

Technical Information Guide: Grit Equivalency Guide & Etchants

Etchants for Iron and Steels

Nital 1-10 ml HNO ₃ 90-99 ml Ethanol or Methanol	Most common etchant for Fe, Carbon and Alloy steels, Cast iron. Reveals alpha grain boundaries and constituents. The 2% solution is the most common. Use by immersion for up to 60 seconds or by swabbing. Do not store etchantic solutions that exceed 2% nitric acid. The 5-10% solution is used for high-alloy steels should not be stored if made with ethanol. (Revised)
Picral 4g Picric Acid 100 ml Ethanol	Recommended for structures consisting of ferrite and carbide. Does not reveal ferrite grain boundaries. Addition of 0.5-1% naphthalenetrizole (a commonly used antibacterial agent) improves etch rate and uniformity. Use by immersion for up to 60 seconds or by swabbing. (Revised)
Glyceric acid 3 parts HCl 2 parts Oxalic 1 part HNO ₃	For high-alloy steels, austenitic Mn steels, stainless steels and Ni-base alloys. Reveals grain structure, outlines sigma and carbides. Use fresh. Discard when turns yellow/orange. Do not store. For slower action and for martensitic or ferritic stainless steel, use 2 parts HCl. Swab sample 5-30 seconds.
Vital's Reagent 1g Picric Acid 5 ml HCl 100 ml Ethanol	For high alloy steels and stainless steels. Use at 20°C for up to 1 minute by immersion or swabbing. Outlines constituents such as carbides, sigma phase and delta ferrite; etches martensite.

Etchants for Copper and Alloys

25 ml H₂O₂ 25 ml Distilled Water (optional) 25-50 ml H₂O₂ (30%)	General-purpose grain-contrast etch for Cu and alloys (does not always produce grain contrast). Use fresh; add peroxide last. Use under a fume hood. Swab sample 5-45 seconds.
5g Fe(NO₃)₃ 25 ml HCl 70 ml Distilled Water	Excellent general-purpose etch; reveals grain boundaries well. Immerse sample 10-30 seconds. (Oxplan and Proxplan)

Etchants for Aluminum and Alloys

0.5-10 ml HF 90-100 ml Distilled Water	General-purpose reagent. Attacks FeAl ₃ ; other constituents outlined. Grain contrast usually poor. The 0.5% concentration of HF is very popular. Use by swabbing.
Keller's Reagent 2.5 ml H₂O₂ 1.5 ml HCl 1 ml HF 95 ml Distilled Water	Very popular general-purpose reagent for Al and Al alloys, except high Si alloys. Swab sample 10-20 seconds. Wash in warm water. Can follow with a dip in concentrated H ₂ O ₂ . Outlines all common constituents; reveals grain boundaries in certain alloys.

Etchants for Nickel and Alloys

Kalling's No. 2 2g Cu Cl 40 ml HCl 80-90 ml Ethanol	"Violetless Kalling's" for Ni-Cu, superalloys and stainless steels. Good for grain size. Swab for up to a few minutes. Can be stored.
Acetic Glyceric acid 15 ml HCl 10 ml Acetic Acid 5 ml H₂O₂ 1-2 drops Oxalic (optional)	For superalloys. Use fresh. Discard when turns yellow/orange. Do not store. Swab sample 5-30 seconds.

Etchants for Titanium and Alloys

Kroll's Reagent 2-6 ml H₂O₂ 100 ml Distilled Water	Very good etch. Swab 5-10 seconds or immerse sample 10-30 seconds.
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Safe laboratory practices should be followed; consult MSDS of all chemicals used in etch solutions prior to use. Safety is the responsibility of the user. Buehler disclaims all liability with respect to use of these chemicals and etch solutions.



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Technical Information Guide: Premium Polishing Cloths & Pads

EUROPEAN/US EQUIVANCY GUIDE

FEPA (Europe)		ANSI/CAMI (US)		Emery Grit
Grit Number	Micron (µm)	Grit Number	Micron (µm)	
P60	269.0	60	268.0	
P80	201.0	80	188.0	
P100	162.0	100	148.0	
P120	127.0	120	116.0	
P180	78.0	180	78.0	3
P240	58.5	220	66.0	2
P280	52.2	240	51.8	
P320	46.2			
P360	40.5	280	42.3	1
P400	35.0	320	34.3	0
P500	30.2	360	27.3	
P600	25.8			
P800	21.8	400	22.1	00
P1000	18.3	500	18.2	000
P1200	15.3	600	14.5	
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Worldwide Guide to Equivalent Irons and Steels Fran Cverna, 2006-01-01 More than 30 000 listings are presented in this edition with increased coverage from major steel producing countries such as China India and Japan *Analytical Characterization of Aluminum, Steel, and Superalloys* D. Scott MacKenzie, George E. Totten, 2005-10-10 Authored by top researchers this book discusses methodologies to quantify the properties and microstructures of aluminum steel and superalloys It is a unique reference to advanced laboratory techniques in the context of characterization and property evaluation methodologies enabling the evolution of stronger and more function specific compositions Topics include metallography an atlas of microstructures thermal analysis x ray diffraction and residual stress measurement transmission electron microscopy electron backscattering diffraction spectroscopy texture measurement electron momentum spectroscopy positron annihilation spectroscopy and atomic probe tomography *Manual of Geology* John Phillips, 1885 **The Complete Wooden Runabout Restoration Guide** Don Danenberg, 2008-08-15 Now MBI Publishing Company s two top selling boating titles written by one of the world s top authorities on the subject of antique wooden boat restoration are available in one volume In this comprehensive restoration guide for owners and enthusiasts of wooden powerboats of all makes and models built from the early 1920s through the 1960s author Don Danenberg covers all major woodworking aspects of restoration surveying disassembly repair reconstruction and varnishing But when it comes to restoring a classic wooden powerboat getting the frame planking and deck right is just one part of the story Danenberg also walks enthusiasts through the topics of hardware running gear electrical wiring plumbing instruments upholstery trailers and maintenance Fully illustrated with step by step color photos and written in an entertaining style in which the author stresses sound reconstruction techniques over preservation of original components this comprehensive volume also includes resource listings glossaries and School of Hard Knocks sidebars *Technical Manual* United States. War Department, 1943 *PPI PE Civil Study Guide, 17th Edition* Michael R. Lindeburg, 2022-09-30 Maximize your efficiency while studying for the PE Civil

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