- Find smaller, finer indications in critical applications with these highly sensitive particles.

Minimises inspection time

- Clear, bright indications form quickly with minimal background fluorescence.

Improve inspection consistency and reliability

- Maintain magnetic particle system performance over longer periods of time thanks to the highly-durable, easily-dispersed particles

FEATURES

- Can be suspended in water or petroleum distillate (oil) vehicle
- High sensitivity
- Excellent fluorescent contrast
- Excellent particle mobility
- Optimised particle size distribution
- Durable particles
- Easily dispersed

APPLICATIONS

Defect location: surface and slightly subsurface

Ideal for:

- Detecting very fine to fine discontinuities
- Critical applications
- Machined parts
- Smooth surface finish
- After secondary processing
- In-service inspections

Ideal for:

- Inclusions
- Seams
- Shrink cracks
- Tears
- Laps
- Flakes
- Welding defects
- Grinding cracks
- Quenching cracks
- Fatigue cracks

COMPOSITION

Compounded fluorescent pigment and magnetic iron oxide.

MG 410

SPECIFICATION COMPLIANCE

- ASME B & PV Code, Sec V
- ASTM E709
- MIL-STD-2132D
- MIL-STD-271F
- NAVSEA 250-1500-1
- SAFRAN In 5300

PRODUCT PROPERTIES

Form and colour	Green powder
SAE sensitivity	7
Particle size range	14 - 22 µm
Usage temperature	< 48°C

Like all Magnaflux materials, MG 410 is closely controlled to ensure batch-to-batch consistency, optimum process control and inspection reliability.

USER RECOMMENDATIONS

NDT Method	Magnetic Particle Testing, Fluorescent, Wet Method
Storage temperature	10°C to 30°C
Suspension Vehicle	Water or MG/MX Carrier II
Water Bath Additive	WA-1 water conditioner WA-2 antifoam
Cleaner	SKC-S
UV lamps	EV6000, ST700
Accessories	Centrifuge Tube

INSTRUCTIONS FOR USE

Clean the component before testing to reduce the risk of contamination and provide a suitable test surface.

Prepare the ink using the recommended concentration range of 0.75 - 1.5 g/litre.

Oil-based ink

Combine the required amount of powder with a suitable oil carrier, such as MG-MX Carrier II. Mix thoroughly until the powder is fully dispersed (this can take up to 15 minutes).

Water-based ink

First, prepare your water carrier by mixing 10g of WA-1 per litre of water. Then add the required amount of powder to the carrier and mix thoroughly until the powder is fully dispersed (this can take up to 15 minutes).

Before using your ink, check it has the correct settlement volume of 0.05 - 0.15 ml. You will need to continually agitate the ink during use to ensure uniformity of mix.

Apply by spraying, flooding or immersion, depending on your chosen method (see below):

Wet continuous method

Apply the ink to all surfaces of the component and apply a magnetising current. Remember to stop the flow of ink before the current is switched off, otherwise there is a risk that the force of the ink flood may wash away indications.

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Wet residual method

This method is generally less sensitive than the continuous method and is more susceptible to rapid particle depletion and bath contamination.

- Pre-magnetise the part to be tested.
- Immerse the part in a bath of the ink.
- Remove it and allow it to drain.
- Inspect the part.

During use, the magnetic content of any ink will become depleted so you will need to check your bath strength at least once each day. The most widely-used way of checking an ink's settlement volume is by using a graduated ASTM pear-shaped centrifuge tube.

When the settlement volume approaches the lower limit (0.05 ml), you can add more powder to the bath as long as it is still clean and uncontaminated. If the bath appears contaminated, or if it has been in use for a long time, replace the contents.

After inspection, remember to completely demagnetise your components before cleaning, to ensure easy removal of any residual powder particles.

PACKAGING AND PART NUMBERS



057C036

HEALTH AND SAFETY

Review all relevant health and safety information before using this product. For complete health and safety information, refer to the Safety Data Sheets, which are available at eu.magnaflux.com.