

ARDROX[®] 800/3

COLOR CONTRAST MAGNETIC INK

1 Description

Ardrox[®] 800/3 is a ready-to-use color contrast magnetic ink ideal for the inspection of ferromagnetic materials, structures and components by the magnetic particle inspection method. A typical application is the inspection of welds, pressure vessels and pipeline in the oil, gas and petrochemical industries as well as power plants.

Ardrox[®] 800/3 consist of very finely divided black magnetic particles suspended in high flash point, dearomatized, odorless petroleum distillate designed to provide good particle mobility. The particles have been selected for their high magnetic response, low coercivity and prolonged operational life.

Ardrox[®] 800/3 and Base Oil HF use a hydrocarbon oil corresponding to the AMS 2641, Type 1 Magnetic Particle Inspection Vehicle with a flash point exceeding 93°C / 200°F.

Ardrox[®] 800/3 is available as bulk material and as aerosol. It offers optimal performances when used together with the Ardrox[®] 8901W or 8903W contrast paint.

Conformances

✓ ASME	Boiler & Vessel Code, Section V, Article 7
✓ CEN	ISO 9934-2
✓ Rolls Royce	CSS 231 & OMat 608D (approval)
✓ SAE	AMS 3041/3043 & 2641 Type 1
Ask your Chemetall representative for a complete list of approvals	

2 Physical and chemical properties

Property	Typical Value	Unit	Test Method
Appearance	suspension of black powder	-	-
Settlement	1.5 – 2.4	%	AMS 3041
Flash point	> 93 / >200	°C / °F	ASTM D93
Particle size	0.5 - 4 / mean 1,5	µm	-
Viscosity	< 3.0 at 40°C / 104°F	mm ² /s	-

These are typical values only and do not constitute a specification.

3 Application

Aerosol cans and bulk containers must be shaken thoroughly before and during use in order to homogenize the powder concentration.

3.1 Method of use

Surface temperature should be between -20 and 75°C (-4 to 165°F).

Components are magnetized and Ardrox[®] 800/3 is applied to the test area, normally by spraying immediately prior to and during magnetization. Application of Ardrox[®] 800/3 should cease before the magnetization is switched off. Defects will show up as well defined black indications and inspection should take place in good white light of at least 500 Lux (refer to the controlling specification for levels of ambient light acceptable for inspection).

3.2 White contrast paint

It is not practical to use Ardrox[®] 800/3 on dark substrates as it would be difficult for the inspector to identify indications against the dark background. Therefore, the white contrast paint Ardrox[®] 8901W or 8903W is frequently used to provide a contrasting background against the black indications (alternatively, fluorescent fluids such as the Ardrox[®] 8 series inks may be used if a UV light is available). Ardrox[®] 8901W or 8903W can then be left on the surface or removed with an appropriate Ardrox[®] solvent cleaner, for instance Ardrox[®] 5319.

4 Effects on materials

When Ardrox[®] 800/3 is used in the prescribed manner, no significant corrosion will occur on ferrous materials. Equipment/tanks should be constructed of stainless steel.

5 Storage

Store in a cool place, with protection from freezing conditions. Shelf life of Ardrox[®] 800/3 is 36 months.

6 Labor and environmental protection

Before operating the process described it is important that this complete document, together with any relevant Safety Data sheets, be read and understood.

All local and national regulations on the transport, storage, use and waste treatment of chemicals in concentrated or diluted form and as working solutions must be obeyed.

7 General Information

Chemetall supplies a wide range of chemical products and associated equipment for cleaning, descaling, paint and carbon removal, metal working and protection and non-destructive testing. Sales Executives are available to advice on specific problems and applications.

The above details have been compiled to the best of our knowledge on the basis of tests and research work and with regard to the current state of our practical experience. This technical product information is non-binding. No liabilities or guarantees deriving from or in connection with this leaflet can be imputed to us. Statements relating to possible uses of the product do not constitute a guarantee that such uses are appropriate in a particular user's case or that such uses do not infringe the patents or proprietary rights of any third party. The reproduction of any or all of the information contained in this leaflet is expressly forbidden without Chemetall's prior written consent.

**Headquarters and Regional Head Office
Europe, Middle East, Africa, South America**
Chemetall GmbH
Trakehner Straße 3
60487 Frankfurt am Main, Germany
Tel: +49 (0) 69 7165-0

**Regional Head Office
North America**
Chemetall US, Inc.
675 Central Avenue
New Providence, NJ 07974, USA
Tel: +1-908-464-6900

**Regional Head Office
Asia-Pacific**
Chemetall Asia Pte Ltd.
12 Loyang Crescent
Singapur 508980
Tel: +65 6885 7900