

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 H ₂ O ₂	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 H ₂ O ₂ 25 ml Distilled Water (optional) 25-50 ml H ₂ O ₂ (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(NO ₃) ₃ 25 ml HCl 70 ml Distilled Water	Excellent general-purpose etch; reveals grain boundaries well. Immense sample: 10-30 seconds. (Oxplan and Prohastal)

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 H ₂ O ₂ 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

Kallings' No. 2 2g CuCl 40 ml HCl 80-90 ml Ethanol	"Violetless Kallings" 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 H ₂ O ₂ 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 2-5 ml H ₂ O ₂ 100 ml Distilled Water	Very good etch. Swab 5-10 seconds or immerse sample 10-30 seconds.
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Safety 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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Grit Equivalency Guide

Michael R. Lindeburg



Grit Equivalency Guide:

Steel Heat Treatment Handbook - 2 Volume Set George E. Totten, 2006-11-14 This reference presents the classical perspectives that form the basis of heat treatment processes while incorporating descriptions of the latest advances to impact this enduring technology The second edition of the bestselling Steel Heat Treatment Handbook now offers abundantly updated and extended coverage in two self contained volumes

Steel Heat Treatment George E. Totten, 2006-09-28 One of two self contained volumes belonging to the newly revised Steel Heat Treatment Handbook Second Edition this book focuses on process design equipment and testing used in steel heat treatment Steel Heat Treatment Equipment and Process Design presents the classical perspectives that form the basis of heat treatment processes while

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

Aviation Unit and Intermediate Maintenance Manual, 1990

The Complete Household Handbook, 2005 The best ways to clean maintain and organize your home Includes laundry and clothes care food and the kitchen storage and home office solutions and safety

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

OECD Guidelines for the Testing of Chemicals / OECD Series on Testing and Assessment Report of the SETAC/OECD Workshop on Avian Toxicity Testing OECD, 2002-05-10 As part of the OECD s Pesticide Programme a Workshop on Avian Toxicity Testing was held in Pensacola Florida on 4 7 December 1994 It was jointly organised by the Society of Environmental Toxicology and Chemistry SETAC and the OECD

PPI PE Civil Study Guide, 17th Edition Michael R. Lindeburg, 2022-09-30 Maximize your efficiency while studying for the PE Civil CBT exam by pairing the PE Civil Study Guide with Michael R Lindeburg s PE Civil Reference Manual PE Civil Study Guide Seventeenth Edition provides a strategic and targeted approach to exam preparation so that you gain a competitive edge With hundreds of entries containing helpful explanations derivations of equations and exam tips the Study Guide connects the NCEES exam specifications for all five PE Civil exams to the NCEES Handbook approved design standards and PPI s civil reference manuals The Study Guide is organized to make the most of your time and is an essential tool for a successful exam experience Relevant sections from the NCEES Handbook design standards and PPI s reference manuals are clearly indicated in both summary lists for each exam specification and in each of the detailed entries

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The Top Books of the Year Grit Equivalency Guide The year 2023 has witnessed a noteworthy surge in literary brilliance, with numerous compelling novels captivating the hearts of readers worldwide. Lets delve into the realm of popular books, exploring the engaging narratives that have charmed audiences this year. The Must-Read : Colleen Hoover's "It Ends with Us" This heartfelt tale of love, loss, and resilience has captivated readers with its raw and emotional exploration of domestic abuse. Hoover skillfully weaves a story of hope and healing, reminding us that even in the darkest of times, the human spirit can succeed. Uncover the Best : Taylor Jenkins Reids "The Seven Husbands of Evelyn Hugo" This captivating historical fiction novel unravels the life of Evelyn Hugo, a Hollywood icon who defies expectations and societal norms to pursue her dreams. Reids compelling storytelling and compelling characters transport readers to a bygone era, immersing them in a world of glamour, ambition, and self-discovery. Grit Equivalency Guide : Delia Owens "Where the Crawdads Sing" This captivating coming-of-age story follows Kya Clark, a young woman who grows up alone in the marshes of North Carolina. Owens spins a tale of resilience, survival, and the transformative power of nature, captivating readers with its evocative prose and mesmerizing setting. These bestselling novels represent just a fraction of the literary treasures that have emerged in 2023. Whether you seek tales of romance, adventure, or personal growth, the world of literature offers an abundance of compelling stories waiting to be discovered. The novel begins with Richard Papen, a bright but troubled young man, arriving at Hampden College. Richard is immediately drawn to the group of students who call themselves the Classics Club. The club is led by Henry Winter, a brilliant and charismatic young man. Henry is obsessed with Greek mythology and philosophy, and he quickly draws Richard into his world. The other members of the Classics Club are equally as fascinating. Bunny Corcoran is a wealthy and spoiled young man who is always looking for a good time. Charles Tavis is a quiet and reserved young man who is deeply in love with Henry. Camilla Macaulay is a beautiful and intelligent young woman who is drawn to the power and danger of the Classics Club. The students are all deeply in love with Morrow, and they are willing to do anything to please him. Morrow is a complex and mysterious figure, and he seems to be manipulating the students for his own purposes. As the students become more involved with Morrow, they begin to commit increasingly dangerous acts. The Secret History is a exceptional and suspenseful novel that will keep you wondering until the very end. The novel is a warning tale about the dangers of obsession and the power of evil.

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