

ISO 4987:2010-03 (E)

Steel castings - Liquid penetrant inspection

Contents	Page
Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Ordering information	1
4 Method of inspection	2
4.1 Operating mode	2
4.2 Qualification of the operators	2
4.3 Surface preparation	2
4.4 Conditions of inspection	2
5 Acceptance criteria	2
5.1 Definition of liquid penetrant indications	2
5.1.1 General	2
5.1.2 Non-linear indications (SP)	2
5.1.3 Linear indication (LP)	3
5.2 Severity levels	3
5.2.1 General	3
5.2.2 Non-linear indications	3
5.2.3 Linear indications	3
5.2.4 Selection of the severity level	4
5.2.5 Designation of severity levels	4
6 Classification of the indications and interpretation of results	4
6.1 Classification of the indications using Tables 1 and 2	4
6.1.1 General	4
6.1.2 Non-linear indications	4
6.1.3 Linear indications	4
6.2 Interpretation of results	5
7 Retesting	5
8 Post-examination cleaning procedures	5
9 Inspection documentation	5
Annex A (informative) Recommended surface finish for liquid penetrant inspection	8
Annex B (informative) Reference figures -- Non-linear isolated indications (SP)	9
Annex C (informative) Reference figures -- Linear indications (LP)	14
Annex D (informative) Model of a liquid penetrant inspection document	29
Bibliography	31