

Pickling Bath 302

For immersion pickling!

Avesta Pickling Bath 302 is a concentrate that should be diluted with water depending on the stainless steel grade.

Standard applications

The bath fluid is recommended for immersion pickling of small objects and for pickling surfaces that are time-consuming to brush or spray pickle. It can also be used for circulation pickling of pipe systems.

Features

- Restores stainless steel surfaces that have been damaged during fabrication operations such as welding, forming, cutting and blasting. It removes weld oxides, the underlying chromium-depleted layer and other defects that may cause local corrosion.
- Working life; the bath fluid is consumed during usage and the effective working life of the bath fluid is determined by the amount of acids and dissolved metals. The bath fluid should hence be analyzed regularly, and new acid should be added when needed in order to obtain an optimal pickling result. We may assist with this analysis service.



Immersion of an object into a pickling bath yields the best pickling result.

Recommended concentrations

Standard grades, such as 304 and 316: Mix 1 part 302 into 3 parts of water. A further dilution can be done if longer pickling times can be accepted.

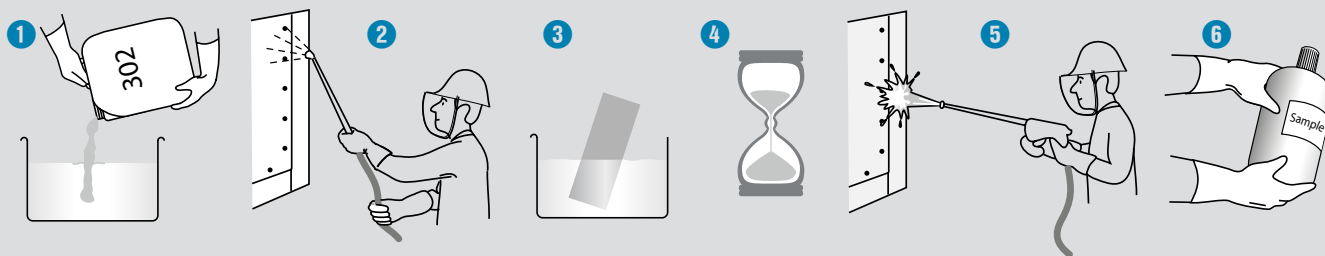
High-alloyed grades, such as duplex grades (2205) and austenitic grades (904 L) for use in severe corrosive conditions: Mix 1 part of 302 into 2 parts of water.

Very high alloyed grades, such as super-austenitic (254 SMO) and super-duplex (2507) grades: Mix 1 part of 302 into 1 part of water.



Avesta Pickling Bath 302 is a concentrate ready to mix depending on which stainless steel grade you need to pickle.

Instructions for use



1. Before first time use. Mix the bath by adding the 302 to the water, not the other way round! The proportions depend on the steel to be pickled.
2. Pre-clean the objects to remove grease and oil before pickling by using Avesta Cleaner 401.
3. Place the product in the pickling bath.
4. Allow sufficient pickling time. Use 5 min to 4 hours depending on temperature, steel grade, condition of the bath etc.
5. Rinse with high-pressure water jet after pickling.
6. Analyse the bath content of acids and free metals regularly to maintain optimal bath composition. We will gladly help you with this.

Passivation

To further improve the result we recommend passivating after pickling using Avesta FinishOne Passivator 630, which is a safer acid-free passivation method.

Optimum pickling results

We help you analyze the bath content of acid and free metals. Please contact us for sample bottles and instructions. After analysis in our lab we will respond with suggestions to help you maximize the pickling results, reduce the impact on the environment and reduce costs.

Packaging

Avesta Pickling Bath 302 is supplied in 33 kg and 240 kg poly-ethylene containers or 1200 kg IBC polyethylene containers.

All packing material follows the UN regulations for hazardous goods.

Storage

Avesta Pickling Bath 302 should be stored indoors at room temperature. Containers must be kept properly closed, in an upright position and inaccessible to unauthorized persons.

The products are perishable and should not be kept in storage longer than necessary. They have a maximum shelf life of two years when stored at room temperature. Exposure to higher temperatures may reduce shelf life.

Worker safety

Protective clothing. In general, users should wear acid-resistant overalls, gloves and rubber boots. Face visor should be used and, if necessary, suitable respiratory protective devices.

Special conditions may apply from one country to another. Consult our website where updated Safety Data Sheets can be found.

Waste treatment

The waste water produced when pickling contains acids and should be treated with Avesta Neutraliser 502 or with slaked lime to a pH-value of 7–10 before discharge.

Heavy metals from stainless steel are precipitated as a sludge, and should be sent for deposition according to local regulations.

Empty containers (HDPE) must be cleaned and can then be recycled according to local regulations.

Other information

For more information, please visit our website: www.avestafinishing.com, where you can find Safety Data Sheets and other useful information.



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