

## High Temperature Penetrant Testing

### FLUXO PHT

Red Dye Penetrant

### FLUXO RHT

White Developer

### FLUXO NHT

Remover

#### Description & Composition

Set of product for Penetrant Testing between 50°C and 200°C:

**FLUXO PHT:** Red Dye Penetrant for Penetrant Testing  
Method C - Type 2 - Level 2 according to EN ISO 3452  
Solution of petroleum distillates (high flash point), nonionic surfactants and red dyes.

**FLUXO RHT:** White Developer for Penetrant Testing  
Form e according to EN ISO 3452  
Suspension of inert white particle in a flammable volatile organic solvent.

**FLUXO NHT:** Cleaner for Penetrant Testing  
Stable solution of petroleum distillates (high flash point) and nonionic surfactants.

#### Approval & Specifications

- Processing Temperature : 50° to 200°C
- NF EN ISO 3452-2 and NF EN 571-1
- NF EN ISO 3452-5 (High temperature)
- RCC-M Code
- ASME BOILER AND PRESSURE VESSEL CODE, SECTION V
- ASTM E 1417 - ASTM E 165
- Low in Sulphur & Halogens (Nuclear Quality)

#### Application

- **Cleaning:** Remove rust, tinder and all contaminations from the part with **FLUXO** cleaner
- **Application of Penetrant:** Apply **FLUXO PHT** by spraying.
- **Removal:** Remove the excess penetrant from the surface **FLUXO NHT**.
- **Developing:** Apply **FLUXO RHT** developer on the part, achieving a thin and uniform layer.
- **Inspection:** Parts shall be inspected as per ISO 3059 standard requirements. Surface defects will appear as red indication.



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## Safety Precautions

On use in higher temperature ranges, the risks associated with this should be adequately considered. Burns to the skin and vapour build up of substances may mean corresponding dangers. The work area must always be suitably ventilated and personnel exposure carefully assessed.



## Temperature and Time of Process

Temperature of the part	Products	Penetration Time	Development Time
50°C - 80°C	Cleaner FLUXO S190 / Penetrant FLUXO P125 Remover FLUXO N130 / Developer FLUXO R175	10 to 20 min	10 min
80°C - 130°C	Cleaner N130 / Penetrant FLUXO PHT Remover FLUXO N130 or NHT Developer FLUXO R175 or RHT	5 to 10 min	5 min
150°C	Penetrant FLUXO PHT / Remover FLUXO NHT Developer FLUXO RHT	3 min	1 to 2 min
200°C	Penetrant FLUXO PHT / Remover FLUXO NHT Developer FLUXO RHT	1 min	immediately

## Shelf Life

- Minimum of 5 years, stored at room temperature

## Packaging

- Aerosol Can 300mL

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