

TECHNICAL DATA SHEET

S-WELD SPS

Code 1108

Spray Pickle Solution

Conforms to ASTM a380-06 Standard Practice for Cleaning, Descaling and Passivation of Stainless Steel Parts, Equipment, and Systems

DESCRIPTION

S-Weld SPS is a unique spray pickling solution that provides excellent working properties for the pickling of stainless steel. Its red colouring allows the operator to know exactly where the product has been sprayed on the stainless surface or if it has been washed down completely.

PHYSICAL PROPERTIES

| | | |
|---------------------|---|---------------|
| Boiling Point | : | N/A |
| Specific Gravity | : | 1.30 +/- 0.01 |
| Water Solubility | : | Miscible |
| pH (as supplied) | : | <1.0 |
| State | : | Liquid |
| Appearance & Colour | : | Red Colour |

BENEFITS

- ✓ Quick acting
- ✓ One step treatment
- ✓ Completely water rinse able
- ✓ Colour indicator
- ✓ Leaves no residual film after rinsing
- ✓ Excellent surface coverage compared to regular paste/gel pickling products
- ✓ Decreased consumption due to colour and consistency
- ✓ Convenient pack size for easy handling

DIRECTIONS FOR USE

1. Ensure welded surface has had sufficient time to cool below 40°C
2. Pre- clean surface to remove any possible contaminants as grease oil and oil. This can be achieved by using Callington S-Weld Britewash Acidic Detergent.
3. Stir or mix solution. Spray onto surface ensuring that coverage is even over the total area. **FOR BEST RESULTS, DO NOT SPRAY IN DIRECT SUNLIGHT.**
5. Application times may vary depending on ambient temperatures, the grade of stainless, surface finish or the method of welding. On a hot rolled surface the pickling time may increase by 50%. MIG welds may require longer pickling times than those obtained using covered electrodes. Allow the pickling gel or solution sufficient time to react with the surface. With high ambient temperatures or when longer pickling times are required, it may be necessary to repeat the process. Do not allow the pickling agent to dry on the surface. Should the product dry on the surface wash down, dry and repeat the process.

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DO NOT OVER PICKLE – The best results are obtained by continuous visual inspection of the surface.

| Grade | Pickling Time | Temperature °C |
|----------------------|------------------|----------------|
| 200, 300, 400 Series | 5 - 30 minutes | 21 - 50 |
| Duplex Grades | 60 - 90 minutes | 21 - 50 |
| Super Duplex | 80 - 120 minutes | 21 - 50 |

S-Weld Clean can be used on Inconel products. Inconel has a very high resistance to corrosion so this means that the dwell time (time the product is left on the surface) will be longer than the dwell time when used on 300 Series stainless products. But the procedure is the same. The pickling times may vary from application to application the method is to conduct series of trials. Produce a small series of test plates using the methods and materials that will be used in normal fabrication. Apply the pickling gel, then conduct a range of visual inspection times starting at 40 minutes and continue and inspect by period until the desired result has been achieved to set the benchmark for normal operations. Use a high-pressure water blaster to wash down, using clean potable water.

- To clean, rinse the surface with clean potable water. The best results are obtained using high pressure water jet or similar. Ensure the pickle residues are not left on the surface. If the surface to be cleaned is in an environmentally sensitive area the bucket and rag method can be employed. Using a bucket of clean potable water wash and wipe surface down with wet clean rags. Repeat to ensure surface is clean and free of acids.

Note:

- Wear gloves and goggles; avoid spillage or splashes. Do not allow to come in contact with the body. If skin contact occurs, apply Calcium Gluconate gel.
- Avoid contact with eyes or breathing any vapour.
- Replace the lid on the container tightly and store upright in a cool dry area away from direct sunlight. Do not store or use below 5°C.
- S-Weld SPS has a recommended shelf life, in good storage conditions, of 2 years.

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PACKAGE SIZES

Available in 10 litre containers.

SAFETY PRECAUTIONS

Caution: This product contains Hydrofluoric Acid and Nitric Acid and is corrosive and poisonous.

Wear appropriate clothing, i.e. rubber gloves, PVC apron/overalls, rubber boots, long sleeve shirt and full-face shield or clear goggles.

Keep lid tightly closed when not in use. Store in a cool, dry spot away from direct sunlight.

Keep out of reach of children.

Refer to the Callington Haven S-Weld Clean Material Safety data sheet for further safety information. A copy of this sheet can be obtained on request from our office.

OTHER CALLINGTON METAL TREATMENT PRODUCTS

| | |
|--------------------------|---|
| S-Weld Passivator | - Passivating gel |
| Steel Bright | - Pickling solution |
| Albright | - Aluminium brightener & cleaner |
| S-Weld Spatter Guard | - Anti-spatter spray |
| S-Weld Neutraliser | - Neutralising solution for acidic pickling paste |
| Cal-Guard | - Non-toxic water based anti-spatter spray |
| Cal-Guard Nozzle Dip Gel | - MIG nozzle cleaner and anti spatter agent |
| S-Weld Brite Wash | - Stainless steel cleaner & corrosion remover |

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