



High Temperature Penetrant Testing

FLUXO PHT

Red Dye Penetrant

FLUXO RHT

White Developer

FLUXO NHT

Remover

General Appearance & Composition

Set of products 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 / Remover for Penetrant Testing
Stable solution of petroleum distillates (high flash point) and nonionic surfactants.

Manufacturer: SREM TECHNOLOGIES

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 - Tome III - Chapter MC4200
- RCC-M Code - Tome V - Chapter F6423
- ASME BOILER AND PRESSURE VESSEL CODE, SECTION V
- ASTM E 1417 - ASTM E 165
- Low in Sulphur & Halogens (Nuclear Quality)

Instructions for Use

- **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 with **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.

Shelf Life

- Minimum of 5 years, stored at room temperature.
- Please refer to the Safety Data Sheet

Pack Sizes

- Aerosol Can 500mL



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

Version: 09/2021